

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-029799
Date Inspected: 10-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 Guo Wu Chen who took over from 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 at this particular location was completed

During the shift, this QA verified a punch list item #3835 that was located at 14E-PP122.5. The punch list item concerned was about the cope that has been made perpendicular to the edge of the vertical plate (VP3007A and VP3008A) as per referenced TC-RFI-0506R0. When the mentioned punch item was inspected, it was noted ground smooth and painted with Inorganic Zinc primer which deemed acceptable to the project requirements.

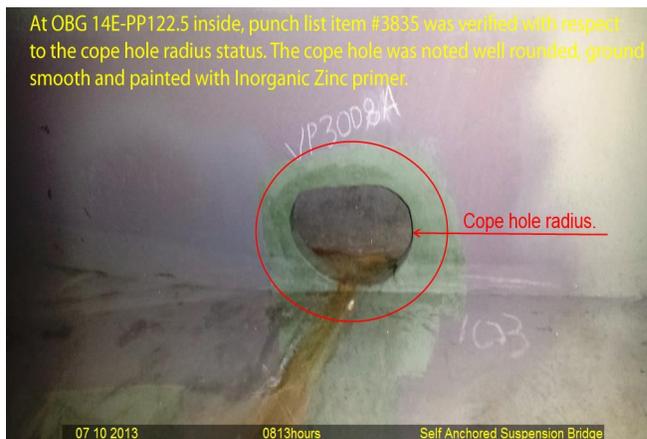
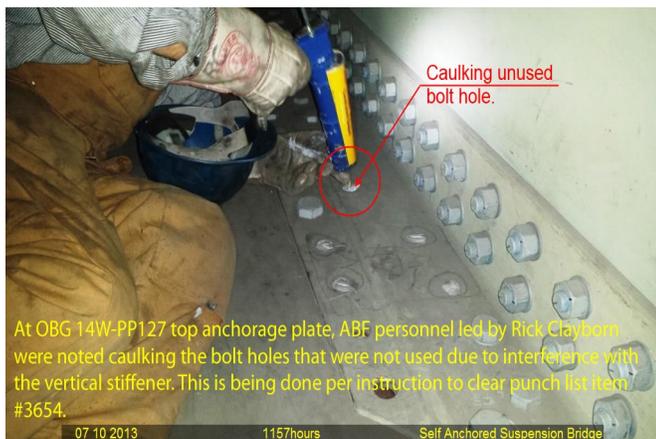
This QA also witnessed ABF personnel perform caulking on unused bolt holes on angle 203mm x 203mm of top anchorage plate at 14W-PP127. The bolt holes were not used due to interference with the vertical stiffener plate. ABF personnel were noted using the Sikaflex caulk. During this operation, ABF QC Brian Connolly was also with the ABF personnel to monitor the work they were doing. This task is being done to clear punch list item #3654.

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FW Spencer:

At location bikepath E panel point PP121, 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 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 five (5) 4" diameter compressed air line field butt joints designated as 76/4/121/BE, 77/4/121/BE, 81/4/121/BE, 82/4/121/BE and 73/4/121/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.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer