

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-029598**Date Inspected:** 24-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	William Sherwood and Fred Mich			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 panel point location PP13.5-E5 east bound, ABF qualified welders Lin E Yun and Lou Xiao Hua were observed continuing to perform 3F (vertical) position fillet welding the barrier cover plate at the corner of luminaire light post box. The welders were noted fillet welding the plates using the Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. The fillet welding of the barrier cover on the luminaire corner was welded per Caltrans approved drawing Barrier Details No. 2D. This QA Inspector had noted QC Inspector William Sherwood monitoring the welders' welding parameters and workmanship of the fillet welding being welded. This QA Inspector performed a verification of the welding parameters and observed working current of 130 amperes on the 3.2mm E7018H4R electrode. At the end of the shift, the welders have completed the 6mm fillet weld joints on two (2) corners of one luminaire box as mentioned above.

FW Spencer:

At location various panel point along the north side of the bikepath, this QA randomly observed FW Spencer qualified welders Rick Kickvee and Tim Esquivel continuing 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 and domestic water line field butt joints. The welders were noted welding the root pass with 3/32" diameter

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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 welders were noted preheating and removing the moisture of the joint using a portable propylene gas torch prior welding. During welding, ABF QC Fred Michels was noted monitoring the parameters of the welders. At the end of the FW Spencer shift, CJP welding on three 4" diameter compressed air line butt joints designated below were completed.

Welder Rick Kickvee:

1. 44/4/53/BE
2. 41/4/55/BE

Welder Tim Esquivel:

3. 29/2.5/39/BE
4. 30/2.5/41/BE
5. 31/2.5/43/BE

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
