

**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  
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(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-029520  
**Date Inspected:** 29-Mar-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:** Jobsite

<b>CWI Name:</b>	See Below	<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>	OBG	

**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various Complete Joint Penetration (CJP) groove welds of the East and West Orthotropic Box Girders (OBG's) and fillet welds of Bikepath items. The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

At the start of the shift this QAI observed the following:

This QAI witnessed the Ultrasonic Testing (UT) inspections of the lifting rod closure plate welds at locations EB-SLLH-11, EB-SLLH-12, and EB-SLLH-16 as performed by the AB/F Quality Control (QC) Inspector Bernard Docena. This QAI also performed the UT verification inspections of these same welds. The weld of EB-SLLH-12 was found to contain 1 rejectable indication. The welds of EB-SLLH-16 and EB-SLLH-11 were found to be without rejectable indications. See the attached TL-6027 UT report for details.

This QAI witnessed the Magnetic Particle Testing (MPT) inspections of the Lifting Lug removal areas of the longitudinal stiffeners indicated as EB-SLL-9 and EB-SLL-12 and of the adjacent Lifting Rod closure plate welds EB-SLLH-9, and EB-SLLH-12 performed by AB/F Quality Control (QC) Inspector William Sherwood.

This QAI also performed the MT verification inspection of same welds. See the attached TL-6028 MT report for details.

This QAI witnessed the Magnetic Particle Testing (MPT) inspections of the North Tower elevator attachment lug

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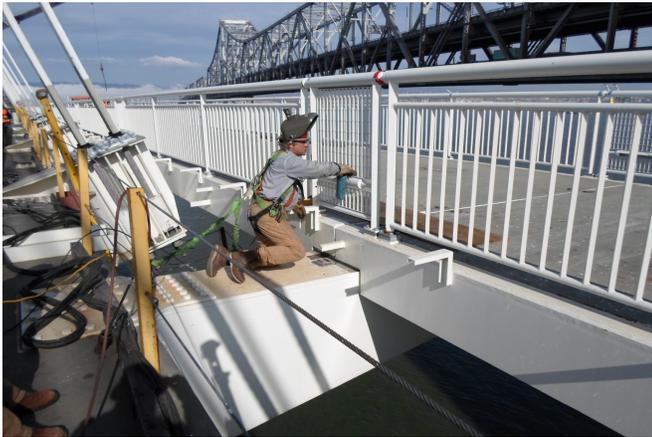
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removal areas at elevations 85M, 87.5M, and 90M (2 lug areas at each elevation) as performed by AB/F Quality Control (QC) Inspector Fred Michels. This QAI also performed the MT verification inspections of these same removal areas. See the attached TL-6028 MT report for details. There were no indications noted at this time. The QC inspection and related work was observed and verified by this QAI which appeared to be in compliance with the contract documents.

This QAI witnessed the Bikepath pipe support brackets welding in process at locations PP9 through PP39 utilizing E7018 electrodes as per WPS-ABF-F1200A by welder Eric Sparks #3040 utilizing E7018 electrodes. This QAI witnessed the Magnetic Particle Testing (MPT) inspections of these welds by the AB/F Quality Control (QC) Inspector Salvador Merino. This QAI also performed the MT and VT verification inspections of these same welds. See the attached TL6028 MT report for details. There were no indications noted at this time. The welding, QC inspection and related work was observed and verified by this QAI which appeared to be in compliance with the contract documents.

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

The digital photographs below illustrate some of the work activities observed on this date:



## Summary of Conversations:

No significant conversations took place.

## 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 SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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**Inspected By:** Morris, Monty

Quality Assurance Inspector

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**Reviewed By:** Reyes,Danny

QA Reviewer