

**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-026465  
**Date Inspected:** 03-Oct-2011

**Project Name:** SAS Superstructure  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV  
**Contractor:** American Bridge/Fluor Enterprises, a JV

**OSM Arrival Time:** 700  
**OSM Departure Time:** 1730  
**Location:** Job Site

<b>CWI Name:</b>	Pat Swain	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Sections	

**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

**Orthotropic Bridge Girder (OBG) Sections:**

12W-PP109-W3: This QA Inspector randomly observed ABF welding personnel Mike Jiminez (#4671) using the Flux Cored Arc Welding (FCAW) process to attach a plate to the deck for ABF-RFI-2569 Rev-0. This QA Inspector observed QC Inspector Pat Swain was monitoring the work at this location.

12W/13W-A deck: This QA Inspector observed multiple fitting aids had been welded to the deck and observed QC Inspector Jesus Cayabyab using a camera and tape measure to document the locations.

This QA Inspector was informed by Lead QA Inspector, Danny Reyes, that access was available for performing Ultrasonic Testing (UT) at Electro Slag Welding (ESW) locations W and N, face – B (inside). ABF personnel had previously been in the space using the carbon arc process to remove the remaining strong back sections.

ESW weld joint location W and N: This QA Inspector performed UT using a 70 degree transducer from Face – B (inside) at ESW locations W and N. This UT is considered to be preliminary at this time and was performed from Y-800 to Y1800 on both welds. This QA Inspector did not observe any signals indicating a defect or a recordable

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# WELDING INSPECTION REPORT

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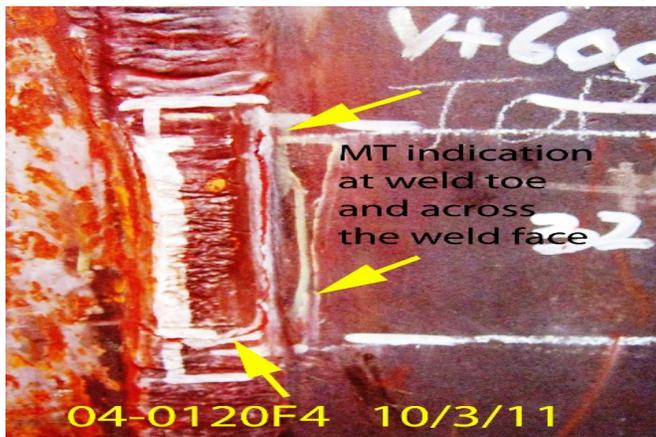
indication at this time. See Ultrasonic Testing Report (TL-6027) this date for further details.

ESW weld joint location R: This QA Inspector performed a random visual verification at the “cold start” area to verify the status of the work at this location and observed what appeared to be a visual defect. This QA Inspector performed Magnetic Particle Testing (MT) from approximately Y-500 to Y-750 and observed an indication approximately 110 mm in length in the toe of the weld on the tower side . This QA Inspector observed this indication appeared to turn and travel in a direction transverse to the weld for approximately 20 mm. Please see photo below. This QA Inspector informed Lead QA Inspector Danny Reyes of this observation and was informed a transverse and/or any MT indications had not been previously reported by QA personnel and/or QC personnel to the best of his Knowledge.

This QA Inspector verbally informed QA SPCM Lead Inspector, Daniel Reyes, of the issues noted in this report for compliance therefore for further details of issues of significance see QA SPCM Lead Inspector, Daniel Reyes, Daily Inspection Report (6031) for this date.

### Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above and noted above there were no notable 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 Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hager,Craig

Quality Assurance Inspector

**Reviewed By:** Levell,Bill

QA Reviewer

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