

**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-027809**Date Inspected:** 21-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**CWI Name:** Fred Michels**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:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI witnessed work in progress related to Contract Change Order (CCO) 214. The QAI observed that the corner assembly of the bikepath handrail has been fit up and is being welded. The QAI noted that the shielded metal arc welding (SMAW) fillet welding is being performed by Jason Collins, ID 8128. The QAI noted that the Quality Control Inspector (QCI) Fred Michels is monitoring this work. The QAI was informed that the welding procedure specification (WPS) being used is ABF-WPS-D15-F1200A Rev.2. During this shift, the QAI made random observations of the work in progress. The QAI noted that the welding appeared to be within the requirements of the WPS and the work appeared to follow the CCO details. The QAI noted that upon completion of the welding, the welds were not ground smooth as required. The QAI was informed that due to limited access with scaffolding and braces in the way. The QAI was informed that the work will be completed when the area is cleared.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued reviewing submittal 1536R120, R121 and R122 for conformance with the contract requirements. This work was in progress until the end of the shift.

**Summary of Conversations:**

The QAI relayed the status of the document reviews and CCO work to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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# WELDING INSPECTION REPORT

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## 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>	Croff,Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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