

**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-026688**Date Inspected:** 11-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**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 this 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) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QAI Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

William Clifford-OBG W13/W14 ("D1" Bottom Plate).

Douglas Frey-Lifting Lug Holes at OBG W14 and E13/E14-F1 (Repair Welding) .

Craig Hager-OBG E14 Lifting Lug Holes and Tower 114M El. (Cover plates at Field Splice).

Joselito Lizardo-OBG E13/E14 ("D1" Bottom Plate) and OBG E11 (MPT of Lifting Lug Hole).

**Quality Assurance Lead Inspector (QALI) Summary**

This QA Lead Inspector (QALI) observed the QA Inspector's Craig Hager, Joselito Lizardo, Douglas Frey and William Clifford monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables,

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welding parameters, preheat and interpass temperatures. 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 no issues were noted on this date.

For additional detailed information see the individual, submitted and approved, QAWeld Inspection Reports (WIR).

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).

**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.

In regards to the linear indication on the north face of the jacking frame, this QALI was informed by Mr. Daquinag that ABF QC had performed an Ultrasonic Test (UT) of the linear indication on Thursday afternoon, November 10, 2011.. This test was performed for information purposes only to the determine the depth of the indication. Mr. Daquinag informed this QALI that at the conclusion of the test, the depth was determined to be 7 mm to 13 mm deep. This QALI contacted and informed the QA Supervisor, William Levell, of the test results.

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

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