

**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-026552**Date Inspected:** 20-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Listed 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:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) 12E/12E weld F backgouging
- 2) Utility Piping Welding

1) The QAI observed ABF welder Fred Kaddu, ID 2188, removing the backing bar from OBG field splice 12E/13E weld F. The QAI noted that the weld is completed on the outside of the OBG and the backing bar is being removed to back weld the interior of the weld. The QAI noted that this work is in progress and was not completed at the end of the shift. See the attached photo.

2) The QAI observed ABF / F.W. Spencer personnel fitting and welding utility piping on the E5 line at approximately panel point 50, on the outside of the barrier rails. The QAI met with the Quality Control Inspector (QCI) Steve Jensen and was informed that the installed piping (utility air & utility water) lines will be moved from the location they are being welded. The QAI noted that the lines will be pulled down to panel point 43 and connected to lines that have been previously installed. The QAI noted that the welding is being performed by Curtis Jump, ID 7326. The QAI was informed that welding procedure specification (WPS) 1-12-1, is being used for the open root pipe welding. The QAI noted that the WPS lists a 6010 electrode for the root passes and 7018 electrode for the final passes. The QAI noted that the welder had both types of electrodes in his possession and was beginning the root passes. The QCI informed the QAI that the fit-up was acceptable and that the welding was

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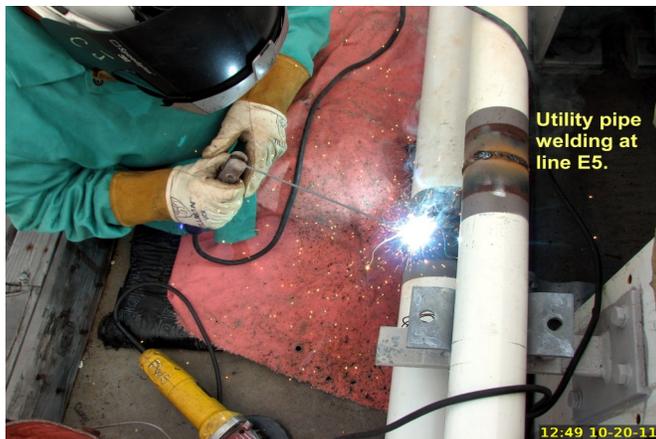
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within the parameter of the WPS. The QAI made random observations of the work in progress and noted that it appeared to be conforming to the contract requirements. The QAI was informed that after this section of piping is welded, it will be pulled into place. The QAI was informed that the painting and final bolt up will be done later, as there are branch connections that still need to be installed. See the attached photo.



## Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the observations and status of work to the QAI Danny Reyes and the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

## 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:** Croff, Scott

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer

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