

**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-026489**Date Inspected:** 07-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite

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

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** SAS OBG**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:

- 10W PP88 W4 Lifting Lug hole (Interior)
- 12W 13W "A" Deck Welding (Exterior)
- 12W 13W "A" Deck Welding (Exterior)
- 12W 13W "D" Deck Welding (Interior)
- 12W 13W "D" Deck Welding (Interior)
- 12W 13W "D" Deck Welding (Interior)

- 10W PP88 W4 Lifting Lug hole (Interior)

The QA inspector observed the QC inspector identified as Sal Moreno perform Magnetic Particle Inspection of completed cover welds on Lifting Lug Holes #1 and 3 at 10W PP88 W4 on the interior of the OBG. The QA inspector verified that the proper procedure was utilized as well as correct technique. The testing found no indications and the QA inspector verified the findings and noted that the work appears to be in general conformance with the contract documents.

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### 2. 12W 13W “A” Deck Welding (Exterior)

The QA inspector randomly observed ABF welding operators Rory Hogan ID#3186 performing Submerged Arc Welding (SAW) on A4/A5 at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-4042 B-1. The parameters were recorded as (A=550/V=32.5/TS=434/HI=2.47). The QA inspector verified the temperature of the flux prior to welding operations and throughout the shift for compliance. 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. The QA inspector reviewed the observations and inspection with QA SPCM Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QA inspector and the QA SPCM Lead Inspector concurs with the QA report.

### 3. 12W 13W “A” Deck Welding (Exterior)

The QA inspector randomly observed ABF welding operators Dan Ieraci ID#3232 performing Submerged Arc Welding (SAW) on A1/A2 at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-4042 B-1. The parameters were recorded as (A=560/V=32.5/TS=435/HI=2.51). The QA inspector verified the temperature of the flux prior to welding operations and throughout the shift for compliance. 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. The QA inspector reviewed the observations and inspection with QA SPCM Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QA inspector and the QA SPCM Lead Inspector concurs with the QA report.

### 4. 12W 13W “D” Deck Welding (Interior)

The QA inspector randomly observed ABF welding operators Wai Kit Lai ID#2953 performing Flux Core Arc Welding with gas (FCAW-G) on the joint of D1 of the OBG. 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-F3200-2. The parameters were recorded as (A=280/V=24/TS=340/HI=1.8). 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. The QA inspector reviewed the observations and inspection with QA SPCM Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QA inspector and the QA SPCM Lead Inspector concurs with the QA report.

### 5. 12W 13W “D” Deck Welding (Interior)

The QA inspector randomly observed ABF welding operators Jin Pei Wang ID#7299 performing Flux Core Arc Welding with gas (FCAW-G) on the joint of D2 of the OBG. 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-F3200-2. The parameters were recorded as (A=238/V=24/TS=340/HI=1.00). 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. The QA inspector reviewed the

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observations and inspection with QA SPCM Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QA inspector and the QA SPCM Lead Inspector concurs with the QA report.

## 6. 12W 13W "D" Deck Welding (Interior)

The QA inspector randomly observed ABF welding operators Xiao Jian Wan ID#9677 performing Flux Core Arc Welding with gas (FCAW-G) on the joint of D2 of the OBG. 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-F3200-2. The parameters were recorded as (A=285/V=24/TS=340/HI=1.20). 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. The QA inspector reviewed the observations and inspection with QA SPCM Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QA inspector and the QA SPCM Lead Inspector concurs with the QA report.

### 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.



### 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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