

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026599**Date Inspected:** 29-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

CWI Name:	Jesse Cayabyab and Salvador Merino			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:	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-# 2 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 175 amperes. At the end of the shift, cover pass welding on the top side location of the butt joint was completed.

After the welding completion of the lifting lug hole at 11W-PP100-W4-# 2, the welder has moved to 11W-PP101-W4-# 1 and performed fit up of the infill plate to the top deck plate. The fit up alignment was checked by ABF QC Salvador Merino and verified by this QA with positive result. The welder started preheating the plates as soon as the alignment was accepted and started welding the root pass with the same process mentioned above. Fill pass welding has continued until the end of the shift without completing the butt joint.

At Cross Beam #1 outside, ABF welder Erick Sparks was observed 2F fillet welding Service Platform Stair attachment tabs to Cross Beam #1 side plate. The welder was noted using 1/8" diameter E7018H4R electrode

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

implementing Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. The tabs being welded are replacements to the old tabs that were welded in ZPMC China due to wrong hole pattern. This work is also being done per Request for Information (RFI) ABF-RFI-002417R00 dated 19 April 2011. During welding, ABF QC Jesse Cayabyab was observed monitoring the welder with measured working current of 130 amperes. During the shift, fillet welding of the two attachment tabs for stair service platform was completed.



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

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
