

**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-029608**Date Inspected:** 22-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:** Fred Michels**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 the OBG panel points PP88.5 and PP97.5 west bound, ABF welders Lin E Yun and Lou Xiao Hua were observed performing the 3F (vertical) position fillet welding of the barrier cover plates at the corners of the 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 the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. The fillet welding of the barrier cover on the luminaire corner was welded as per the drawing Barrier Details No. 2D. This QA Inspector noted QC Inspector William Sherwood monitoring the welding parameters and the quality of the workmanship. 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 the two (2) corners of luminaire box at PP97.5 while the luminaire box at located at PP88.5 was still in progress.

FW Spencer:

At various locations along the north side of the bikepath, this QA randomly observed FW Spencer welders Rick Kickvee and Tim Esquivel perform the Complete Joint Penetration (CJP) of the pipe butt joints using the Shielded Metal Arc Welding (SMAW) process. root pass to cover pass on 4" diameter compressed air line field butt joints. The welding was performed on the 4" diameter compressed air line using the 3/32" electrodes using the E6010

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# WELDING INSPECTION REPORT

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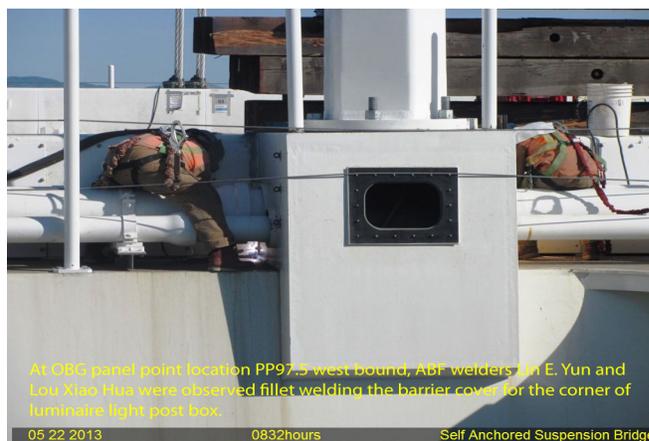
electrodes for the root pass and the E7018H4R electrodes for the fill to cover passes as per the FW Spencer WPS 1-12-1. The welders were noted preheating the joints using a portable propylene gas torch prior welding. During welding and at random intervals this QA inspector observed the ABF QC inspector, Fred Michels, monitoring the welding and performing the in process weld inspection. At the end of the shift the welding of three 4" diameter compressed air line butt joints were completed as noted below:

Welder Rick Kickvee:

1. 46/4/63/BE
2. 45/4/63/BE

Welder Tim Esquivel:

3. 4/51/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.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

**Reviewed By:** Reyes, Danny

QA Reviewer

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