

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026742**Date Inspected:** 21-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** Bernie Docena**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:** Bike Path - Skyway**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on the jobsite between the times noted above to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations made on this date were:

CCO: 178 - Description: Modify the existing Bike Path belvederes, Bike Path maintenance traveler, and existing maintenance traveler rail on the Skyway portion of the East Span SFOBB.

This QA Inspector randomly observed ABF welder Mr. Gil Peralta performing the Air-Carbon-Arc gouge operation to remove the remnant material - (at least 10 mm of material) from the section of the architectural beam that was previously removed from the bottom panel of the Bike Path at Pier Location 8E. This QA Inspector observed that the removal of remnant material did not damage the remainder of the Bike Path bottom panel. The steel surface was ground flush and there were no areas that were damaged that required any weld repairs to be performed. See attached Photos.

This QA Inspector randomly observed ABF welder Mr. Gil Peralta (Welder ID 9543) performing the fillet weld operation on the new cover plate to the remaining architectural beam of the belvedere at Pier Location 8E per the Shielded Metal Arc Welding (SMAW) process in the (3F) vertical and (4F) overhead positions. This QA Inspector observed QC Inspector Mr. Bernie Docena verify prior to the start of the fillet weld operation that the welding parameters (Amps, Volts and Travel Speed) and the preheat temperature of 70 degrees F were established and in accordance with WPS-F1200A. See attached Photos.

After the fillet weld operation was completed connecting the new cover plate to the end of the remaining architectural beam, this QA Inspector observed QC Inspector Mr. Bernie Docena; perform a visual inspection of

# WELDING INSPECTION REPORT

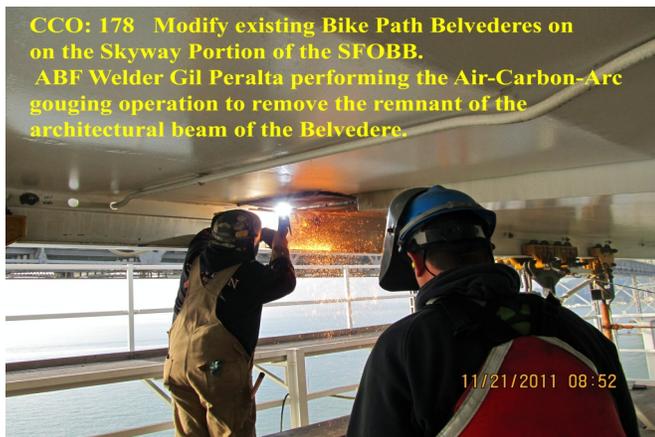
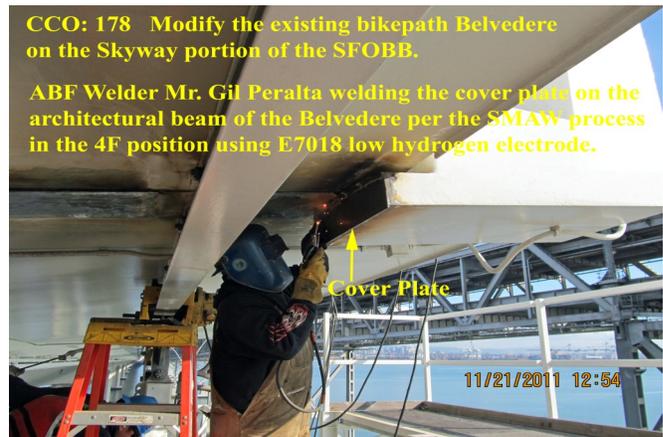
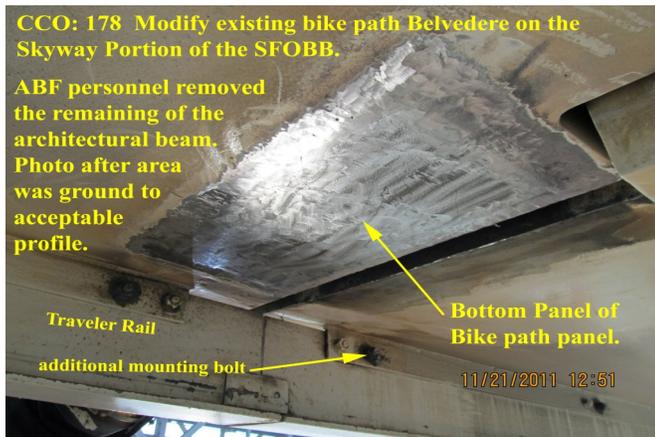
( Continued Page 2 of 3 )

the fillet weld to verify the fillet weld size and weld quality. The fillet weld size and quality visually appeared to be in general compliance with AWS D1.5-2002 Section 3.6 and CCO 178.

CCO: 178 - Description: Modify the existing Bike Path belvederes, Bike Path maintenance traveler, and existing maintenance traveler rail on the Skyway portion of the East Span SFOBB.

This QA Inspector observed ABF personnel performing the drilling operation for the installation of additional mounting bolts - (19 mm diameter) in the existing box girder web plate of the Bike path box girder and the Bike Path maintenance traveler outer rail. This QA Inspector observed that ABF personnel were in-process on the drilling operation and were working towards Pier location 10E at the end of this QA Inspectors' shift.

The work observed on this date on CCO 178 appeared to be in general compliance with the extra work described in the CCO and the contract specifications.



## Summary of Conversations:

No significant conversations were reported on this date.

## 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.

---

---

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

---

**Inspected By:** Peterson, Art

Quality Assurance Inspector

---

**Reviewed By:** Levell, Bill

QA Reviewer