

**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-027844**Date Inspected:** 22-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See 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:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-OBG W13 Drop-In Panel (Observation of welding, QC inspection and testing of panel splices) and Tower, Shear Plates/ESW (Observation of repair welding, QC inspection and testing of ESW Identified as "T" & "V").

Will Clifford-Tower Shear Plates (Observation of repair welding, QC inspection and testing of ESW "V") and OBG W13 Drop-In Panels (Observation of welding, QC inspection and testing of deck field splices).

Doug Frey-Tower, Shear Plates/ESW (Observation of repair welding, QC inspection and testing of ESW Identified as "P" & "V") and OBG E13, Drop-In Panel (Observation of repair and production welding, QC inspection and Testing).

Rodney Patterson-OBG E13 Drop-In Panel (Observation of production welding, QC inspection and testing of structural steel deck beams, deck field splices and tie brackets) and Tower, Shear Plates/ESW (Performed UT of ESW joint "F").

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Matt Daggett-OBG W13 (Observations of welding and QC inspection of deck field splices) and FW Spencer (Observation of welding and QC inspection of mechanical testing).

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

## Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Doug Frey, Rodney Patterson and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted.

## Tower, Shear Plates/ESW, Verification

Later in the shift, this QA Lead Inspector was present for a meeting to discuss the verification of the ABF QC reports for Ultrasonic Testing of the Tower Shear Plate connections. The meeting was conducted by Caltrans Mets personnel Robert Mertz, ASNT Levell III. The purpose of this meeting was to review the documentation and procedural aspects of the verification process. At the request of the contractor the following ESW, with the attached QC/UT reports, were turned over for QA verification and are identified as "F", "H", "R" and "S". These welds were previously tested and accepted by QC technicians utilizing the QAS D1.5-2002, table 6.4 and the contractor's supplemental ultrasonic procedure SE-UT-D1.5-CT-108-ESW. William Clifford and Rodney Patterson were also present during this on-site meeting.

### Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

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

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