

**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-026444**Date Inspected:** 30-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:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford 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:

**East Line**

This QA randomly observed ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1010. The joint being welded is a 20mm plate insert at the "A" deck to close a man way deck penetration hole. This work was located at 8E-PP70.5-E5 NE and was performed in the overhead position from the bottom of the "A" deck plate.

During welding, ABF Quality Control (QC) Steve McConnell was noted monitoring the welding parameters. Welding parameters were recorded as (A=123).

This QA randomly observed ABF/JV qualified welder Todd Jackson #4639 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1220A. The joint welded was two (2) 6mm fillet welds to restore 939mm of diverter bar removed at a previous time. This work was located at the Lift 11E, E5 line and was performed in the flat position from the top of the "A" deck plate.

During welding, ABF Quality Control (QC) Steve McConnell was noted monitoring the welding parameters.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Welding parameters were recorded as (A=131).

This QA randomly observed ABF/JV qualified welder Mike Jiminez # performing Flux Cored Arc Welding (FCAW) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2. The joints welded were four (4) 6mm fillet welds to install a temporary wench attachment plate to "A" deck. This work was performed in the flat position from the top of the "A" deck plate.

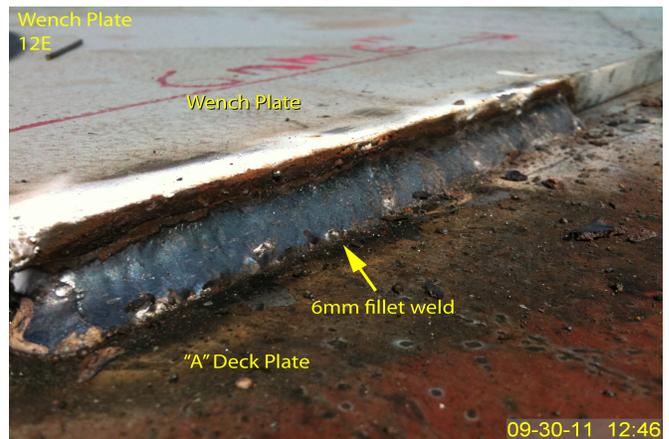
During welding, ABF Quality Control (QC) Steve McConnell was noted monitoring the welding parameters. Welding parameters were recorded as (A=24, V=304).

Approximately:

10:30 this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of the completed welds at panel point E3-PP104-L#1&3 location. Mr. Vonhoff recorded no rejectable indications at this time.

13:00 this QA observed QC Steve McConnell perform Magnetic Particle (MT) of four (4) 6mm fillet welds to install a temporary wench attachment plate to "A" deck. Mr. McConnell recorded no rejectable indications at this time.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### 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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Clifford, William

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer