

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-029289**Date Inspected:** 13-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:	Bonifacio Daquinag and 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 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 12W-PP116.5-W2 deck access hole outside, QA randomly observed ABF/JV qualified welder Cris Bruce continuing to perform fill pass welding on the Complete Joint Penetration (CJP) butt joint. The welder was observed manually welding in the 1G (flat) position utilizing a Shielded Metal Arc Welding (SMAW) with 5/32" diameter E7018H4R electrode and implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1040C. The joint being welded has a single-V-groove butt joint welded with steel backing bar. ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. QA randomly monitored the welding parameter with reading of 170 amperes which appears in conformance to the contract requirements. At the end of the shift, SMAW fill pass welding was still continuing and should remain tomorrow.

At OBG 12E-PP116.5-E2 deck access hole (DAH) outside, QA randomly observed ABF welder Mike Jimenez perform the fit up on the DAH plate to deck plate. The welder was noted aligning the plate to the deck plate using U-bar with bull pen. After the completion of the fit up, this QA together with ABF QC Bonifacio Daquinag performed inspection and verification on the fit up. The alignment between the plate and deck plate measured was approximately 1.5mm and appears to comply with the specifications. The maximum root opening was measured and was noted as 24.5mm and appeared to exceed the allowable per the contract specifications. At this time the backing bar was still in the fit-up and tack weld process. The backing plate that was being installed was not continuous and that it will also be unacceptable to the specification.

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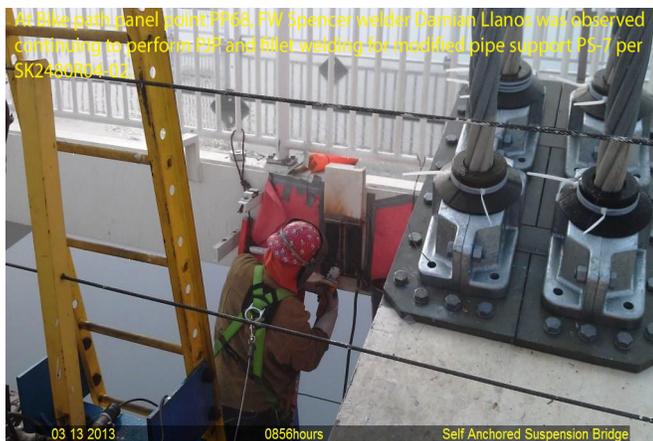
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At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT on temporary welded lifting lug removal mentioned below. The QA verification was performed to verify that the VT/MT inspection performed by the QC inspector meet the requirements of the contract documents. At the conclusion of the QA verification it appeared that the ground removal of the lifting lugs and the QC inspection complied with the contract documents.

1. L13E-PP122.65-E4 North – OBG lifting lug (pyramid) removal QA verified
2. L13E-PP121.65-E4 North – OBG lifting lug (pyramid) removal QA verified
3. L13E-PP124.65-E4 North – OBG lifting lug (pyramid) removal QA verified
4. Bike Path PP15.5 – 2 lifting lug removal QA verified.
5. Bike Path PP16.5 – 2 lifting lug removal QA verified.

FW Spencer:

At Bikepath 'E' panel point PP68, this QA randomly observed FW Spencer qualified welder Damian Llanos continuing to perform PJP and fillet welding on pipe support PS-7 per SK2480 R04-02. The welder was noted PJP welding 5mm and 8mm deep penetration and 6mm fillet welding per modified pipe support detail just mentioned. The welder was noted using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode. During the shift, ABF QC Fred Michels was noted monitoring the welders' welding parameters and workmanship of the pipe support joint being welded. At the end of the shift, PJP and fillet welding of the PS-7 pipe support was completed.



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

Reviewed By: Reyes, Danny

QA Reviewer