

**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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026976**Date Inspected:** 27-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Harry Scharein**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:** Bike Path - Skyway**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on the jobsite between the times noted above to randomly observe Quality Control (QC) personnel monitor the welding operations performed by American Bridge Fluor (ABF) personnel on the bike path box panels of the Skyway portion of the SFOBB. The following observations made were for extra work being performed to the following contract change orders:

Skyway Portion of the SFOBB: Bike Path at Expansion Joint Hinge "C"

CCO: 193 - Description: Modify the existing bike path panels at the expansion joints of the Skyway portion of the SFOBB East Span Seismic Safety Program.

This QA Inspector randomly observed ABF welder Mr. Jason Collins (Welder ID 8128) performing the root, fill and cover pass weld operation on a partial-joint-penetration (PJP) groove weld per the Flux Cored Arc Welding (FCAW-S) self shielding process in the (2G) horizontal position connecting the new end plate to the existing bottom soffit plate of the bike path panel at expansion joint Hinge "C" as per ABF Submittal no. 2549R1 of Contract Change Order (CCO) 193. This QA Inspector observed QC Inspector Mr. Harry Scharein verify prior to the start of the root, fill, and cover pass weld operation that the preheat temperature of 150 degrees F was established and afterwards verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with ABF-WPS-D15-2160-1 using the E71T8 NR232 electrode - (.072") diameter electrode. The cover pass weld operation was still in-process at the end of this QA Inspectors' shift.

The root, fill, and cover pass weld operation observed on this date appeared to be in general compliance with the

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# WELDING INSPECTION REPORT

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aforementioned weld procedure specification and the work observed appeared to be in general compliance with contract change order (CCO) 193.

Note: At the Expansion Joint Hinge "C", this QA Inspector previously observed ABF personnel cut back the Top skin plate, Side skin plate and the Diaphragm plate of the bike path box panel using an oxyacetylene cutting torch on a track system and also observed ABF personnel use a mechanical cutting blade on the existing Bottom skin soffit plate of the bike path box panel. The cut back distance was measured at 306 mm as per Contract plan sheet number 1164S8 and ABF Submittal number 2549R1. The new end plate weld operation connecting to the bike path box panel is being performed on this date as mentioned above.



## Summary of Conversations:

No significant conversations were reported on this date.

## 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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**Inspected By:** Peterson, Art

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer

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