

**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-027410**Date Inspected:** 02-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**CWI Name:** N / A**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:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) Deck Access Hole (DAH) welding, East spans
- 2) DAH welding, West span

1) The QAI observed ABF personnel making vertical (3G) complete joint penetration (CJP) welds at longitudinal stiffeners under the DAH at panel point (PP) 70.5 E2. The QAI noted that ABF welder Todd Jackson, ID 4639, is welding the West stiffener and Khit Lounechaney, ID 4985, is welding the East stiffener. The QAI noted that the Quality Control Inspector (QCI) John Pagliero is monitoring this welding. The QAI noted that these welds are being back welded at this time and almost completed. At both weld locations, the QAI verified that the preheat temperature was conforming to the welding procedure specification (WPS) ABF-WPS-D15-1012-3. As the welding progressed, the QCI informed the QAI that the welding parameters were conforming to the WPS. During this shift, the QAI made random observations of the work in progress at both locations and noted that the shielded metal arc welding (SMAW) appeared to be conforming to the WPS requirements. The QAI noted that the welding was completed at both locations. The QAI was informed that the weld tabs and grinding needed to be performed and the welds will not be ready for final inspections for a while. See the attached photo.

2) The QAI observed ABF personnel making 3G CJP welds at longitudinal stiffeners under the DAH at PP 61.5 W2. The QAI noted that ABF welder Erick Sparks, ID 3040, is welding the West stiffener and Mike Jiminez, ID

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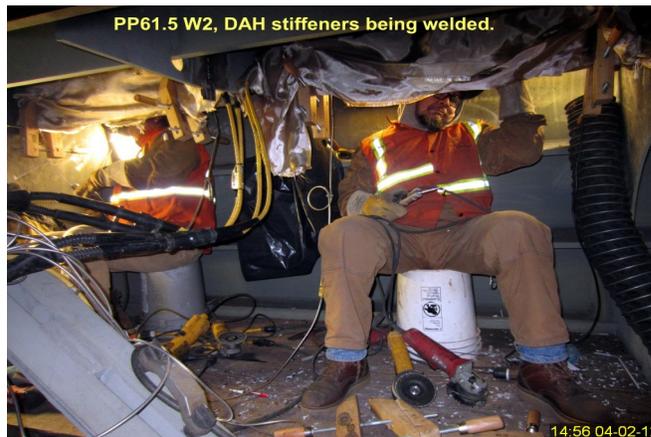
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4671, is welding the East stiffener. The QAI noted that the QCI Steve Jensen is monitoring this welding. The QAI noted that the first side of the welds are being made. At both weld locations, the QAI verified that the preheat temperature was conforming to the welding procedure specification (WPS) ABF-WPS-D15-1012-3. As the welding progressed, the QAI made random observations of the work in progress at both locations and noted that the work appeared to be conforming to the WPS requirements. The QAI noted that this welding was not completed at either location during this shift. See the attached photo.



### Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the general observations and status of work to the QAI Lead Bill Levell and the QAI Ken Riley. Except as described above, there were no other notable conversations or observations.

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