

**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-026900**Date Inspected:** 16-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See 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**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Douglas Frey-OBG Field Splice W13/W14 (Observation of Repair Welding and QC Inspection of Plate "A2.2") and OBG W12/W13 (Observation of repair welding and QC inspection of plate "E").

Joselito Lizardo-OBG E11 (Observation of the repair welding and QC inspection on the lifting lug holes), OBG E13/E14 Field Splice (Observation of Welding and QC inspection on "E2" Side Plate) and FW Spencer, South Tower Shaft (Observation of the utility pipe welding).

Art Peterson-CCO: 179 Item 2-Continued observation of the welding and QC Inspection of the pipe sleeve at the bike path divider panels and installation of the pipe sleeve at the South Rail Divider and CCO: 193-Observation of modification of bike path panels at the expansion joints.

William Clifford-OBG W11 (Observations of welding, repair welding and QC inspection/testing of lifting lug holes), OBG W13/W14 field splice (Observation of welding and QC inspection of "A2.2" deck plate) and QA/UT verification ventilation holes.

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# WELDING INSPECTION REPORT

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## Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Douglas Frey, Art Peterson, Joselito Lizardo and William Clifford monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and one (1) issue was noted on this date. For additional information see Summary of Conversation.

See QA daily Weld Inspection Reports (WIR) for additional information and details.

This QA Inspector continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates).

### Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

This QALI was informed by QAI, William Clifford, that upon the arrival to perform QA/UT verification of a ventilation hole identified as 14W-PP126.2-W3.7 per the request of Lead QC inspector, Bonifacio Daquinag, Jr., he noted that the CJP weld had been painted. Mr. Clifford informed the QC lead inspector of this issue and expressed to Mr. Daquinag that QA verification would commence after the paint is removed. This QALI concurs with the action taken by Mr. Clifford.

Later in the shift this QALI spoke with QC Lead Inspector, Mr. Daquinag, regarding this issue and Mr. Daquinag response was that the paint would be removed and he would notify Mr. Clifford when the paint removal task was completed.

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

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