

**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-029622**Date Inspected:** 31-May-2013**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:** 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:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford 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:

**In Process Visual Inspection**

RWR-201304-013

This QA observed, at random intervals, ABF/JV welder Donald Plumb #0891 performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1000R-03. Welding was performed on tower Electroslag Weld "ESW" designated as N.

Face A

Y= 6400mm

L= 390mm

W= 60mm

D= 42mm

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters.

This QA observed, at random intervals, an ABF/JV qualified welder, Wai Kit Li #2953, performing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018-MH4-R electrode and implementing Welding Procedure Specification (WPS) ABF-WPS-D15-F1200. Welding was performed on access stairs at the 13M

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# WELDING INSPECTION REPORT

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diaphragm.

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters.

This QA observed, at random intervals, ABF/JV welder apprentice Reggie Humphrey performing carbon arc and mechanical grinding to perform excavation of an electroslag weld for repair. Excavation was performed on tower Electroslag Weld "ESW" designated as T.

Face B

Y= 5000mm

L=1000mm

W= 80mm

D= 60mm

### Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of completed weld excavation on tower ESW "T", face B. This QA observed no rejectable indications at the time of testing. Photographs, dimensions, and testing results have been submitted by QC personnel for approval to begin welding. The completed work observed at this location appeared to be in compliance with the contract specifications.

Y= 5000mm~6000mm

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

### Summary of Conversations:

Conversation was relevant to testing 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>	Clifford,William	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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