

**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-028717**Date Inspected:** 05-Nov-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:** Harry Scharein**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:

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck drop-in related welds for lift 13E. 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;

**12W Corner Drop-in Deck Splice (Weld No. 12W-W2.1-A1)**

The QAI performed a total of 20% verification of this weld from Y=13,200~20,000. A total of one (1) rejectable indication was observed at the time of inspection. The rejectable indication was confirmed by ABF QC inspector Harry Scharein on the following shift.

The QAI observed at random intervals ABF welder Richard Clayborn performing fit up operations of the bike path cantilever at panel point 128 on lift 14E. The welder was observed using fit-up gear to level the top plate of the cantilever to the deck at the welded connection. The ABF QC inspector Harry Scharein was seen measuring the offset after fit-up. The QAI confirmed an offset of 3mm in way of the eastern termination of the weld connection. No welding was performed at this location during the shift.

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

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# WELDING INSPECTION REPORT

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**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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<b>Inspected By:</b>	Patterson,Rodney	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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