

**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  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012773**Date Inspected:** 23-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Jesus Cayabyab**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:** Orthotropic Box Girder**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

This QA arrived at Pier 7, Site Office at 0800 to attend Confined Space Safety Training scheduled at 0900. While waiting for the Safety Training, this QA updated inspection reports that were previously performed. At 0900, QAI went to Caltrans SAS Burma Office Conference room and attended the Safety Training presided by Caltrans Senior Transportation Safety Officer Mr. Bob Ambhule. The training lasted for around four hours and after getting the Confined Space Safety Training sticker, this QA proceeded to the job site at around 1330 hours.

At the job site, QAI had noted ABF/JV welder Jordan Hazelar (I.D. 2135) performed the horizontal (2F) fillet welding of the backing bar to one side of the deck plate at L3E/L4E 'A'. The welder was using shielded metal arc welding (SMAW) with 1/8" E7018 H4R electrode implementing Welding Procedure Specification (WPS) ABF-D15-F1200A. During welding, the welder was noted preheating the plates prior welding and ABF QC Jesus Cayabyab was also noted monitoring the welding parameters.

QAI also noted ABF personnel perform gouging of backing bar at L2E/L3E plate 'D' using the track mounted plasma arc machine and grinding of back gouged backing bar at L1E/L2E plate 'D'. There were no untoward incidents noted during the two operations just mentioned.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



## Summary of Conversations:

As stated above.

## 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 Mohammad Fatemi (916) 227-5298, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

---

**Reviewed By:** Levell, Bill

QA Reviewer