

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-029320**Date Inspected:** 16-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 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 13W-PP124-PP127-W2 top deck plate diverter bar, QA observed ABF welders Lin E. Yun and Guo Wu Chen perform the fillet welding on 2 1/4" wide x 3/8" thick diverter bar to the deck plate. The welders were welding in 2F (horizontal position) using 1/8" diameter E7018H4R electrode as per the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. The diverter bar was originally fillet welded both on sides of the bar to the deck plate but was removed using carbon arc and ground smooth due to interference with the safety bridge railing. During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welders. At the end of the shift, the fillet welding was not completed and will continue on the next scheduled shift.

At OBG 12W-PP116.5-W2 deck access hole inside, QA randomly observed the ABF/JV welder Chris Bruce perform the back gouging on the Complete Joint Penetration (CJP) butt joint. This task was not completed during this shift and will continue on the next scheduled shift.

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

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complied with the contract documents.

1. L14E-PP127.75-E4 North-OBG lifting lug (pyramid) removal QA verified
2. L14E-PP127.75-E4 South-OBG lifting lug (pyramid) removal QA verified
3. Skyway east bound-lifting lug hole #1 removal QA verified.
4. Skyway east bound-lifting lug hole #5 removal QA verified.
5. Bikepath east panel point PP26.5-north lifting lug removal QA verified.
6. Bikepath east panel point PP27.5-north lifting lug removal QA verified.
7. Bikepath east panel point PP30.5-north and south lifting lug removal QA verified.
8. Bikepath east panel point PP31.5-north and south lifting lug removal QA verified.
9. Bikepath east panel point PP32.5-north and south lifting lug removal QA verified.
10. Bikepath east panel point PP33.5-north and south lifting lug removal QA verified.
11. Bikepath east panel point PP34.5-north and south lifting lug removal QA verified.



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
