

**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-026512  
**Date Inspected:** 12-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:** 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  
**Component:** SAS OBG

**Bridge No:** 34-0006**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:

1. 9W PP80 Pipe Welding (Exterior)
2. 12W 13W D2 Welding (Interior)
3. 8W PP62 Pipe Welding (Exterior)
4. 10W PP92 W Lifting Lug Holes (Interior)

1. 9W PP80 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat and 3G vertical positions on 2.5 and 4 inch schedule 80 pipe located at 9W PP80 weld #19/2.5/80/SW and weld #19/4/80/SW. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

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## 2. 12W 13W D2 Welding (Interior)

The QA inspector randomly observed ABF welding operator Rory Hogan ID#3186 performing Submerged Arc Welding (SAW) on "D2" 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=400/HI=2.73). 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.

## 3. 8W PP62 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat and 3G vertical positions on 2.5 and 4 inch schedule 80 pipe located at 8W PP62 weld #12/2.5/62/SW and weld #12/4/62/SW. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

## 4. 10W PP92 W Lifting Lug Holes (Interior)

The QA inspector observed ABF welder Mike Jimenez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on Lifting Lug Holes (LLH) #2 and 4 located at 10W PP92 W4. The QA inspector observed the QC inspector identified as Sal Moreno monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Revision 1. The parameters were recorded as (Amperes=135). The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA 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.

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## 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:** Frey,Doug

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer