

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-026497**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:** See 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**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed as noted below:

## A). OBG W12/W13

This QA SPCM Lead Inspector assigned QAI Craig Hager to observed the Complete Joint Penetration (CJP) welding of the Seismic Performance Critical Member (SPCM) field splice identified as 12W-13W-A. There was no welding performed due to the welding department preparing the welding set up for the Sub-Merged Arc Welding (SAW) process and awaiting for the baking process of the flux to be completed. The QAI, Mr. Hager, and the QC inspector, William Sherwood observed the filling of the drying ovens with the ESAB OK Flux 10.62 and verified the oven temperature of 315 degrees Celsius at 1500 and 1700.

At the conclusion of the shift this QAI SPCM Lead Inspector discussed and reviewed the work performed by the QAI, Craig Hager, in regards to verifying the work described above. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and AWS D1.5-Section 12.6.6 SAW/Para 12.6.6.3, 2002 with no issues noted on this date.

## B). OBG E12/E13

This QA SPCM Lead Inspector assigned QAI William Clifford to observed the continued seal welding of the

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Siesmic Performance Critical Member (SPCM) field splice identified as 12E-13E-A. The welding was performed utilizing the Flux Cored Arc Welding w/gas (FCAW-G) as per the Welding Procedure Specification (WPS) ABF-WPS-D15-F3200-2, Rev. 0 which was utilized by the QC Inspector, William Sherwood, as a reference to monitor the welding, verify the welding parameters and the preheat and interpass temperatures. The QAI also observed and monitored the inspection performed by the QC inspector.

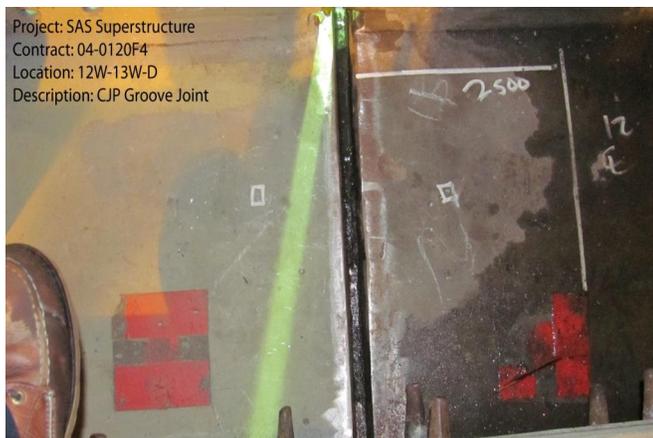
Later in the shift, this QA SPCM Lead Inspector also observed the QAI, Mr. Clifford, monitor the work performed by the QC inspector and at random intervals observed Mr. Clifford verify the welding parameters, the minimum preheat and maximum interpass temperatures. At the conclusion of the shift this QAI SPCM Lead Inspector discussed and reviewed the work performed by QAI William Clifford in regards to verifying the WPS's, consumables, welding parameters, preheat and interpass temperatures in regards to the work described above. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and AWS D1.5-Section 12.16, 2002 with no issues noted on this date. The welding was not completed during this shift.

## C). Review of QA Tracking Plan

This QA Inspector continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG), Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates. The QAI also updated the tracking records for the pipe welds and the pipe supports.

On this date the QAI commence the review of QA tracking documents for the OBG's identified as E3, E4 and E5.

The digital photographs below illustrate some of the work observed during this scheduled shift.



## Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

## Comments

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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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>	Reyes,Danny	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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