

**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-027776**Date Inspected:** 15-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**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:** OBG/Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) Rodney Patterson 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:

**OBG 13E Deck Drop-in (Panel Point 123.5)**

The QA inspector periodically observed ABF/JV qualified welder Khit Lounechaney #4985 performing grinding operations for the weld reinforcement of the completed deck drop-in web/flange weld connections designated as 13E-PP123-E2.1-BF2 and 13E-PP123-E2.1-BW1. The QC inspector Salvador Merino was present in order to monitor the progression of work inspecting the weld surface to ensure visual compliance prior to final UT and MT inspection.

**OBG 13E Deck Drop-in (Panel Point 123)**

The QA inspector observed at random intervals ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) in the 2G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1080. The weld is a Complete Joint Penetration (CJP) Tee joint between the horizontal floor beam flange and vertical floor beam flange at panel point 123.5. The weld is designated as 13E-PP123-E2.1-BF2. The weld surface and surrounding area was brought to temperature by the use of a gas torch and the preheat temperature was confirmed by ABF personnel prior to welding. The ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters at the beginning of the shift as seen in the attached photo. The welding at this location was observed to be completed prior to the end of the QA inspectors shift.

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# WELDING INSPECTION REPORT

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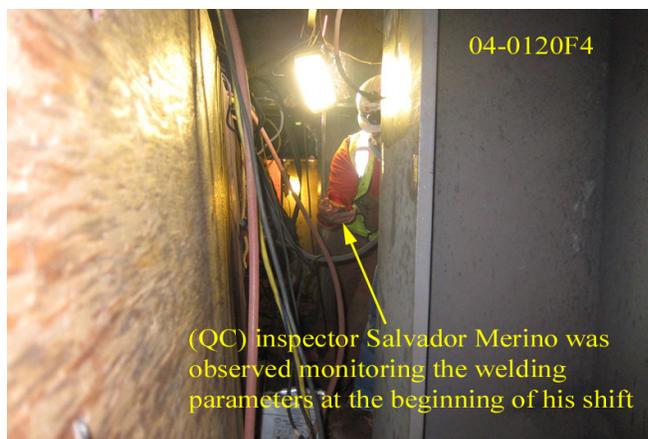
This QA spent a portion of this reviewing and documenting the status and completion of various production welding and NDT tracking logs for lift 13E/14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

The QA inspector periodically observed ABF/JV qualified welder Steve Davis #7889 performing Shielded Metal Arc Welding (SMAW) in the 3G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1030. The welding observed was for the deck panel diaphragm web splice at panel point 122.5. The weld is designated as 13E-PP122-E2.1-BW1. The repair surface and surrounding area was brought to temperature by the use of a gas torch and the preheat temperature was confirmed ABF personnel prior to welding. The Quality Control (QC) inspector Salvador Merino was observed monitoring the welding parameters at the beginning of the shift. The weld was observed to be completed prior to the end of the QA inspectors shift.

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

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**Inspected By:** Patterson,Rodney

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer