

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-029798**Date Inspected:** 09-Jul-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 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 14E-PP125-E1, this QA has observed ABF welder Wai Kit Lai continuing to perform 4F position SMAW fillet welding on thick drip plate to OBG side plate. The welder was using 3.2mm diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. The drip plate being welded is 2" wide x 3/8" thick on overhead position. During the shift, ABF QC William Sherwood was noted monitoring the welder. At the end of the shift, fillet welding on the drip plate was still ongoing and should continue tomorrow.

At OBG crossbeam number 8 inside, this QA performed MT verification on the removal of welded temporary attachments during the restoration of the said crossbeam. QA was using Parker Contour Probe Model DA 400 with serial number 16989 electromagnetic yoke with red magnetic powder as detecting media. QA found no significant indications during the verification.

FW Spencer:

At location bikepath E panel point PP111, this QA randomly observed FW Spencer qualified welder 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 line field butt joints. The welder was

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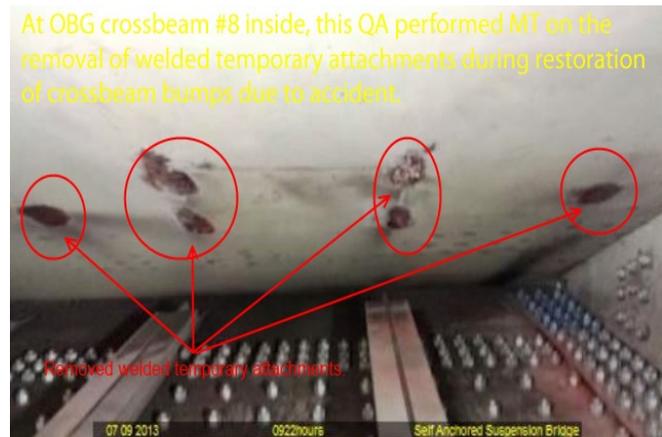
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noted welding the root pass with 3/32" diameter E6010 electrode and followed by fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing Caltrans procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable propylene gas torch prior welding. During welding, ABF QC Fred Michels was noted monitoring the parameters of the welder. At the end of the FW Spencer shift, CJP welding on three (3) 4" diameter compressed air line field butt joints designated as 71/4/111/BE, 72/4/111/BE and 73/4/111/BE were completed.

This QA together with two (2) Caltrans Engineers Mr. Thong Lee and Mr. Tuc were also tasked to perform Punch List inspection at various OBG locations. The following punch list items were verified corrected by the contractor to the satisfaction of both Caltrans Engineers;

Punch List Item: Description:

1. 462 Removal of finish coat at some minor areas on the deck.
2. 280 The emergency gate track is not welded to emergency platform connection plate per shop drawing BKR-AN-5.
3. 282 Drill pull box platform holes in edge plate.
4. 466 Suspender brackets (2 pieces) at PP106 E&W were loaded on the ship in mist coat without being checked for cleanliness.
5. 3508 Type 2/10 stiffeners require buttering due to Green Joint at FS12.
6. 460 Areas with minor paint damaged due to grinding, handling and Installing elastomeric bearing pad shall be repaired with Interzinc.
7. 3760 Lift 13E Barrier cover plate and Luminaire on E line PP119.
8. 3719 OBG steel barrier. Skyway section. Horizontal stiffener fillet weld.
9. 173 OBG segment 6AW green tags 1, 2 and 4 are pending due to incomplete work per RFI 2083.



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
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