

**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-028943**Date Inspected:** 02-Jan-2013**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**CWI Name:** William Sherwood**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 Tower and 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-W2.8-@12570mm drop-in top deck plate inside, ABF welder Mike Jimenez was observed continuing to perform repair welding on Seismic Performance Critical Member (SPCM) per approved Request for Weld repair (RWR) #201212-043. Prior to perform the repair, ABF QC William Sherwood was noted performing the Magnetic Particle Testing (MT) on the defect removal with no relevant defects noted during the test. The repair location was at Y=6220mm and having excavation dimensions of 100mm long x 22mm wide x 12mm deep. After the completion of the MT, welder Mike Jimenez was observed welding in the 4G (overhead) position utilizing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1004-Repairs. The welder preheated the repair area to more than 325°F prior welding using propylene gas torch. During the shift, the welder completed the repair mentioned above and then performed the Post Weld Heat Treatment (PWHT) of more than 450°F for one hour after welding as required.

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT on the Bike Path cantilever flush ground previously welded T- joint. 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.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

1. Bike Path cantilever panel point PP121 – flush ground welded T- joint cover QA verified.

FW Spencer:

This QA randomly observed FW Spencer Damian Llanos perform seal welding on the four (4) bolt holes on every pipe support PS3s that are intended for bike path cantilever beams. The welder was noted seal welding the bolt holes using Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode per Request for Information (RFI) ABF-RFI-003139 Rev. 00. During the shift, ABF QC Salvador Merino was noted monitoring the welder. At the end of the shift, seal welding on the PS3 supports was still continuing and should remain tomorrow.



## 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.

---

---

## WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

**Reviewed By:** Reyes, Danny

QA Reviewer