

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-028299**Date Inspected:** 20-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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 and 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 excavations, repair welding, QC inspection and testing of floor beams and deck splices) and performed QA/VT and MPT verification. There was one(1) issue noted during this shift. See Summary of Conversations.

Rodney Patterson-OBG E13 Drop-In Panel (Observation of excavations, repair welding, QC inspection and testing of the deck field splices) and performed QA/VT, MPT and UT verification at various locations.

Fritz Belford-OBG W12/W13 Corner Drop-In Assembly (Observation of welding, QC inspection and testing of longitudinal beams and floor beams) and OBG W12 Corner Drop-In Ass'y ( Observation of welding, QC inspection and testing of diverter plates).

Matt Daggett-OBG E12 (Observation of welding, QC inspection and testing of deck access hole) and OBG E13 (Observation of welding, QC inspection and testing of floor beams) and QA/MPT verification of K-barrier @ Pier 7.

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William Clifford-Tower Shear Plates/ESW "Q" & "P" (Observation of excavations, repair welding, QC inspection and testing) and performed QA/MPT verification.

Doug Frey-OBG E12/E13 Corner Drop-In Ass'y (Observation of excavations, repair welding, QC inspection and testing of longitudinal stiffener plate splices), OBG E12 Corner Drop-In Plate Ass'y (Observation of welding, QC inspection and testing of deck plate splices), OBG E13 Drop-In Panel (Observation, excavations, repair welding, QC inspection and testing of floor beams) and observation of QC/UT of E12/E13 edge plate..

Rob DeArmand-OBG W13 Drop-In Panel (Observation of excavations, repair welding, production welding of the K-Plate Extension.

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, Rob DeArmand, Rodney Patterson, Fritz Belford, Doug Frey 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 there was one(1)issue noted during this shift.

This QA Lead Inspector commence the review of NDT reports, tracking of welding and developing and generating weld maps for W13 drop-in panels, E12 and W12 corner drop-in assemblies. This QA Lead Inspector also received and reviewed the following Request for Weld Repair (RWR) documents RWR 201208-054, RWR 201208-056 and RWR 201208-055. This QALI also received, via e-mail, an updated SAS Submittal Log.

### **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.

There were also, other pertinent conversations with QA Supervisor, William Levell, throughout the course of this shift in regards to scheduling of QA personnel, work progress and related structural steel and weld issues. There was one significant issue noted during this shift. See below:

### Issue 1

This QALI also was notified by the QA inspector, Joselito Lizardo, that at the weld joint identified as 13W-W2.1, repair cycle #2 will require a contractor's Request for Weld Repair (RWR). This item is noted as a second time repair. The contractor was notified of this issue and elected to commence the excavation and repair welding prior

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to the engineer's approval. At the conclusion of this discussion, this QALI decided that issue warrants an Incident Report (IR) and directed Mr. Lizardo to generate and submit an IR to the QA Task Leader, William Levell, for his review and disposition.

This QALI also met with Assistant Structural Materials Representative (ASMR) Parinaz Aghili to discuss, review the status of the progress of work in regards to the east and west bound OBG's. This meeting was conducted onsite at the Caltrans conex.

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

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