

**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-026674**Date Inspected:** 08-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted 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 Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford 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:

Approximately 8:00 this QA randomly observed QC Fred Vonhoff perform visual inspection of weld reinforcement at "D" bottom plate of 12E/13E segment splice. Mr. Vonhoff recorded reinforcements measuring from 0~5mm. ABF/JV personnel utilized angle grinding equipment to reduce weld reinforcements that measured in excess of 3mm.

After completion of grinding, this QA observed Inspector Vonhoff performing magnetic particle inspection of areas that had previously been measured and/or corrected to meet tolerance criteria.

See attached illustration for areas of visual and magnetic particle inspection.

**In Process Visual Inspection****East Line**

This QA observed, at random intervals, ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint being welded was a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at E4-PP128-LLH#1&2 and was performed in the flat position from the top of the "A" deck plate.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=136).

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This joint is a Seismic Performance Critical Member (SPCM) member.

Approximately 9:45 this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of the back gouged welds at this panel point E4-PP128-LLH#1&2 location. Mr. Vonhoff recorded no rejectable indications at this time.

This QA observed, at random intervals, ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint being welded was a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at E3-PP128-LLH#3&4 and was performed in the flat position from the top of the "A" deck plate.

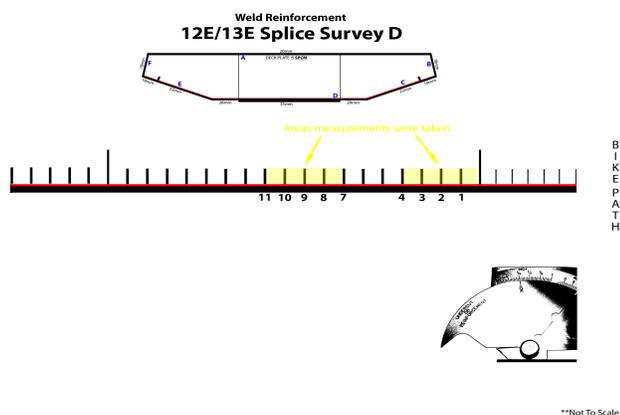
During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=134).

This joint is a Seismic Performance Critical Member (SPCM) member.

Approximately 9:30 this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of the back gouged welds at this panel point E3-PP128-LLH#3&4 location. Mr. Vonhoff recorded no rejectable indications at this time.

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant 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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Clifford, William	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill	QA Reviewer
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