

**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-026491**Date Inspected:** 06-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:** Job Site**CWI Name:** Pat Swain**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 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/13W A1 thru A5: This QA Inspector observed ABF personnel placing unused / new packages of Submerged Arc Welding (SAW) flux into the flux baking oven which was placed on the 12W deck. This QA Inspector observed ABF personnel were constructing plywood covering for the oven. At approximately 0915 hours this date this QA Inspector observed what appeared to be the thermostat on the flux oven set at 600°F and that the thermometer for the flux temperature was reading 227°F. The weather condition this date contained rain storms off and on and at 0915 hours this date this QA Inspector observed water running down through the weld joint, see photo below. This QA Inspector observed SAW was not performed this date. This QA Inspector monitored the SAW flux temperature this date at multiple times for verification of baking at the minimum time and temperature. This QA Inspector observed the flux temperature appeared to have reached a temperature of 607°F as of 1501 hours this date. This QA Inspector checked the flux temperature after approximately 2 hours and observed temperature reading was 608°F, see photos below. AWS D1.5-02, paragraph 12.6.6.3 states that new flux must be baked at a minimum temperature of 550°F for a minimum of 2 hours prior to use. This QA Inspector observed the temperature reading observed between 1500 and 1700 hours this date appeared to meet these requirements. ABF welding foreman Danny Ieraci (#3232) informed this QA Inspector he anticipated starting the SAW first thing

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next morning.

8E-PP70-E5 NE Access Hole: This QA Inspector observed that grinding of the back gouged weld joint from the top surface was not completed this date due to rain. Welding at this location was not observed.

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

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**Reviewed By:** Levell,Bill

QA Reviewer