

**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-028570**Date Inspected:** 12-Oct-2012**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

<b>CWI Name:</b>	Salvador Merino and Barry Drake			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	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 Tower elevation 119 meter, this QA randomly observed ABF/JV qualified welder Richard Garcia continuing to perform 2G (horizontal) position Partial Joint Penetration (PJP) welding 6mm bent plate butt joint per Request for Information ABF-RFI-002642R01 dated December 6, 2011. The RFI pertains to the modification of the Tower Lift 4 Façade Seal Elevator interference. The welder was noted implementing the Option #3 and detail #3 of the RFI's attachment.

During welding, the welder was observed manually welding in 2G (horizontal) position utilizing self-shielded Flux Cored Arc Welding (FCAW-S) with 0.035" diameter E71T-11 wire electrode implementing Caltrans approved welding procedure ABF-WPS-D11-2044. ABF QC Barry Drake was noted on site monitoring the welder and his welding parameters with measured working current of 80 amperes and 16 volts. At the end of the shift, two bent plates modification were done at north and west shafts of the Tower at elevation 119 meter. The remaining modification of the same bent plates at higher elevation will continue tomorrow.

FW Spencer:

As for FW Spencer, there was no welding activity performed by the welder today. FW Spencer personnel were noted continuing laying pipes at the west bound of the bridge along the W2 grid line.

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# WELDING INSPECTION REPORT

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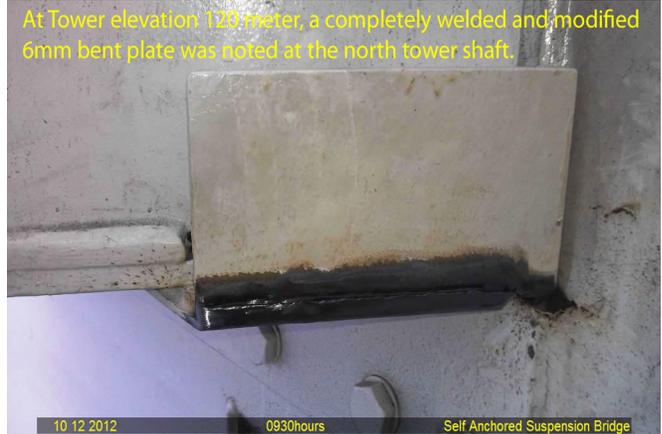
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At Tower elevation 129 meter, a completely welded and modified 6mm bent plate was noted at the west tower shaft.



10 12 2012 0931hours Self Anchored Suspension Bridge

At Tower elevation 129 meter, a completely welded and modified 6mm bent plate was noted at the north tower shaft.



10 12 2012 0930hours Self Anchored Suspension Bridge

## 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 Materials for your project.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

**Reviewed By:** Reyes, Danny

QA Reviewer