

**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  
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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-027580  
**Date Inspected:** 10-May-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:** 1600  
**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>	Tower Component	

**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford 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:

**In Process Visual Inspection****Tower**

This QA randomly observed ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 3.2 diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-F1200A. This work was located on C channel designated as 098-3 just below the 9m diaphragm.

During welding, ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters. Welding parameters were recorded as (A=135).

**Request For Information: ABF-RFI-002667R00**

“Multiple Shear Tabs were removed, due to interference during the 9m and 13m Diaphragm erection, which provide a bolted connection between the Diaphragms and Shear Plates...”

This QA randomly observed ABF/JV qualified welder Jeremy Dolman #5042 performing Shielded Metal Arc Welding (SMAW) with 3.2 diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-1160. This work was located on Shear Tabs #1 and #2 at the 9m elevation at location “M”.

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# WELDING INSPECTION REPORT

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During welding, ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters. Welding parameters were recorded as (A=128).

This QA randomly observed ABF/JV qualified welder Jeremy Dolman #5042 performing Shielded Metal Arc Welding (SMAW) with 3.2 diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-F1160. This work was located on Shear Tabs #1 and #2 at the 13m elevation at location "M".

During welding, ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters. Welding parameters were recorded as (A=128).

This QA randomly observed ABF/JV welding personnel performing excavation of welds previously Ultrasonic Testing (UT) rejected. Quality Control (QC) Inspector Jesse Cayabyab performed Magnetic Particle (MT) and visual confirmation of excavations.

Excavations were recorded as follows:

Weld "F" – Y=7305mm, L=160mm, W=15mm, D=10mm

Weld "F" – Y=9100mm, L=180mm, W=35mm, D=40mm

Weld "F" – Y=8190mm, L=230mm, W=50mm, D=40mm

Weld "F" – Y=3945mm, L=210mm, W=50mm, D=40mm

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

No relevant conversations.

**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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Clifford,William	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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