

**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-029593**Date Inspected:** 13-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

<b>CWI Name:</b>	Salvador Merino and Fred Michel			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	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.

This QA Inspector randomly observed ABF welder Jose Torres #6235 perform the Shielded Metal Arc Welding (SMAW) process on the Hinge A barricade adjustment plates 1-4 (PL1, PL2, PL3 and PL4) on the north side of the eastbound OBG. The welder was observed utilizing WPS ABF-D1.5-1072-Revision 1 for Complete Joint Penetration (CJP) welding. The welder was also observed preheating the surface area to 150 degrees Fahrenheit prior to welding. Other welding parameters were inspected by the QC Inspector Fred Michels and were as 136 amperes. The welding appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract documents.

This QA Inspector randomly observed ABF welder Rick Clayborn perform the SMAW process on the Hinge A barricade adjustment plates 1-4 (PL1, PL2, PL3 and PL4) on the south side of the eastbound OBG. The welder was observed utilizing WPS ABF-D1.5-1072-Revision 1 for CJP welding. The welder was observed preheating the surface area to 150 degrees Fahrenheit prior to welding. Other welding parameters were inspected by the QC Inspector Fred Michels and as 130 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract documents. During the shift, the welder left and went to another job assignment.

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# WELDING INSPECTION REPORT

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FW Spencer:

At OBG location panel point PP37, this QA randomly observed FW Spencer welder Tim Esquivel continue to perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on 4" diameter compressed air line field butt joints. The welder was noted welding the root pass with 3/32" diameter E6010 electrode and followed by fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing Caltrans procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable propylene gas torch prior welding. During welding, ABF QC Salvador Merino was noted monitoring the parameters of the welder. At the end of the FW Spencer shift, CJP welding on two 4" diameter c water line compressed air line butt joints designated as 30/4/37/BE and 31/4/37/BE were completed.



### 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