**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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Casey, William
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-026871
**Date Inspected:** 12-Dec-2011

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

**OSM Arrival Time:** 700
**OSM Departure Time:** 1530
**Location:** Job Site

| | | | |
|---|---|---|---|
| **CWI Name:** | As noted 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:** | OBG Component |

**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection
13W/14W

This QA randomly observed ABF/JV qualified welder Rick Clayborn #2773 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200. Welding consisted of six millimeter (6mm) fillet welds to attach temporary erection aid “PWS Swift Guide Support” at approximately 13W-PP121.5-W3 as detailed on Sheet No: DE450DQ.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=138).

This weld is a Seismic Performance Critical Member (SPCM) member.

This QA randomly observed ABF/JV qualified welder Eric Sparks #3040 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200. Welding consisted of six millimeter (6mm) fillet welds to attach temporary erection aid “PWS Swift Guide Support” at approximately 13W-PP121.5-W3 as detailed on Sheet No: DE450DQ.

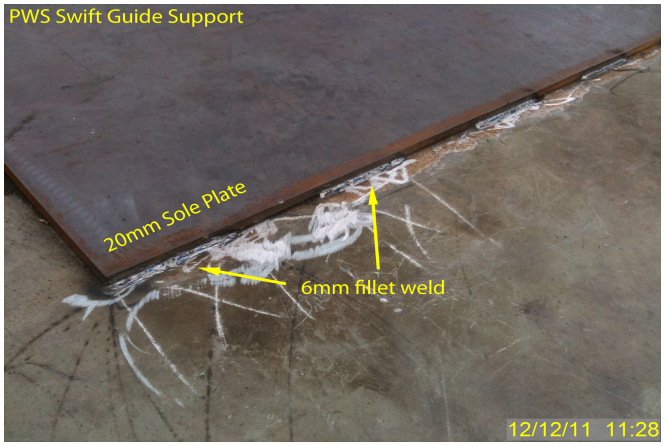
During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

Welding parameters were recorded as (A=138).
This weld is a Seismic Performance Critical Member (SPCM) member.

Ultrasonic Testing
This QA performed Ultrasonic Testing (UT) on approximately 25% of 13E/14E "D" deck plate Complete Joint Penetration (CJP) splice weld. Approximately 3000mm of this weld was inspected using this testing method. (Testing area includes a repair area previously retested and accepted by QC personnel.)
This weld was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.
This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.
This weld is a Seismic Performance Critical Member (SPCM) member.

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.




**Summary of Conversations:**
No relevant conversations.
**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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

**Inspected By:** Clifford,William Quality Assurance Inspector

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

**Reviewed By:** Levell,Bill QA Reviewer