

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-029323**Date Inspected:** 11-Mar-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:** Bonifacio Daquinag**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 12E-PP116.5-E2 LSW longitudinal stiffener, this QAI randomly observed the ABF welder Mike Jimenez perform the Complete Joint Penetration (CJP) groove joint using the Shielded Metal Arc Welding (SMAW) process. The double-v-groove weld joint fit up was inspected and accepted by ABF QC Bonifacio Daquinag. This QAI also verified the root gap of 6mm and the alignment of less than 2mm and concurs with the QC inspector's assessment. The welder was using E9018H4R with 1/8" diameter electrode as per the Welding Procedure Specification (WPS) ABF-WPS-D1.5-1012-3. The splice joint was preheated to a minimum temperature of 200 degrees Fahrenheit using propylene gas torch. The QAI Inspector observed ABF QC Inspector, Bonifacio Daquinag, monitoring the preheat temperature, welding parameters and monitoring the electrodes due to its limited exposure time allowed. During the shift, observations of the welding was turned over to QAI Doug Frey due to a work assignment change.

At OBG 2E-3E inside and outside, this QA verified the transition ratio performed by ABF on the misalignment that was noted at 2E-3E-B and 2E-3E-F edge plates. During the verification, the slope transitions on the two (2) edge plates were noted smooth and appeared to comply with the 2.5 to 1 ratio requirement. The verification of the misalignment transition ratio was made for the purpose of closing out the two Incident Reports #033 and #034 both dated April 07, 2013.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

At Skyway Bikepath, this QA assisted SMR Adam Kreger in acquiring water samples from the bikepath structure. This QAI assisted Mr. Kreger in regards to the operation of the Ingersol Rand air supplied traveler rail platform that moved from end to end underneath the bike path span. SMR Adam Kreger was able to get one bottle of water sample from one of the bikepath structure but failed to get samples from two other structures due to their dry condition. Due to limited time, SMR Adam decided to continue to take the water samples either tomorrow or some other date.

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
