

**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-029877  
**Date Inspected:** 15-Jul-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>                   | As noted 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:**

Quality Assurance Inspector (QA) Douglas Frey 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:

FW Spencer welder Tim Esquivel #8348 was observed welding the 2.5" schedule 40, pipe utilizing the Shielded Metal Arc Welding (SMAW) process. The welder was observed utilizing the WPS-1-12-1 to perform the welding and the preheating of the surface area to be welded. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above. This QA Inspector made random observations throughout the shift and noted that the work was completed on this date and appeared to be in general conformance with the contract documents. 70/2.5/129/NW and 1/DW1/128/SW were completed on this date.

**Punch List Item 11063**

This QA Inspector observed ABF/JV welder Earl Clayborn #5070 performing the Shielded Metal Arc Welding (SMAW) process in the 1G flat position on the horizontal stiffener plates of the edge plate at PP98 W2 on the interior of the OBG. The welder had initiated work without the presence of a Quality Control Inspector, no preheat of the joints to be welded, and no approved procedure for the repair. This QA Inspector also noted that the dimensions of the root gaps of the joints were in excess of 10mm. This QA Inspector notified QC Fred Michels who measured the dimensions of the root opening and in conclusion concurs with the QA assessment. The QC inspector informed this QA that a non-conformance report was going to be generated.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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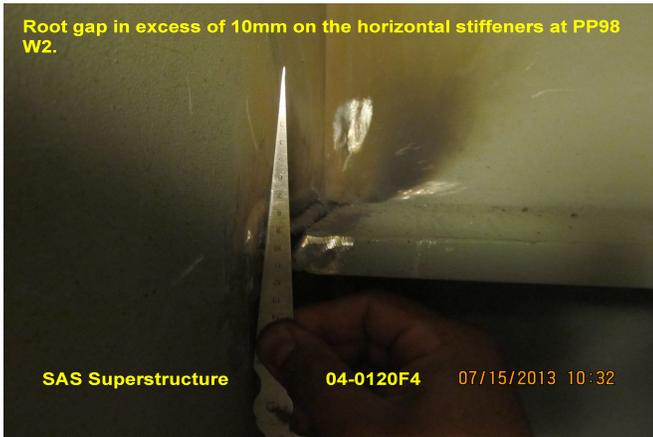
Punch List Item 4003

This QA Inspector observed ABF/JV welder Rick Clayborn performing SMAW repair welding on two (2) gouges on the C plate at PP24 in the absence of QC, no preheat of the area to be welded and an approved written procedure. This QA Inspector notified QC Inspector Fred Michels who submitted an RWR. This QA Inspector generated a TL-15 on this date.

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

## Summary of Conversations:

Conversations on this date were relevant to work performed.



## 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:** Frey,Doug Quality Assurance Inspector

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**Reviewed By:** Reyes,Danny QA Reviewer