

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-029199**Date Inspected:** 21-Feb-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**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**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 Skyway East Bound alignment lifting lug hole number 3, this QA randomly observed ABF welder Mike Jimenez perform 1G Shielded Metal Arc Welding (SMAW) welding repair on welded Complete Joint Penetration butt joint. The welder was noted using 1/8" diameter E7018H4R electrode implementing the Welding Procedure Specification (WPS) ABF-WPS-D15-1001 Repair. During welding, ABF QC Salvador Marino was noted monitoring the welding parameters. The location of the two repair excavations were at Y=166mm having excavation dimensions of 85mm long x 20mm wide x 12mm deep and at Y=439mm having excavation dimensions of 85mm long x 20mm wide x 14mm deep. Prior repair welding, the welder was noted preheating the 25mm thick plate repairs to 150 degrees Fahrenheit using propylene gas torch. The welding parameters were noted as 135 amperes which appeared to be in compliance of the contract requirements. The repair welding of the excavations were completed during this shift.

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 2 of 2)

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
----------------------	-------------------	-----------------------------

Reviewed By:	Reyes, Danny	QA Reviewer
---------------------	--------------	-------------
