

**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-028507**Date Inspected:** 26-Sep-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:** John Pagliero**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:

**Ultrasonic Testing OBG**

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck access hole longitudinal stiffener connections for lift 13W at E5. The welds were previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

**13W Deck Access Hole Stiffener Splice (Weld No. DAH-13W-PP124.5-W5-LSW)**

The QAI performed a 100% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

**13W Deck Access Hole Stiffener Splice (Weld No. DAH-13W-PP124.5-W5-LSE)**

The QAI performed a 100% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

The QAI observed ABF/JV qualified welder Erick Sparks #3040 performing Carbon Arc Gouging (CAG) for the repair of the deck access hole weld designated as DAH-13W-PP124.5-W5. The ABF/JV QC inspector John Pagliero was observed performing magnetic particle testing (MT) in way of the repair excavations at the following

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locations,

DAH-13W-PP124.5-W5

Y=1180 Depth 11, Width 20mm, Length 170mm

Y=1360 Depth 12, Width 20mm, Length 80mm

The ABF welder Erick Sparks was observed later in the shift performing Shielded Metal Arc Welding (SMAW) in the 1G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair at the locations previously noted. The weld and surrounding area was brought to a temperature of 325°F by the use of a gas torch and maintained throughout the welding process. The weld was then observed to be post heated at 450°F for one hour.

The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 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:

Conversations relevant to the work being performed.



### 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 Gary Thomas (916) 764-6027, 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

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