

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
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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-026700  
**Date Inspected:** 12-Nov-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:** 1530  
**Location:** Jobsite

<b>CWI Name:</b>	As noted below	<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No	N/A
		<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	SAS OBG		

**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:

- 14W/PP128/W4 Lifting Lug Hole W4 (Exterior)
- 14W/PP128/W3 Lifting Lug Hole W2 (Exterior)
- 13W/14W/"D1" (Interior)

- 14W/PP128/W4 Lifting Lug Holes W4 (Exterior)

This QA Inspector randomly observed ABF welder Jorge Lopez (Welder ID 6149) performing the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the Seismic Performance Critical Member (SPCM) "A" deck lifting lug hole 14W/PP128/W4/W4. This QA Inspector observed QC Inspector Sal Merino verify that the preheat temperature was at the minimum of 10 degrees C and that the welding parameters (Amps=260) were in accordance with ABF-WPS-D15-1050A-CU. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general compliance with the approved WPS and the contract specifications.

- 14W/PP128/W3 Lifting Lug Hole W2 (Exterior)

This QA Inspector made random observations of ABF welder Mike Jimenez (ID 4671) perform the Shielded

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Metal Arc Welding process (SMAW) in the 1G flat position on the SPCM Lifting Lug Hole (LLH) 14W/PP128/W4/W2. This QA Inspector observed QC Inspector Sal Merino measure the pre-heat temperature to verify a minimum of 10°C was achieved. This QA Inspector also observed the QC Inspector monitoring the welding and verifying that the parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The parameters were recorded as (Amperes=230) utilizing a 4.0 mm E7018-H4R electrode. During in process welding, this QA Inspector noted that the QC Inspector measured the inter-pass temperatures to maintain a heat range below 230°C. This QA Inspector made subsequent observations during the shift and noted that the work was completed on this date and appeared to be in general conformance to the contract specifications.

### 3. 13W/14W/“D1” (Interior)

This QA Inspector randomly observed ABF welding operator Rory Hogan (ID3186) performing Submerged Arc Welding (SAW) on “D1” at 13W/14W of the OBG. The Seismic Performance Critical Member (SPCM) joint being welded has a single V-groove butt joint with backing bar that will be removed and back gouged then back welded. This QA Inspector observed QC Inspector Steve Jensen 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=555/V=32.5/TS=365/HI=2.93). 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.

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:

The were no pertinent conversations to report.



### 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>	Frey,Doug	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell,Bill	QA Reviewer
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