

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-026607**Date Inspected:** 01-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** John Pagliero**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 Cross Beam #17 outside, ABF welder Salvador Sandoval was observed continuing to work on the stair attachment tabs to the side of the Cross Beam and placement of the North and South stairs of the Service Platform. The tabs were removed due to wrong bolt holes orientation and the stairs placements are being done per Request for Information (RFI) ABF-RFI-002417R00 dated 19 April 2011. The welder has completed carbon arcing and grinding smooth the North and South sides stair attachment tabs and the removal was tested by Salvador Merino using Magnetic Particle Testing (MT). The welder has started fillet welding the North side stair attachment tabs and completed them during the shift. According to the welder, he is awaiting the other two attachment tab plates (6" x 6" x 9/16" thick plates) for the South stairs.

During the shift, this QA continued observations at the welding of the lifting lug hole after fellow QA Doug Frey left early during the day. At OBG 11W-PP101-W4-# 2 lifting lug hole infill plate to top deck plate outside, ABF welder Jorge Lopez was observed continuing to perform 1G SMAW welding fill 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. During welding, ABF QC John Pagliero was noted monitoring the welder's welding parameters with measured working current of 185 amperes. During the shift, cover pass welding on the top side location of the butt joint was completed.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

During the shift, this QA continued observations at the welding of the lifting lug hole after fellow QA Doug Frey left early during the day. At OBG 11W-PP100-W3-# 2 lifting lug hole infill plate to top deck plate outside, ABF welder Mike Jimenez was observed continuing to perform 1G SMAW welding fill pass to cover pass on the infill plate to top deck plate butt joint. The welder was noted using 3/16" diameter E7018H4R electrode implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1070. During welding, ABF QC John Pagliero was noted monitoring the welder's welding parameters with measured working current of 270 amperes. During the shift, fill pass welding on the top side location of the butt joint 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
