

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026257**Date Inspected:** 09-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite

<b>CWI Name:</b>	As noted below		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Component:</b>	SAS OBG		

**Bridge No:** 34-0006**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

- 11W 12W Bottom Plate D (Exterior)
- 10W PP88 W3 Lifting Lug Hole #1 and 3 (Interior)
- 9W PP77 W4 Lifting Lug Holes #2 and 4 (Interior)
- 9W PP77 W4 Lifting Lug Holes #1 and 3 (Interior)

- 11W 12W Bottom Plate D (Exterior)

The QA inspector randomly observed ABF welding operator James Zhen ID#6001 performing Flux Core Arc Welding with gas (FCAW-G) utilizing a "Bug-O" motorized rail system with a magnetic base attached in the 4G overhead position on the underside of bottom plate D, at 11W 12W of the OBG. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042A-4. The parameters were recorded as (A=250/V=24.4/TS=175/HI=2.09). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

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2. 10W PP88 W3 Lifting Lug Hole #1 and 3 (Interior)

The QA inspector observed ABF welder Salvador Sandoval ID# 2202 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on Lifting Lug Holes (LLH) #1 and 3 located at 10WPP88 W3. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Revision 1. The parameters were recorded as (Amperes=133). The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

3. 9W PP77 W4 Lifting Lug Holes #2 and 4 (Interior)

The QA inspector observed ABF welder Mike Jimenez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on Lifting Lug Hole (LLH) #2 and 4 located at 9W PP77 W4. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Revision 1. The parameters were recorded as (Amperes=135). The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

4. 9W PP77 W4 Lifting Lug Holes #1 and 3 (Interior)

The QA inspector observed ABF welder Mike Jimenez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on Lifting Lug Hole (LLH) #1 and 3 located at 9W PP77 W4. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Revision 1. The parameters were recorded as (Amperes=133). The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

**Summary of Conversations:**

At the beginning the shift the QA inspector met with QC inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

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## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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