

**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-026636**Date Inspected:** 02-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:** Steve Jensen**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 #1 outside, ABF welders Erick Sparks and Todd Jackson were observed continuing to work on the stair treads modification due to wrong step to step distance (stair tread distance). ABF personnel have noted the stair treads that was fabricated in ZPMC China were having more than 11 inches step to step distance contrary to the contract requirement of 235mm (9 1/4 inches). The welders have removed the welded steps then ground smooth the removal and rewelded back to the required 235mm step to step distance. During fillet welding of the treads, ABF QC Steve Jensen was noted monitoring the welders. At the end of the shift, rewelding of the stair steps was still continuing and should remain tomorrow.

This QAI performed a review of various listed weld joints generated by the Quality Assurance Lead Inspector (QALI), Daniel Reyes. The list was in regards to open Magnetic Particle Test (MPT) Reports. At conclusion of the survey this QAI reported to the QALI that the testing (QA Verification) was completed but there were areas marked by this QAI regarding minor weld profile grinding to be completed. The profile grinding has been completed which resolves these minor issues. For additional information, see the QAI TL-6028 generated on this date. The survey was not completed during this shift.

**Summary of Conversations:**

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# WELDING INSPECTION REPORT

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

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