

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-026821**Date Inspected:** 05-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Listed below.**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) F.W. Spencer - Utility pipe welding
- 2) OBG QC inspections
- 3) Pier 7 - CCO 179 green tag

1) The QAI observed F.W. Spencer personnel making complete joint penetration (CJP) welds on utility piping at the Tower structure. The QAI noted that welder Damian LLanos, ID 6845, is using Shielded Metal Arc Welding (SMAW) in the horizontal (2G) position. The QAI also noted that the Quality Control Inspector (QCI) Steve Jensen is monitoring this welding. The QAI was informed that welding procedure specification (WPS) 1-12-1, is being used for the open root pipe welding. The QAI noted that the WPS lists a 6010 electrode for the root passes and 7018 electrode for the final passes. The QAI noted that the welder had both types of electrodes in his possession. The QAI noted that weld 7-2-T-114, on the 2" utility water piping was completed and visually inspected by the QCI. The QCI informed the QAI that the weld was acceptable. The QAI examined the weld and it appeared to be conforming to the contract requirements. The QAI noted that as the welds are being completed, the piping is being raised up the length of the tower and additional pipe is being welded in. This work progressed through the shift. The QAI made random observations of the work in progress and noted that it appeared to be conforming to the contract requirements. See the attached photo.

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# WELDING INSPECTION REPORT

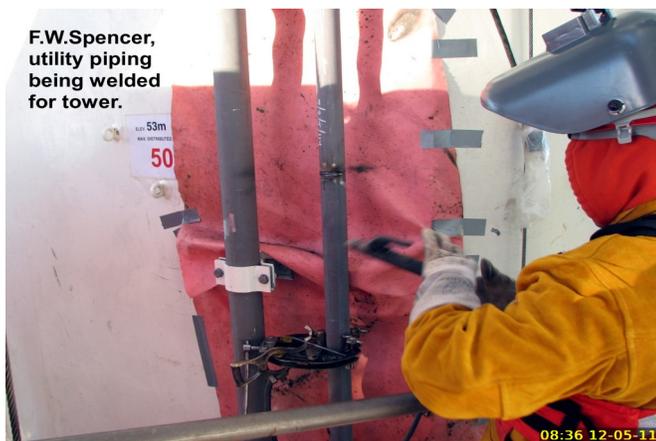
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2) The QAI observed the QCIs John Pagliero, Pat Swain and Jesus Cayabyab conducting Ultrasonic Testing (UT) of completed OBG field splice welds and OBG deck holes (Vent holes and lifting lug holes) on 13E/14E and 13W/14W. The QAI witnessed the QCIs scanning welds and identifying rejectable and recordable indications. The QAI was informed that there were multiple repairs that have been identified and the repairs will be performed at a later time.

3) The QAI was requested to green tag handrail components for the Skyway Bike Path. The QAI noted that the access gates will be receiving additional modification at R.W. Fab. and expansion plates will be sent to 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) Nicolai Hvass and there was general agreement that the part could be released for transport to the fabrication facilities. The QAI generated TL-6011 reports and green tag lot numbers B212-048/049-11. Reference the TL-6011s for additional information. See the attached photo.



### 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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