

**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-029068  
**Date Inspected:** 22-Jan-2013

**Project Name:** SAS Superstructure  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV  
**Contractor:** American Bridge/Fluor Enterprises, a JV

**OSM Arrival Time:** 700  
**OSM Departure Time:** 1730  
**Location:** S.A.S. Job site

<b>CWI Name:</b>	N / A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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 continued reviewing the contractor's submitted 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' overall reported condition. The QAI continued reviewing welding report packages 139, 140 & 141, for contract conformance. This work was in progress at the end of the shift.

At the pier 7 blast booth, the QAI observed Certified Coatings Co. (CCC) personnel preparing to epoxy / sand overlay coat the expansion joint A deck plates A11(2 plates), A10 and A12. The QAI noted that the deck plates have been abrasive blast cleaned and the CCC Quality Control Inspector (QCI) Tony Catrones is measuring the profile and environmental conditions prior to application of the epoxy / sand overlay. The QAI was informed that the steel was ready and the overlay process would begin. The QAI was informed that 2 plates would be coated at a time. The QAI was informed that environmental conditions were: 69° dry bulb, 46% relative humidity, steel temperature 64°. The QAI made additional observations through out the shift and observed Pro-poxy type 3 DOT being applied and #30 silica sand being applied. Upon completion of the applications, the QAI relayed the observations to the QAI Charlie Stewart. The QAIs verified that there are complying environmental conditions for the epoxy / sand overlay. See the attached photos.

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The QAI observed CCC personnel performing surface preparations to repair the finish coating on the traveler platforms that are staged at pier 7. The QAI noted that 2 workers are sanding the surface of the shop applied finish coat and will be touching up the paint at areas previously identified. The QAI made observations of this work throughout the shift and noted that at areas where sanding / touch ups will be performed, there are blue masking tape pieces put in place to assist the workers to identify each area. The QAI was informed by CCC worker Ruben, that a solvent wipe and zinc primer will be applied at each area. The QAI noted that Sherwin Williams Zinc Clad III will be used at these locations. The QAI noted that the batch numbers are B69 A 100 / B69 D 11 / XM 2241LL / 1592. During this shift, the QAI did not observe the mixing or application of the primer.



### Summary of Conversations:

The QAI relayed the status of the document / submittal reviews and the observed paint repairs / overlay work 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.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

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