

**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-026608**Date Inspected:** 31-Oct-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:** 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-PP101-W4-# 1 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. 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 190 amperes. During 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-PP101-W4-# 1, the welder has moved to 11W-PP101-W4-# 3 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 OBG 11W-PP100-W3-# 1 lifting lug hole infill plate to top deck plate outside, ABF welder Mike Jimenez was observed performing 1G SMAW welding root pass to fill pass on the infill plate to top deck plate butt joint. The

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# WELDING INSPECTION REPORT

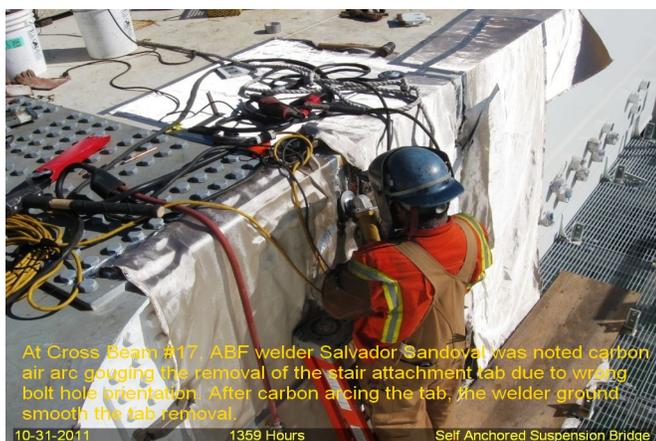
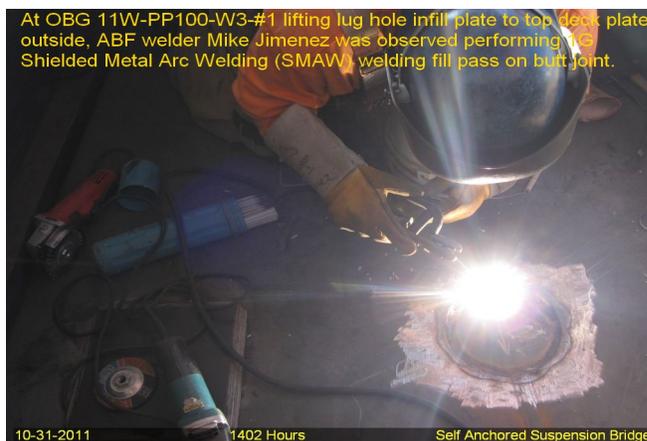
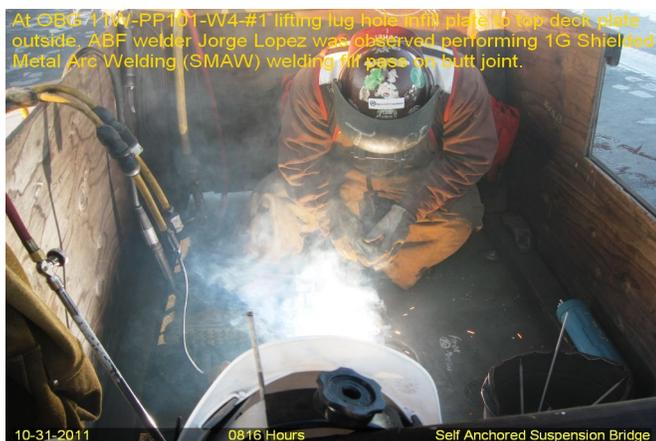
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welder was noted using 1/8" diameter E7018H4R electrode implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1070. Prior welding, ABF QC Salvador Merino was observed inspecting the fit up of the butt joints. QA verified the fit up alignment 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 130 amperes. During the shift, fill pass welding on the top side location of the butt joint was completed.

At Cross Beam #17 outside, ABF welder Salvador Sandoval was observed removing the stair attachment tabs to the side of the Cross Beam using carbon air gouging followed by disc grinding. The tabs are being removed due to wrong bolt holes orientation and per Request for Information (RFI) ABF-RFI-002417R00 dated 19 April 2011. The welder has completed carbon arcing and grinding smooth the North side stair attachment tabs while the South side is still in progress.



## 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.

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# WELDING INSPECTION REPORT

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