

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-028054**Date Inspected:** 26-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted 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 and Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford 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**

This QA observed, at random intervals, ABF/JV qualified welder Mike Jiminez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018-MH4-R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. The joint being welded was a 35mm thick internal longitudinal stiffener butt splice designated as LS#1 on the underside of the "A" deck plate, 12E-PP111.1 segment splice location.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters.

This QA randomly observed ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans unapproved Welding Procedure Specification's (WPS) ABF-WPS-D15-1072. The joint being welded was 13E-EK-SK1.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters.

Note: This QA issued a TL-15 Incident Report on this joint dated for 7/23/12. Please Incident Report for pertinent information.

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

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# WELDING INSPECTION REPORT

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Specification's (WPS) ABF-WPS-D15-1040C-CU. The joint being welded was 12E-E2.1C.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters.

## Platform 17E and 21E Dimensional Survey

On 07/25/12 at approximately 8:30 this QA met with Task Leader Bill Levell and Structural Materials Representative Nicolai Hvass. This QA was instructed to do a visual dimensional survey of the embed plate connection to service platforms 17E and 21E. This QA was instructed to record component dimension measurements and submit them to SMR Hvass and SMR Bahjat Dagher.

On 07/26/12 this QA met with Mr. Levell, Mr. Hvass, and Mr. Dagher and received further instruction for this task. This QA was instructed to produce a "to scale" autoCAD drawing to be used in fabrication and testing at an offsite facility.

## Joint Report Status

On 07/25/12 at approximately 10:30 this QA was instructed by Task Leader Bill Levell to gather all QA copies of the Electroslag Weld (ESW) joint survey report forms. Mr. Levell instructed this QA to generate an excel format spreadsheet summarizing all joint QA/QC findings to date. This QA continued working on this assigned task at various intervals throughout the days shift.

## Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 100% of lifting lug removal area at 12E-PP112.5-E2. This area was previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

This QA Inspector tested approximately 300mm of this area.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

## Summary of Conversations:

As noted above.

## 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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Clifford,William	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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