

**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-026598**Date Inspected:** 28-Oct-2011**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

<b>CWI Name:</b>	Jesse Cayabyab and Salvador Merino			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	SAS OBG		

**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.

At OBG 11W-PP100-W4-# 4 lifting lug hole infill plate to top deck plate outside, ABF welder Jorge Lopez was observed 1G SMAW welding root pass to cover pass on the infill plate to top deck plate butt joint. The welder was noted using 5/32" diameter E7018H4R electrode implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1070. Prior welding, ABF QC Salvador Merino was observed inspecting the fit up of the butt joints. QA verified the fit up alignment of the lifting lug hole which deemed acceptable to the contract requirements. During welding, ABF QC Salvador Merino was noted monitoring the welder's welding parameters with measured working current of 168 amperes. At the end of the shift, cover pass welding on the top side location of the butt joint was completed.

At the East/West bound side of the OBG, ABF welder Rick Clayborn was observed 2F fillet welding on the cat walk storm tie at various locations. Welder Rick Clayborn was noted utilizing self shielded Flux Cored Arc Welding (FCAW-S) with 1.8mm diameter E71T-8 wire electrode implementing (WPS) ABF-WPS-D15-F2200-2. During the shift, ABF QC Jesse Cayabyab was noted monitoring the parameters of the welder with measured welding parameters of 310 amperes and 22.6 volts. At the end of the shift, fillet welding of 6mm x 300mm long on both sides of the plate welded to the top of deck plate was completed at the following locations;

Panel Point Location OBG Remarks

# WELDING INSPECTION REPORT

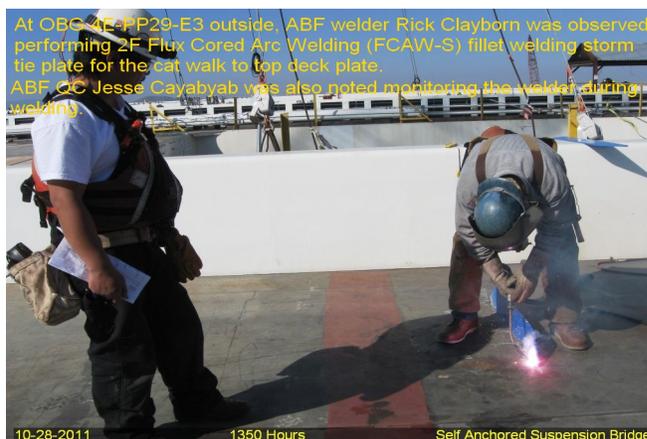
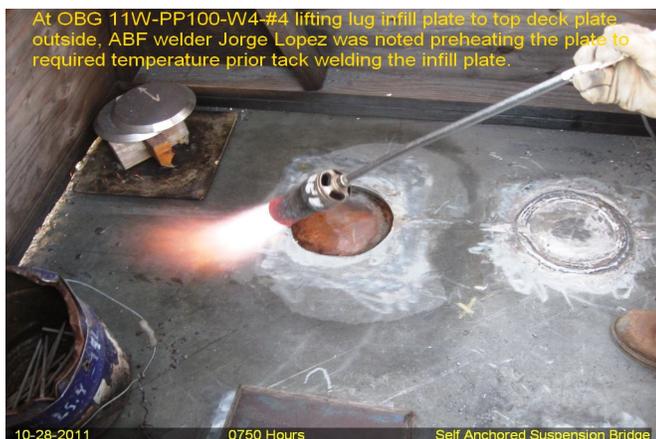
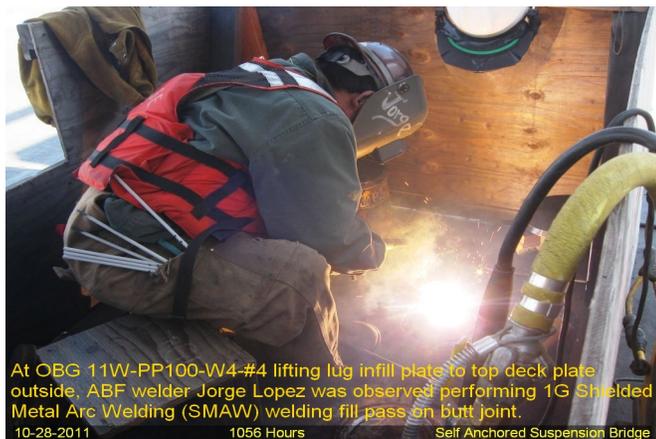
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1. 4E-PP29-E5 Inboard East Bound Completed
2. 4E-PP30-E5 Inboard East Bound Completed
3. 4W-PP29-W5 Inboard West Bound Completed
4. 4W-PP30-W5 Inboard West Bound Completed

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT of four (4) lifting lug holes infill plate to top deck plate. The QA verification was performed to verify that the welding and the VT/MT inspection performed by the QC inspector meet the requirements of the contract documents. At the conclusion of the QA verification it appeared that the weld and the QC inspection complied with the contract documents.

## Lifting Lug Hole Location      Remarks

1. 11E-PP100-E3-#1 & 2    QA VT/MT acceptable
2. 11E-PP104-E3-#1 & 2    QA VT/MT acceptable



## Summary of Conversations:

No significant conversation occurred today.

## 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

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## WELDING INSPECTION REPORT

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remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lizardo,Josecito	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell,Bill	QA Reviewer
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