

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-028419**Date Inspected:** 18-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 and Fred Michel			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 13E-E2.1-@9500 drop-in top deck plate inside, QA randomly observed ABF/JV qualified welder Mike Jimenez continuing to perform CJP groove welding repair at location Y=3200mm. The repair was having a boat shape excavation profile of 70mm long x 25mm wide x 10mm deep. The welder was observed manually welding in the 4G (overhead) position utilizing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing Caltrans approved welding procedure ABF-WPS-D15-1004-Repair. The repair has been excavated and being welded per Caltrans approved Request for Weld Repair (RWR) #201209-090. The repair excavation was preheated to more than 225 degree Fahrenheit using propylene gas torch. After the completion of excavation and removal MT verification from ABF QC Salvador Merino and this QA, the welder pumped up the preheat to more than 325°F using the same torch during welding. ABF QC Salvador Merino was noted monitoring the welder with measured working current of 130 amperes. During the shift, repair welding at location mentioned above was completed and the welder has moved to another location OBG 13E-E2.4-@2600 Y=160mm with Caltrans approval per RWR #201209-092. The boat shape repair excavation has profile of 90mm long x 35mm wide x 13mm deep and welded from the inside then moved to the top side and excavated having profile of 85mm long x 25mm wide x 8mm deep and welded. The welder followed the same steps and procedure mentioned above in completing the weld repair.

At OBG 6E location Panel Point PP31 to PP33 grid line E5, this QA randomly observed FW Spencer qualified

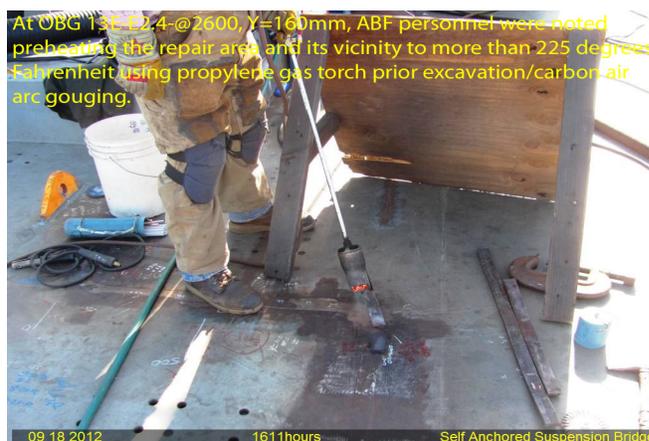
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welder Damian Llanos perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on the field splice butt joint of 2.5" and 4" domestic water and compressed air lines respectively. The system lines being welded are field weld joints along the grid line of E5 of the OBG. The welder was noted welding the root pass with 3/32" diameter E6010 electrode and followed by fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing Caltrans approved procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable propane gas torch prior welding. During welding, ABF QC Fred Michels was noted monitoring the parameters of the welder. At the end of the shift, the welder has completed the welding of the field splice butt joints at the following;

Line Service Line/Pipe Size Panel Point Location Joint Designation

1 Domestic Water	2 ½"	31 Northeast	15.5/2.5/31/NE
2 Compressed Air	4"	33 Northeast	15.5/4/33/NE
3 Domestic Water	2 ½"	33 Northeast	16/2.5/33/NE
4 Compressed Air	4"	33 Northeast	15.5/4/33/NE



Summary of Conversations:

No significant conversation occurred today.

Comments

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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 Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
