

**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-028025  
**Date Inspected:** 22-Jul-2012

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

**OSM Arrival Time:** 700  
**OSM Departure Time:** 1530  
**Location:** Job Site

<b>CWI Name:</b>	As noted below	<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>	SAS OBG	

**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey 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:

**In Process Visual Inspection**

## 12E-E2.1-C1 (Exterior)

This QA randomly observed ABF/JV qualified welder Chau Tran #3139 performing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040C-CU. The joint being welded was 12E-E2.1-C1. During welding, ABF Quality Control (QC) Fred Michels was noted monitoring the welding parameters.

## 13E-K (Interior)

This QA randomly observed ABF/JV qualified welder Richie Garcia #5892 performing SMAW with 3.2mm diameter E9018H4R electrode and implementing ABF-WPS-D15-1040C-CU. The joint being welded was 13E-SK3. During welding, ABF QC Fred Michels was noted monitoring the welding parameters.

## 12E/13E-LS1 (Interior)

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This QA randomly observed ABF/JV qualified welder Mike Jimenez #3671 performing SMAW with 3.2mm diameter E9018H4R electrode and implementing Caltrans approved Welding Procedure Specification's ABF-WPS-D15-1012-3. The joint being welded was 12E/13E-LS1. During welding, ABF QC Fred Michels was noted monitoring the welding parameters.

## 12E-E2.1 (Interior)

This QA Inspector randomly observed the ongoing Carbon Arc Cutting (CAC) process of the backing bar and the back-gouging from the root side of the joint at 12E-E2.1 on the interior of the OBG. ABF/JV qualified welder Wen Han Yu #6317 was observed continuing the process throughout the shift employing scaffolding to access the locations for cutting and gouging. This QA Inspector observed the welder utilizing the appropriate respiratory apparatus and noted that the work at this location was in progress and appeared to be in general conformance with the contract specifications.

## QC UT (Exterior)

This QA Inspector randomly observed QC Inspector Jesse Cayabyab at 13E PP122.2 at y+3010mm performing Ultrasonic Testing (UT). The QC Inspector was observed scanning from each side of the weld and the scanning pattern as described in D1.5 6.24. The QC Inspectors were noted as identifying a class A rejectable indication 15mm in length at 14mm deep. This QA Inspector noted that the work at these locations is ongoing and appeared to be in general conformance with the contract documents and SE-UT-D1.5-CT-100-Revision 4.

## Summary of Conversations:

Discussed welder assignments and locations with Quality Control Inspector Slavador Merino.



## 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:**      Frey,Doug

Quality Assurance Inspector

**Reviewed By:**      Levell,Bill

QA Reviewer