

**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-028858**Date Inspected:** 05-Dec-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:** S.A.S. Job site**CWI Name:** N / A**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:** S.A.S. Structure**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI began reviewing the contractor's weekly welding report package #134, for conformance with the contract requirements. The QAI continued reviewing Electro-Slag Welding (ESW) reports and referencing the Requests for Weld Repair (RWRs) in order to determine the status of completion of the repairs and welds. This work was in progress until the end of the shift. The QAI completed reviewing submittal 1536R136 and R137. The QAI commented that Electro-Slag welds have additional information that will need to be submitted by the contractor and the submittal was approved as noted. Reference the TL-20 reports for additional information.

The QAI examined the E2-E3 East bound (EB) and West bound (WB) traveler platforms' handrail repair welds, as requested by Caltrans Engineer Rob Kobal. The QAI noted that 2 of the 4 repair welds on the EB platform do not conform with the contract requirements and are visually unacceptable. The QAI relayed this information to Mr. Kobal. The QAI issued a non-conforming incident report regarding the welds. Reference the TL-15IR for additional information. See the attached photos.

The QAI met with the Caltrans Engineer Sebastian Mofor and discussed the bikepath panels that will be placed on the S.A.S. structure at panel point 5-8. The QAI was informed that the contractor wishes to release the panels and associated supporting beams, as they will not be installed on this contract. The QAI made a short survey of the

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

components and noted that significant damage to the finish coating and zinc primer is apparent on all of the parts. The QAI relayed to Mr. Mofor that the contractor will need to repair the coatings prior to release. Mr. Mofor was informed that additional examinations will be performed at a later time.

**Summary of Conversations:**

The QAI relayed the status of the document reviews to the QAI Lead Danny Reyes. Except as described above, there were no other notable 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 Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
----------------------	--------------	-----------------------------

---

<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer
---------------------	--------------	-------------