

**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-027229**Date Inspected:** 22-Feb-2012**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:** Salvador Merino**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:**

Quality Assurance Inspector (QA) Rene Hernandez 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 randomly being observed:  
West Line

This QA observed, at random intervals, ABF/JV qualified welder Mike Jimenez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 13W PP119.5 W3 2 was performed in the flat position from the topside of the "A" deck plate. During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded. Also verified that CU backup strip was secured from top and under deck.

**Ultrasonic Testing**

This QA performed Ultrasonic Testing (UT) on approximately 10% of welds at the following location and weld numbers: 13W/14W weld no. A3 and A4.

These welds were 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

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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 inspector observed ABF QC personnel performing MT weld inspection in accordance with section 6 of AWS D1.5. All work was being performed by certified personnel performing MT testing to level II requirements. Weld inspection was observed at 13W/14W weld # A3 and A4.

This QA inspector observed that during fitup of 20mm thick cover plate weld identified as 11W PP109.5 W5 SW had an excessive root gap around the entire circumference of the weld. QC personnel has stopped further work from occurring until a decision by the contractors engineer has been reached and a repair procedure has been recommended for submittal to the appropriate authority for approval and or further recommendations. Note: this item is still in pre-construction mode, no items have been presented for inspection, work has been temporarily suspended.

This QA observed, at random intervals, ABF/JV qualified welder Rory Holguin #3186 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-10101-1. This was a Complete Joint Penetration (CJP) weld on a 18mm stiffener plate on CB side of "pit" welding. This work was located at L13W PP119 – 119 +1500 was performed in the flat position from the topside of the stiffener plate. During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded.

This QA observed, at random intervals, ABF/JV qualified welder

Valmont Industries

Attended meeting at Pier 7 office with Caltrans representative Jason Gramlick. Meeting consisted of estimating man-hours for construction of C-channel backing. A Claim has been filed and we are estimating cost based on my knowledge of their fabrication capabilities. Areas of fabrication cost were based on the following construction practices: Welding, post buffing of galvanizing, grinding of C-channel, starter wall construction, and indirect man-hours.



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**Summary of Conversations:**

Pertinent conversations are in the body of this report

**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>	Hernandez,Rene	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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