

**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-029592**Date Inspected:** 15-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:****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 8W thru 12W and 9E thru 12E top deck plate outside, this QA was tasked to perform survey on the planar misalignment of the welded splice butt joints of the OBG various plates. During the survey, the following measurements were taken from the actual location of the misalignments;

OBG 9E-10E-B, Y-Locations Y=450-1392mm, Offset=7mm

OBG 9E-10E-C2, Y-Locations Y=5077-5277mm, Offset=4.5mm

OBG 9E-10E-E2, Y-Locations Y=4800-4980mm, Offset=7mm

OBG 9E-10E-E1, Y- Locations Y=0-150mm, Offset6mm

OBG 9E-10E-F, Y-Locations Y=0-90mm, Offset=3mm

OBG 9E-10E-F, Y-Locations Y=1282-1392mm Offset=2mm

OBG 10E-11E-C2, Y-Locations Y=0-250mm, Offset=3.5mm

OBG 10E-11E-C1, Y-Locations Y=4977-5277mm, Offset=4mm

OBG 10E-11E-D1, Y-Locations Y=0-100mm, Offset=3mm

OBG 10E-11E-D2, Y-Locations Y=4090-4250mm, Offset=7mm

OBG 10E-11E-E2 Y Locations Y=4677-5277mm, Offset=5mm

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OBG 10E-11E-E1 Y-Locations Y=0–220mm, Offset=5mm

OBG 10E-11E-F Y-Locations Y=0–130mm, Offset=2.5mm

OBG 11E-12E-B No visible offset.

OBG 11E-12E-C No visible offset.

OBG 11E-12E-D No visible offset.

OBG 11E-12E-E No visible offset.

OBG 11E-12E-E No visible offset.

OBG 11E-12E-F No visible offset.

OBG 8W-9W-B No visible offset.

OBG 8W-9W-C No visible offset.

OBG 8W-9W-D No visible offset

OBG 8W-9W-E No visible offset.

OBG 8W-9W-F No visible offset.

OBG 9W-10W-C2 Y-Locations Y=5140–5277mm, Offset=3mm

OBG 9W-10W-D2 Y-Locations Y=3460–3900mm, Offset=7mm

OBG 9W-10W-F Y-Locations Y=0–90mm, Offset=1mm

OBG Y location Planar offset Remarks

10W-11W B 800 – 1070mm 4mm

10W-11W D2 4090 – 4250mm 3mm

10W-11W E2 5147 – 5277mm 5mm

10W-11W E1 0 – 140mm 3.5mm

OBG Y location Planar offset Remarks

11W-12W B No visible offset.

11W-12W C No visible offset.

11W-12W D No visible offset.

11W-12W E No visible offset.

11W-12W F No visible offset.

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. Bikepath east panel point PP17.5 – north and south lifting lug removal QA verified.
2. Bikepath east panel point PP18.5 – north and south lifting lug removal QA verified.
3. Bikepath east panel point PP19.5 – north and south lifting lug removal QA verified.

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4. Bikepath east panel point PP20.5 – south lifting lug removal QA verified.
5. Bikepath east panel point PP21.5 – south lifting lug removal QA verified.
6. Bikepath east panel point PP27.5 – south lifting lug removal QA verified.
7. Bikepath east panel point PP28.5 – 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.

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<b>Inspected By:</b>	Lizardo, Joselito	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

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