

**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-026802**Date Inspected:** 29-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) Green tag release of North Tower Head
- 3) Preliminary Post Arrival Inspection

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 its conformance with the contractor requirements.

2) The QAI was requested to green tag the North Tower Head for shipment to Tangent, Oregon. The QAI noted that the part will be receiving additional modification at L & M industrial fabricators. The QAI was informed that the work will be performed according to the approved Contract Change Order (CCO) 179. The QAI also noted that shop drawings for the work to be performed are referenced in Submittal 2568 and have not been approved at this time. The QAI conferred with the Structural Materials Representative (SMR) Aaron Prchlik and there was general agreement that the part could be released for transport to the fabrication facility. The QAI generate a TL-6011 report and green tag lot number B212-047-11. Reference the TL-6011 for additional information. See the attached photos.

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3) The QAI made observations of the contractor's personnel in the process of unloading shipping containers at Pier 7. The QAI examined some of the parts being unloaded and determined that these parts were shipped from ZPMC.

The QAI relayed this information to the QAI Lead Bill Levell and was then informed that the Quality Control Manager (QCM) Chuck Kanapicki will conduct a post arrival inspection of the components. The QAI was provided with a shipping list and noted that bikepath hand rail sections, OBG deck insert plates, traveler rails and various small parts were part of this shipment. The QAI met with the QCM and a partial post arrival inspection was performed. At the time of inspection, 2 of 6 shipping containers had been unloaded. The QAI and QCM noted that the handrail segments appear to have significant paint damage and minor galvanized zinc damage. The QCM informed the QAI that additional inspections will be performed after all shipping containers have been unloaded. See the attached photos.



## Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the observations and conditions of the unloaded parts and green tag of tower head section 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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