

**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-026709  
**Date Inspected:** 14-Nov-2011

**Project Name:** SAS Superstructure  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV  
**Contractor:** American Bridge/Fluor Enterprises, a JV

**OSM Arrival Time:** 600  
**OSM Departure Time:** 1530  
**Location:** Job Site

<b>CWI Name:</b>	See 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>	OBG	

**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead 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 QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Douglas Frey-OBG W12/W13-C2(Repair Welding), OBG W14(Welding of Lifting Lug Holes).

Joselito Lizardo-OBG E13/E14 ("D1" Bottom "I" Vertical Plates), OBG E12/E13-C(Excavation & Repair Welding)

Art Peterson-Continued review of punch list item identified as No. 3508 from the OBG shipment 8 and observed the work on the skyway in regards to CCO #193, 178 and 128.

Craig Hager-OBG E14 field fit-up and welding of the Lifting Lug & Ventilation Holes and observed QC/UT at the OBG field splice 12E-13E-C.

William Clifford-OBG W13/W14 ("D1" Bottom, "H" Bottom Side Plate) and OBG E14 (Lifting Lug and Ventilation Holes). Note: See Summary of Conversations in regards to the field fit-up of plate "H" on page xxxx of this report.

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

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Douglas Frey, Art Peterson, Craig

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Hager 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, 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, QA TL-6031 Weld Inspection Reports (WIR) and QA TL-6027 Ultrasonic Test Reports (UTR).

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.

QAI, William Clifford, informed this QALI of the planar misalignment located at the W13-W14-D1 and H field splice junction. It appears that the ABF fitting crew has exhausted multiple ways to correct the misalignment of approximately 9 mm. Later in a conversation with QC Lead Inspector, Bonifacio Daquinag, Jr., informed this QALI that an internal Non-Conformance Report (NCR) would be generated regarding to this issue.

### 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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