

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
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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-029544  
**Date Inspected:** 09-May-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:** Job Site

<b>CWI Name:</b>	Andrew Keech	<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>	SAS Tower	

**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island 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:

**In Process Visual Inspection**

RWR201304-011

Electroslag Weld (ESW) E-043, "Q"-Face A

The QA Inspector randomly observed ABF/JV welder Chris Bruce (WID-8901) performing welding on a repair excavation on Electroslag Weld (ESW) "Q", at face A. Location of repair was:

Y= (Original) 5475mm

L= 770mm

W= 50mm

D= 60mm

The original defect listed for repair was described in Request for Weld Repair (RWR) 201304-011. The welder was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets at Face B. The welder utilized ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode. The welding parameters were verified by QC Inspector Andrew Keech throughout the day and appeared to be in compliance with the WPS noted above. The welding repair at this location is still in process and approx. 50% complete.

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# WELDING INSPECTION REPORT

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**Summary of Conversations:**

Only general conversations with ABF/JV QC NDT personnel relevant to work performed during this shift.

**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>	Adame,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer

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