

**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-028986**Date Inspected:** 14-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**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 Base Electro Slag Weld (ESW) 'Q' weld joint #E-043 face A, ABF welder Cris Bruce was observed perform 2G/3G welding repair on the weld cover on previously welded ESW. The welder was noted utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing ABF-WPS-D15-1000 Repair Rev.3. The surface of the areas that were welded was ground smooth and then tested by ABF QC William Sherwood using Magnetic Particle Testing (MT) with no relevant indications noted. This QA also performed the same test and noted same result. Prior welding, ABF personnel have preheated the repair area to more than 300°F using propylene gas torch. During the shift, the ABF QC William Sherwood was noted monitoring the welding parameters and workmanship of the repairs being welded.

The following were the locations and dimensions where repairs were performed;

1. Y=9270mm 110mm long x 14mm wide x 5mm deep (horizontal excavation/temporary attachment removal).
2. Y=9120mm 140mm long x 17mm wide x 10mm deep (vertical on weld zone)
3. Y=8790mm 300mm long x 17mm wide x 11mm deep (vertical on weld zone)
4. Y=5620mm 200mm long x 11mm wide x 7mm deep (vertical on weld zone)
5. Y=5330mm 140mm long x 10mm wide x 2mm deep (horizontal excavation/temporary attachment removal)
6. Y=7880mm 140mm long x 8mm wide x 5mm deep (horizontal excavation/temporary attachment removal)

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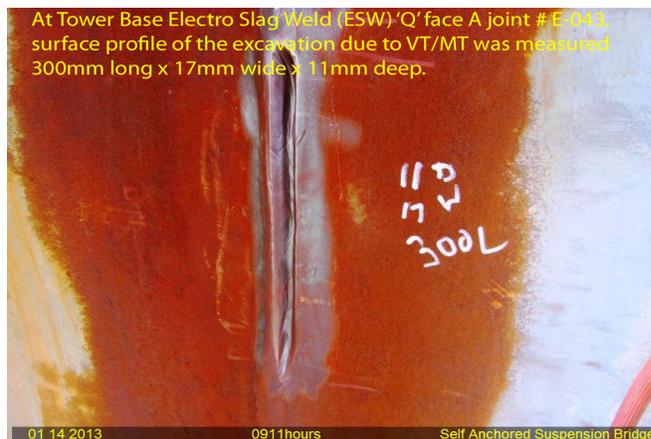
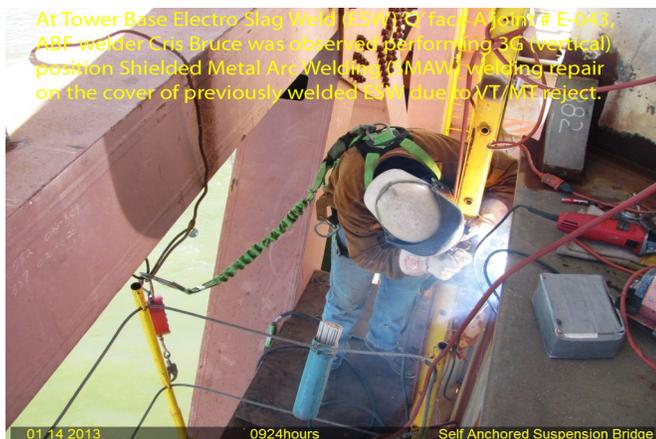
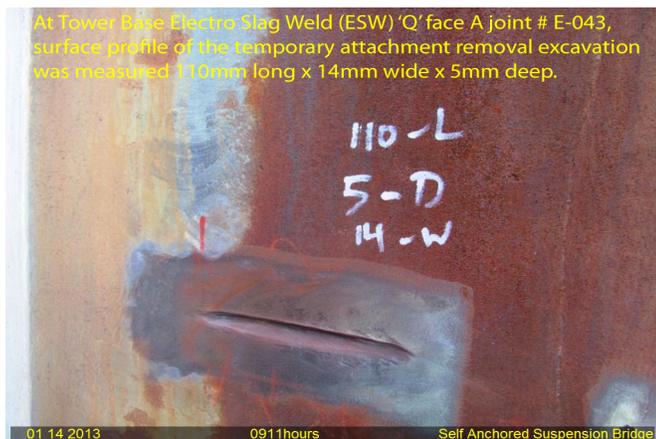
# WELDING INSPECTION REPORT

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After the repair completion on the cover of the ESW at 'Q' face A mentioned above, the welder has moved to ESW 'P' and 'Q' face A and set-up their equipment and tools for their next welding repair. ABF personnel have started grinding the areas that need to be repaired. ABF QC William Sherwood performed the Magnetic Particle Testing (MT) on these areas with no relevant indications noted.



## 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

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**Reviewed By:** Reyes, Danny

QA Reviewer