

**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-027485  
**Date Inspected:** 21-Apr-2012

**Project Name:** SAS Superstructure  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV  
**Contractor:** American Bridge/Fluor Enterprises, a JV

**OSM Arrival Time:** 700  
**OSM Departure Time:** 1530  
**Location:** Job Site

<b>CWI Name:</b>	As noted below	<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No	N/A
		<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	SAS OBG		

**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey 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 observed:

## 12W PP109.5 W2- LSW (Interior)

This QA Inspector randomly observed ABF welder Steve Davis (ID 7889) perform back-gouge operations on "A" Deck West Longitudinal Stiffener (LSW) at 12W PP109.5 W2 on the interior of the OBG. Upon completion of the back-gouging and clean up, this QA Inspector observed QC Inspector Sal Merino perform Magnetic particle (MT) testing to ensure the soundness of the metal. It was noted that Mr. Merino found no rejectable indications. This QA Inspector randomly observed the welder perform Shielded Metal Arc welding (SMAW) in the (3G) vertical position utilizing 3.2mm E7018-H4R electrodes drawing amperage of 127. On a subsequent observation, QC Inspector Sal Merino was observed monitoring the welding to insure the parameters were in accordance with ABF-WPS-D15-1012-3. This Q Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general accordance with the contract documents.

## 12E PP112 E2 Temporary Attachments (Exterior)

This QA Inspector observed QC Inspector Sal Merino perform MT Inspection of temporary attachments on the exterior of "A" Deck at the locations listed below. Prior to MT, the surface was examined, and any adjacent area within at least 25 mm of the surface to be tested, was dry and free of contaminants. Mr. Merino performed the

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testing within the standards and specifications. It was noted that rejectable indications was observed on all of the test areas.

12E PP112 E2 12E PP111 E2 12E PP110.5 E2 12E PP110.2 E2  
12E PP110 E2 12E PP109.5 E2 11E PP108.3 E2

12E PP109.5 E2-DAH (Exterior)

This QA Inspector on random observations of ABF welder Salvador Sandoval utilizing a small disc grinder, brushes and compressed air to grind and blend the excessive reinforcement of the Deck Access Hole (DAH) located at 12E PP109.5 E2 on the interior of the OBG. On subsequent observations, Mr. Sandoval was observed performing SMAW as touch up in certain locations and it was noted that the work at this location was in progress and appeared to be in general conformance with the contract specifications.

### Summary of Conversations:

There were general conversations with Quality Control Inspector, Jesse Cayabyab at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.



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

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