

**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-028000  
**Date Inspected:** 18-Jul-2012

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

**OSM Arrival Time:** 630  
**OSM Departure Time:** 1500  
**Location:** Job Site

<b>CWI Name:</b>	Fred Michels	<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>	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 made several attempts to witness welding of welding at Pier 7. The QAI noted that a toe board is being welded onto the tower saddle head plate 15d, per Request For Information (RFI) 2899R0. The QAI noted that this work began yesterday and was not completed. At 7am, the QAI was informed that the welder has been tasked with other duties and it will be several hours before welding resumes. The QAI returned at 2pm and noted that the welding appeared to be completed. The QAI noted that the QCI Fred Michels was tasked with monitoring this work and he was on standby this morning. The QAI observed VTOK marked on the parts and conducted a visual examination of the welds. The welds appeared to be visually conforming to the contract requirements. The QAI was later informed that MT will be performed after the 24 hour requirement. See the attached photo.

The QAI was requested to sample fastener assemblies that have been delivered to the pier 7 staging area. The QAI met with Caltrans Transportation Engineer Bob Brignano and selected a representative sample of the fasteners. The QAI reviewed the supporting documentation for the fasteners. The QAI noted that these fasteners are intended for use with West Jacking Saddle Frame. The QAI completed a TL-102 sampling form with lot number B212-071-12. The QAI noted that these fasteners will be field released upon acceptable verification testing. See the attached photo.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

The QAI relayed the status of the fastener sampling and toe board welding to the QAI Lead Bill Levell. Except as described above, there were no other notable 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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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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