

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-027523  
**Date Inspected:** 30-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:

## 13W PP120/PP124.7 Grid Line W2.0/W2.8 Deck Plate Drop-in Sections

This QA Inspector made random observations of the fit-up operations of Drop in Panel SA3013A on the west OBG at 13W PP119.7-122.2. ABF Welding personnel were observed pre-heating the deck and this QA Inspector verified the pre-heat utilizing a 150° Tempilstik. ABF welder Rick Clayborn (ID 2773) was observed performing the fillet weld operation as pertaining to the Shielded Metal Arc Welding (SMAW) process to attach blank nuts and key plates along the W2.3 line. QC Inspector William Sherwood was present to monitor the welding as it pertained to ABF-WPS-D1.5-F1200A. Mr. Sherwood was observed measuring the planar offset by employing a Bridge Cam Gauge in order to locate alignment points at W2.1 line. On a subsequent observation, alignment work was being performed on A0 to A2.1. The welder was observed welding transverse to the roll of the steel as pertaining to submittal 1361 Revision 3. At periodic intervals, this QA Inspector observed the welder attaching blank nuts and key plates along W2.8 line in locations identified by the QC Inspector. This QA Inspector observed ABF Welder Todd Jackson (ID 4639) performing the fillet weld operation per the SMAW process in the (4F) overhead position to attach the U-Bars to the underside of the deck plate on Segment 13W. The work being performed was to augment the installation of the non-fusible copper backing bar prior to welding the complete-joint penetration (CJP) single V groove butt-joint between the Deck Plate section and Deck Plate Drop-in section at longitudinal field weld splice along Grid W2.8. On a subsequent observation, this QA Inspector

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observed the welder performing the fillet weld operation per the SMAW process in the (2F) horizontal position attaching the blank nuts to the deck plate on line segment PPW 122.2 for installation of the key plates to adjust the longitudinal weld splice planar offset between the Deck Plate section and Deck Plate Drop-in section at transverse field weld splice 13W/14W on PP125, longitudinal field weld splice along Grid A2.1 and Grid W2.2. This QA Inspector observed QC Inspector William Sherwood verify prior to the start of the fillet weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterward's verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS F1200A using E7018 3.2mm diameter electrodes. Welder Todd Jackson was continuing performing the fillet weld operation per the SMAW process in the (4F) overhead position to attach the U-Bars to the underside of the deck plate on Segment 13W. The work being performed was to augment the installation of the non-fusible copper backing bar prior to welding the complete-joint penetration (CJP) single V groove butt-joint between the Deck Plate section and Deck Plate Drop-in section at longitudinal field weld splice along Grid W2.5. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general conformance with the contract documents.

### 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
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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