

**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-029503**Date Inspected:** 01-May-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:** Bernie Docena**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 Pier 7 warehouse, this QA together with ABF QC Bernie Docena have observed the exploratory excavation of Ultrasonic Testing (UT) detected defect on welded mock up plate ESW #19 Electro Slag Weld (ESW). ABF personnel was observed continuing to perform exploratory excavation on welded ESW at location Y=830mm. The ABF personnel have resumed the exploratory excavation from 12mm deep with 3mm increments. The personnel were noted using only the disc grinder in every 3mm increments of excavation up to 25mm and 1mm increments after 25mm up to the transverse indication. ABF QC Bernie Docena was observed performing Magnetic Particle Testing (MT) on every depth of excavation with no significant indication noted so far. This QA also performed the same test at every depth and noted same result. During the shift, the ABF personnel continued the excavation in 3mm increments using the same method of test and verification up to 25mm and then 1mm increments after 25mm until 34mm where 1.5mm long transverse indication was noted at this depth. After finding the transverse indication, SMR Aaron Prlich was called to see the indication. The shift was completed up to this depth of excavation and an ABF personnel was advised to excavate the side where the indication was located.

The results of the exploratory excavations are as follows;

1. 15mm in depth – no significant indication noted.
2. 18mm in depth – no significant indication noted.

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3. 21mm in depth – no significant indication noted.
4. 24mm in depth – no significant indication noted.
5. 25mm in depth – no significant indication noted.
6. 26mm in depth – no significant indication noted.
7. 27mm in depth – no significant indication noted.
8. 28mm in depth – no significant indication noted.
9. 29mm in depth – no significant indication noted.
10. 30mm in depth – no significant indication noted.
11. 31mm in depth – no significant indication noted.
12. 32mm in depth – no significant indication noted.
13. 33mm in depth – no significant indication noted.
14. 34mm in depth – 1.5mm transverse indication noted.



## 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

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**Reviewed By:** Reyes, Danny

QA Reviewer