

**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-029595**Date Inspected:** 15-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:** 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.

This QA Inspector randomly observed ABF welder Lou Xiao Hua continuing to perform 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 parameter were inspected by the QC Inspector William Sherwood and the working current was measured 136 amperes which 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. All four (4) barrier plates were completed during the shift.

FW Spencer:

At location panel point PP31 and PP33 along the north side of the bikepath, this QA randomly observed the FW Spencer welders Rick Kickvee and Tim Esquivel continuing to perform Complete Joint Penetration (CJP) 6G (all position). The Shielded Metal Arc Welding (SMAW) welding of the 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

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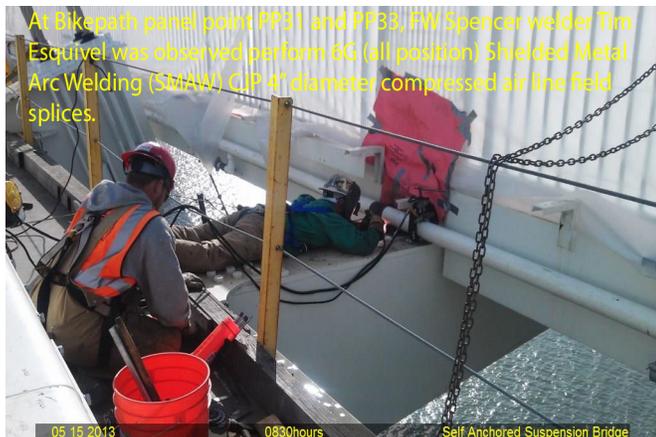
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procedure FW Spencer WPS 1-12-1. The welders were noted preheating and removing the moisture of the joint using a portable propylene gas torch prior to welding. During the welding, ABF QC Fred Michels was noted monitoring the parameters and the preheat. At the end of the FW Spencer shift, CJP welding on two 4" diameter compressed air line butt joints were still in progress during the shift.



## 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

**Reviewed By:** Reyes, Danny

QA Reviewer

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