

**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-027562**Date Inspected:** 07-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted 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:** As noted below.**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI) David R Gray was at the American Bridge Fluor (ABF) job site between 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:

The QAI witnessed work in progress related to Contract Change Order (CCO) 179. The QAI noted that work was limited to preparing the locations for modifications as detailed on (CCO)179 Sheet 5 of 7, to include removing handrails from panel 140 to approximately 160. Holes for the 16mm Pipe Sleeve were observed being drilled from divider 140 to approximately 145. The expansion Joint Cover Plate was noted as being removed and the same plate was replaced with a few anchor bolts between panels 173 and 174. The QAI spoke with Quality Control Inspector (QCI) Steve Jensen and it was agreed that the QCI would contact the QAI should welding be conducted this date.

At OBG top deck plate 13E-E2.1-@0-9500mm outside, QAI randomly observed ABF certified welder Mike Jimenez ID# 4671 continuing to perform 1G (flat position) Shielded Metal Arc Welding (SMAW) on the Seismic Performance Critical Member (SPCM) CJP splice butt joint. The welder was noted welding 1G flat position using 3.2mm E7018-H4R electrodes with an average of 130amps. This welding was in progress for the duration of the shift. QC Inspector Salvador Merino was observed monitoring the welding parameters for compliance to ABF-WPS-D1.5-1040C-CU Revision 0 and measuring inter-pass temperatures between passes. During subsequent observations it was noted that the welder was using a power disc grinder at weld starts and stops as needed and was cleaning between weld passes with power wire wheel brushes. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general accordance

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with the project plans and specifications.

**Summary of Conversations:**

No significant conversations were held 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>	Gray,David	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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