

**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-028168**Date Inspected:** 11-Aug-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:** Salvador Merino**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**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Rodney Patterson 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:

The QA inspector noted and periodically observed ABF/JV qualified welder Jia Yan #1571 performing Shielded Metal Arc Welding (SMAW) in the 3G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1040-A. The welding observed was for the edge plate splice at panel point 121.6 designated as 13E-PP121.6-G. The weld surface and surrounding area was brought to temperature by the use of a gas torch and was confirmed ABF personnel prior to welding.

The QAI observed ABF/JV qualified welder Wai Kitlai #2953 performing Carbon Arc Gouging (CAG) for the repair of the deck panel drop-in splice designated as 13E-PP122.2. The ABF/JV QC inspector Salvador Merino was observed performing magnetic particle testing (MT) in way of the repair excavation at the following locations,  
Y=3610 first time repair,  
Y=4580 second time repair  
Y=4830 second time repair.

The ABF qualified welder was observed later in the shift performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair. The weld and surrounding area was brought to temperature by the use of inductions heaters and maintained throughout welding. The second time repairs at Y=4580 and Y=4830 were performed without the prior approval of the

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engineer. The QA task leader was notified in writing of the non-compliant issue for further discussion with the Caltrans Structural Materials Representative (SMR) and ABF Management.

The QA inspector periodically observed ABF/JV qualified welder Xiao Hua Luo #1291 performing Shielded Metal Arc Welding (SMAW) in the 2G/3G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1040-A. The welding observed was for the web splice at panel point 121. The weld surface and surrounding area was brought to temperature by the use of a gas torch and was confirmed ABF personnel prior to welding.

The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13W/14W and 13E-14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

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

### Summary of Conversations:

No relevant 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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**Inspected By:** Patterson,Rodney

Quality Assurance Inspector

**Reviewed By:** Levell,Bill

QA Reviewer