

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-029197**Date Inspected:** 01-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Fred Michels**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 the W2 Bent Cap, located at west end between the east and west bound OBG, this QA randomly observed ABF/JV qualified welder Richard Garcia perform the Partial Joint Penetration (PJP) welding of the 8" C-channel to a 3" x 5" angle brace connection. The welder was observed using 1/8" diameter E7018H4R electrode. The Dehumidification Platform is being assembled and installed per the Request for Information (RFI) #001249R02 and ZPMC drawing OBG E3050. During welding, ABF QC Fred Michels was noted monitoring the welding parameters of the welder which measured 142 amperes. Prior to welding, the welder was noted beveling one side of the joint to 45 degree to a depth of preparation of 8mm deep by 10 inches long. After beveling all four (4) connections marked SA6028F, SA6028G, SA6028H and SA6028J using the disc grinder, the welder started the PJP welding. The welder was noted performing welding and at the same time with the help of other ABF personnel, they were assembling the platform. At the end of the shift, two of the PJP connections were completed.

WELDING INSPECTION REPORT

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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