

**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-027504  
**Date Inspected:** 26-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:** 1730  
**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:

## 12E PP109.5 E2 LSW (Interior)

This QA Inspector made random observations of ABF welder Todd Jackson (ID 4639) conducting back gouge operations on the West Longitudinal Stiffener (LSW) of the Deck Access Hole (DAH) located at 12E PP109.5 E2 on the interior of the OBG. The welder was observed utilizing the Air Carbon Arc method to remove weld metal from the weld root side of the joint and also employed a small disc grinder. Upon completion of the back-gouging, QC Inspector Sal Merino performed a Magnetic Particle (MT) Inspection to verify soundness of the metal. It was noted that Mr. Merino found no rejectable indications. On a subsequent observation, the welder was observed performing Shielded Metal Arc Welding (SMAW) in the 3G vertical position utilizing 3.2mm E9018-H4R electrodes drawing an amperage of 119. QC Inspector Sal Merino was present monitoring the welding and the parameters as they pertain to ABF-WPS-D1.5-1012-3. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work at this location was in progress and appeared to be in general conformance with the contract specifications.

## 12E PP117 E5 (Exterior)

This QA Inspector made random observations of ABF welder Mike Jimenez (ID 4671) welding in the SMAW

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process on "A" deck Diverter Bars located approximately at 12E PP117 E5 on the exterior of the OBG. Mr. Jimenez was employing 3.2mm E7018-H4R electrodes to join the 12.70mm bar stock to the deck with QC Inspector Sal Merino monitoring the welding and the parameters to ensure compliance with ABF-WPS\_D1.5-F1200A. On a subsequent observation it was noted that the work at this location was completed on this date and appeared to be in general conformance with the contract documents.

### 14W PP128 E6 (Exterior)

This QA Inspector randomly observed ABF welder Edward Brown (ID 9331) perform SMAW on the drip rails on the side of the OBG at approximately 14W PP128. The welder was observed welding the bar stock to edge plate "B" on the exterior of the OBG utilizing E7018-H4R electrodes drawing amperage of 123. QC Inspector Sal Merino monitored the welding and the parameters to ensure conformance with ABF-WPS-D1.5-F1200A. The welder completed the work at this location and this QA Inspector noted that it appeared to be in general conformance with the contract documents.

### 12E PP109.5 E5-DAH (Exterior)

This QA Inspector performed a UT inspection on approximately 10% of the welds on the DAH at 12E PP109.5 E5 on the interior of the OBG. 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 date. The completed work observed at this location appeared to be in compliance with the contract specifications.

### Summary of Conversations:

There were no pertinent conversations 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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<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell,Bill	QA Reviewer
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