

**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-027354**Date Inspected:** 21-Mar-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**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:**

Quality Assurance (QA) Inspector Danny Smith arrived at the new San Francisco Oakland Bay Bridge to observe, document and perform a general visual verification and NDT. Upon arrival the QA Inspector observed Quality Control Inspector (QC) John Pagliero on site performing welding inspection. The QA Inspector at this time communicated with the QC Inspector regarding the work to be performed on this date. At this time the QC Inspector informed the QA Inspector that work performed on this date consisted of welding the longitudinal stiffener wing plates.

**LSA 12E/13E-@LS5/LS6**

The QA Inspector performed a random visual review of the fit up. Upon completion of performing the review the QA Inspector observed the fit up to be within the proper tolerances per the contract documents.

The QA Inspector then observed ABF welding personnel Jeremy Dolman welder ID#5042 utilizing the Shielded Metal Arc Welding (SMAW) process in the overhead (4G) position with Lincoln Excalibur, 1/8 inch diameter electrode to weld the longitudinal stiffener wing plates.

The QA Inspector observed welder Jeremy Dolman welding on the 18mm Wing Plate to the 35mm stiffener plate located on 12E/13E at LS5/LS6. The QA Inspector performed a random verification of the welding parameters at this location and were observed and noted at 130 amperes for Partial Joint Penetration (PJP) weld passes per Welding Procedure Specification (WPS) ABF-WPS-D15-1162-4. The QA Inspector verified the pre-heat temperature met the minimum requirement of 225 degrees Fahrenheit, but did not exceed the maximum allowable interpass temperature. The welder was observed using the proper cleaning procedures with slag hammers and wire brushes. The QA Inspector observed QC Inspector John Pagliero frequently monitoring the work in progress to ensure compliance with the contract specifications.

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Later in the shift the QA Inspector observed QC Inspector John Pagliero frequently monitoring the work in progress to ensure compliance with the contract specifications.

All work appears to be in general compliance with the contract documents.



## Summary of Conversations:

Conversations included welding work being performed 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:** Smith,Danny

Quality Assurance Inspector

**Reviewed By:** Levell,Bill

QA Reviewer

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