

**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-028846**Date Inspected:** 10-Dec-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:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey 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 observed the following welders working in the Tower and the OBG at various locations:

ABF welders Xiao Hua Luo #1291 and Gue Wu Chen #1556 were observed performing weld repairs at the shim removal sites of the temporary attachments on the OBG at 5W PP32 and 4W PP28. The welders were observed utilizing WPS ABF-WPS-D1.5-1000-Repair revision 2 for SMAW. The welders were observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above.

FW Spencer welder Damien Llamas # 6645 was observed performing SMAW welding on shear lugs to 2.5 and 4.0 schedule 40 pipe at 8W PP61-W5 on the exterior of the OBG. The welder was observed utilizing WPS FWS-Fillets Murex for SMAW. The welder was observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above.

ABF welder Richard Garcia was observed performing SMAW welding on pad eyes to the existing boom assembly at the tower west chimney. The welder was observed utilizing WPS ABF-D1.5-F1200A for SMAW. The welder was observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above.

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This QA observed QC Inspector William Sherwood and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. This QA also observed QC Inspector's John Pagliero and Bernie Docena performing various Non-Destructive Testing (NDT) on completed weld repairs as they became available for testing. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). QC Inspectors were observed performing inspection per applicable code and or contract criteria.

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

**Summary of Conversations:**

Conversations were relevant to work 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>	Frey,Doug	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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