

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-028814**Date Inspected:** 16-Nov-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Salvador Merino 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 OBG 13W-PP22-PP24-W2.2 drop-in floor beam inside, QA randomly observed ABF/JV welder Ric Chouinard perform CJP groove welding surface repair due to various surface defects. The welder was observed welding in various positions utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1001-Repairs. The surface repairs were preheated to more than 150 degree Fahrenheit using propane gas torch prior welding. During the shift, ABF QC Fred Michels was noted monitoring the welder. These surface repairs were noted after ABF QC has turned them over to QA and these were rejected due to surface defects. At the end of the shift, surface welding repair was still continuing and should remain tomorrow.

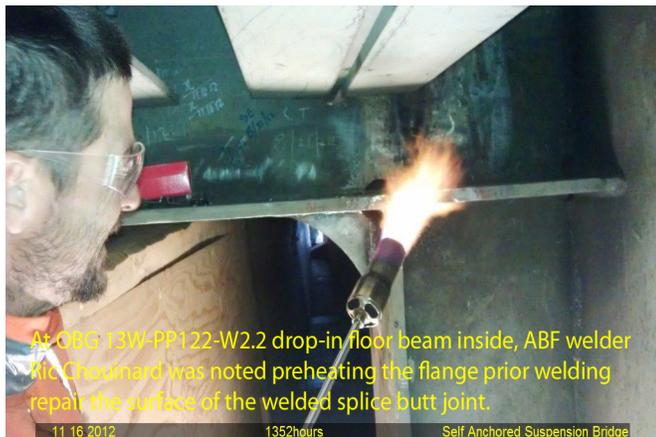
FW Spencer:

At OBG location panel point PP17.5 to PP20.5, this QA randomly observed FW Spencer welder Damian Llanos continuing to perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on 1" weldolet to 2 1/2" diameter domestic water line field branch joints. The welder was noted welding the branch joints on 2" diameter weldolet to 4" diameter compressed air line. 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 procedure FW Spencer WPS 1-12-1. The

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

welder was noted preheating and removing the moisture of the joint using a portable propylene gas torch prior welding. During welding, ABF QC Steve Jensen was noted monitoring the parameters of the welder. At the end of the FW Spencer shift, CJP welding on four (4) 1" diameter weldolet to 2 1/2" diameter domestic water line pipe joints were still in progress at the joint designated joints; 1/CA2/17.5/BP-E, 1/CA2/18.5/BP-E, 1/CA2/19.5/BP-E and 1/CA2/20.5/BP-E.



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.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer
