

**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-028406**Date Inspected:** 14-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**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 12E/13E-LS2 deck stiffener flange inside, QA randomly observed ABF/JV qualified welders Wai Kit Lai and Jose Torres continuing to perform production PJP groove welding cover pass on the 485W deck stiffener flange Partial Joint Penetration (PJP) T-joint. The welders were observed perform manual welding in the 4G (overhead) position utilizing a Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E9018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1162-4 rev. 0. The stiffener flange plate has a 45 degree bevel groove that is being welded PJP T-joint to the 485W longitudinal stiffener. The plates were preheated to more than 200 degree Fahrenheit using Miller Proheat 35 Induction Heating System. During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters of the welder with measured working current of 126 and 135 amperes respectively on the welders mentioned. At the end of the shift, cover pass welding was completed on the two wing plates of LS2 and the welders held the same preheat of >200 degree Fahrenheit for three hours after welding as required.

At OBG 12E-PP116.5-E2.1-BW1 corner drop-in floor beam, QA randomly observed ABF certified welder Gue Wu Chen continuing to perform 3G (vertical position) Shielded Metal Arc Welding (SMAW) back welding fill pass to cover pass on the CJP web splice butt joint. The welder was utilizing 3.2mm diameter E7018H4R on the root pass implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040A Rev. 0. The joint being welded has a single V-groove butt joint that was welded from one side with ceramic backing then

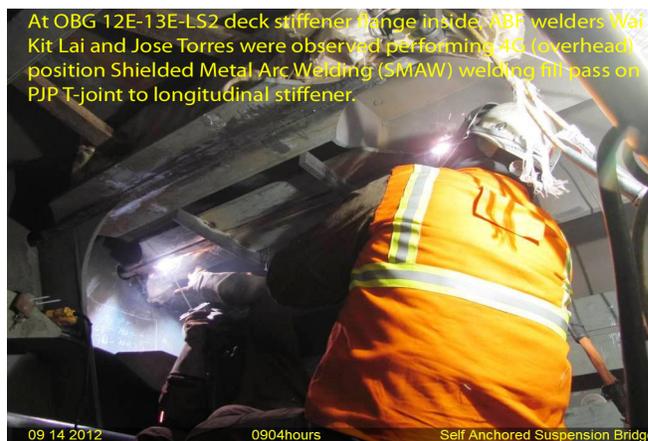
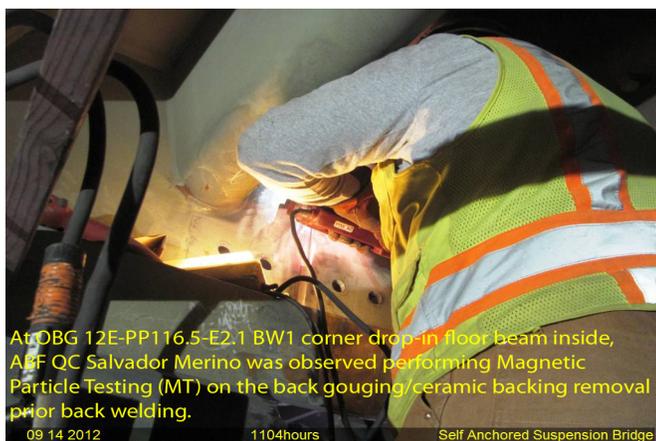
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removed and back gouged and being back welded. The plates were preheated to more than 150 degree Fahrenheit using propylene gas torch prior welding. Welding parameters were monitored by ABF/QC Salvador Merino. QA noted the welding working parameter of 125 amperes on the 3.2 diameter E7018H4R electrode. The workmanship and appearance of the completed cover pass deemed satisfactory. During the shift, cover pass back welding was completed and the welder started flush grinding in preparation for inspection.

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT on the OBG longitudinal stiffener CJP field splice butt joints. 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 welds and the QC inspection complied with the contract documents.

1. 12E-13E-LS2 longitudinal stiffener inside - splice butt joint weld cover QA verified.
2. 12W-PP111.1-W2 LS3 longitudinal stiffener inside - splice butt joint weld cover QA verified.



## 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 Gary Thomas (916) 764-6027, who represents the Office of Structural

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Materials for your project.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

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**Reviewed By:** Levell, Bill

QA Reviewer