

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-029324**Date Inspected:** 20-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 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 Tower		

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, this QAI randomly observed ABF/JV qualified welder Lin E. Yun perform the continued back welding of the Complete Joint Penetration (CJP) butt joint. The welder was observed welding in the 4G (overhead) position utilizing the Shielded Metal Arc Welding (SMAW) process using a 5/32" diameter E7018H4R electrode as per the Welding Procedure Specification (WPS) ABF-WPS-D15-1040C. The weld joint appeared to be a single-V-groove butt joint welded with a steel backing bar. ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters and monitoring minimum preheat temperature which appeared to conform to the contract requirements. The welding was not completed on this date and will continue on the next scheduled shift.

At OBG 12E-PP116.5-E2 deck access hole, this QAI randomly observed the ABF/JV welder Mike Jimenez perform the welding of the Complete Joint Penetration (CJP) butt joint. The welder was observed welding in the 1G (flat) position utilizing the Shielded Metal Arc Welding (SMAW) process using a 5/32" diameter E7018H4R electrode and as per the Welding Procedure Specification (WPS) ABF-WPS-D15-1040C. The weld joint appeared to be a single-V-groove butt joint using a steel backing bar. The ABF Quality Control (QC) Inspector, William Sherwood, was observed monitoring the welding parameters. This QAI randomly monitored the welding parameters with a reading of 170 amperes which appeared to conform to the contract requirements. The welding was not completed on this date and will be continued on the next scheduled shift.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

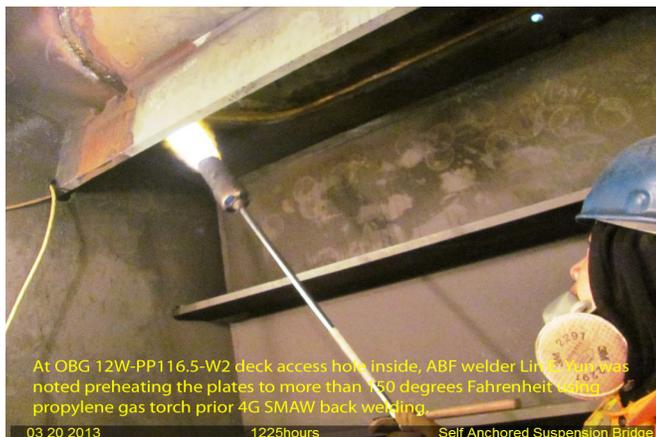
FW Spencer:

At Bikepath 'E', this QA randomly observed FW Spencer qualified welder Damian Llanos continuing to perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on 2" diameter weld-o-let to a 4" diameter compressed air line. The welder was noted welding the root pass with a 3/32" diameter E6010 electrode and fill pass to cover pass using a 3/32" diameter E7018H4R electrode as per the welding procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a propylene gas torch prior welding. During welding, ABF QC Bonifacio Daquinag was noted monitoring the welding parameters. At the end of the FW Spencer shift, CJP welding on four (4) 2" diameter weldolet to 4" diameter compressed air line weldolet T-joints were completed.

Line Service	Pipe Size	Panel Point	Location	Joint	Designation
1. Compressed Air	2"	weldolet 91.5	Bikepath 'E'	1/CA2/91.5/BE	
2. Compressed Air	2"	weldolet 92.5	Bikepath 'E'	1/CA2/92.5/BE	
3. Compressed Air	2"	weldolet 95.5	Bikepath 'E'	1/CA2/95.5/BE	
4. Compressed Air	2"	weldolet 96.5	Bikepath 'E'	1/CA2/96.5/BE	

At location Panel Point PP47.5-PP50.5 Bikepath 'E', this QA randomly observed the FW Spencer welder Rick Kiiikvee ID-5319 perform the Complete Joint Penetration (CJP) 6G (all position) using the Shielded Metal Arc Welding (SMAW) process. The welding of the 2" weld-o-let for the 4" diameter compressed air line was performed utilizing the 3/32 electrodes as per the welding procedure FW Spencer WPS 1-12-1. The welder was observed preheating and removing the moisture of the joint using a portable propane gas torch prior welding. During welding, ABF QC Bonifacio Daquinag was noted monitoring the parameters. At the end of the shift, four (4) 2" diameter weldolet were completed and visually accepted by QC. This QA performed VT verification on the completed weld splices and they appear to comply with the Contract requirements.

Line Service	Pipe Size	Panel Point	Location	Joint	Designation
1. Compressed air	2"	weldolet 47.5	Bikepath 'E'	1/CA2/47.5/BE	
2. Compressed air	2"	weldolet 48.5	Bikepath 'E'	1/CA2/48.5/BE	
3. Compressed air	2"	weldolet 49.5	Bikepath 'E'	1/CA2/49.5/BE	
4. Compressed air	2"	weldolet 50.5	Bikepath 'E'	1/CA2/50.5/BE	



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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