

**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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026767**Date Inspected:** 28-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** N / A**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:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) Document Reviewing at Pier 7
- 2) OBG Deck welding at 14E
- 3) Field splice prep at 13E/14E-F

1) The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued reviewing welding report package 91 for it's conformance with the contractor requirements.

2) The QAI observed ABF personnel making complete joint penetration (CJP) welds at 14E, panel point (PP) 125 line E4, lifting lug hole #1. The QAI noted that ABF welder Eric Sparks, ID 3040, is using Shielded Metal Arc Welding (SMAW) in the flat (1G) position. The QAI also noted that the Quality Control Inspector (QCI) Bernie Docena is monitoring this welding. The QAI spoke with the QCI and confirmed that the weld being made has the contract requirements of a Seismic Performance Critical Member (SPCM). The QAI verified that the preheat and interpass temperatures were conforming to the welding procedure specification (WPS) ABF-WPS-D15-1050A-CU.

The QCI informed the QAI that the welding parameters were conforming to the WPS. The QAI made random observations of the work in progress during this shift. The QAI noted fill passes are being made. The work was in progress until the end of the shift and was not completed.

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3) The QAI observed ABF personnel removing the backing bar from the exterior side of weld F on the 13E/14E field splice. The QAI noted that Fred Kaddu, ID 2188, is using carbon arc gouging to remove the backing bar to prepare the CJP field splice for back welding. The work was in progress until the end of the shift and was not completed. See the attached photo.

The QAI also observed several QCI performing Magnetic Particle Testing and Ultrasonic Testing at completed lifting lug hole welds and completed vent hole welds in the deck of OBG 14E. The QAI noted that verification testing was being performed by the QAIs William Clifford and Joselito Lizardo.



### Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the general observations and status of work to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

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

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