

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-028735**Date Inspected:** 12-Nov-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

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|------------------------------------|--------------------------------|-----------|------------|----------------------------------|------------|-----------|------------|
| CWI Name: | Bernie Docena and 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 Tower elevation 155 meters, QA randomly observed ABF welder Richard Garcia continuing to perform seal welding between the Tower head cover and tower side cover. The welder was noted welding in seal welding utilizing self-shielded Flux Cored Arc Welding (FCAW-S) with 0.072" diameter E71T-8 wire electrode implementing Caltrans Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2. Prior seal welding, the paint coating on both sides of the joint was ground off and the plates were preheated to more than 150 degrees Fahrenheit. During the shift, QA noted ABF QC Bernie Docena was on site monitoring the in process preheats and welding parameters with measured working current of 340 amperes and voltage of 23 volts. At the end of the shift, seal welding of the Tower head cover to Tower west side between the Tower shafts West and South was still continuing and should remain tomorrow.

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT on the Tower Head cover to chimney fillet weld joints and seal weld of East side plate to tower head cover. 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.

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1. Tower elev. 155M – East shaft west side fillet joint weld cover QA verified
2. Tower elev. 155M – South shaft east side fillet joint weld cover QA verified
3. Tower elev. 155M – East side between North and East shafts seal weld joint cover QA verified

FW Spenser:

The QAI observe the ongoing installation, field fit-up and tack welding of the utility pipe support lug 5” long x 1” wide x 3/8” thick along the W2 grid line (panel point PP111). The lug pipe support was fillet welded on both sides of the 2 ½” diameter domestic water line and 4” diameter compressed air line. The QC inspection was performed by Steve Jensen utilizing the Welding Procedure Specification (WPS) identified as Fillet Murex to monitor the tack welding and fillet welding to verify the welding parameters. The welding parameters were observed and recorded as 88 amps utilizing 2.4 mm electrodes with the welding performed in the 2F position. The tack welding/fillet welding was performed and completed by FW Spenser welder Damian Llanos. At the end of the shift, two (2) support lugs welded on each line were completed.



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

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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,Josecito | Quality Assurance Inspector |
| Reviewed By: | Reyes,Danny | QA Reviewer |
