

**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 #: 99.28**WELDING INSPECTION REPORT**

**Resident Engineer:** Casey, William  
**Address:** 333 Burma Road  
**City:** Oakland, CA 94607

**Report No:** WIR-027834  
**Date Inspected:** 20-Jun-2012

**Project Name:** SAS Superstructure  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV  
**Contractor:** American Bridge Manufacturing

**OSM Arrival Time:** 600  
**OSM Departure Time:** 1630  
**Location:** Reedsport, OR

**CWI Name:** James Vanek  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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 Gray was at the offsite fabrication facility of American Bridge Manufacturing (ABM) 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 (CCO) 230:

The QAI observed ABM welder Brian Moore ID# B welding in the 2F position with Flux Cored Arc Welding with 100% CO2 Gas Shielding (FCAW-G) utilizing 1.4mm E71T-1C wire electrode. Welding this date is for Suspender Bracket Modifications at the added stiffeners, (reference ABF drawing X451-12A and X451-12B) for fillet weld wrap at ends (Reference RFI ABM-829210-2 and ABF-RFI-002872R00 "Option No. 2") on Suspender Brackets 108W, 108E, 110W and 110E. Quality Control Inspector (QCI) James Vanek was observed monitoring the welding parameters for compliance to WPS ABM-SAS-06. The QAI observed, on further monitoring that the welds were blended by power disc and die grinder to fillet welds previously welded. Welding was in process to the end of the shift. The QAI noted that the workmanship herein appears to be in compliance with approved plans and specifications.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## Summary of Conversations:

Except as noted above 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
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<b>Reviewed By:</b>	Foerder, Mike	QA Reviewer
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