

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-029861
Date Inspected: 12-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:	Salvador Merino and Fred Michel			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 Cross beam #4 inside, this QA randomly observed perform Flux Cored Arc Welding (FCAW-S) PJP welding 1 3/4" diameter pipe butt joints for handrail. The handrails are being welded back to its original position after the electricians have previously cut the handrails for access. During the shift, AB QC Fred Michels was noted monitoring the workmanship and parameters of the welder. At the end of the shift, 8 PJP butt joints on the crossbeam #4 handrails were completed.

This QA also witnessed ABF personnel continuing to perform caulking on 4 to 5mm gap between the backing bar and vertical plate at 13AW-PP119.65. This caulking is being done to clear a punchlist item #3770 from ZPMC China. The location of the gap was limited and that MT/NDT was not accessible to perform.

At Pier 7 Warehouse, this QA performed the visual verification on the PJP welding of 4" diameter x 0.337" thick pipe butt joint for bikepath Belvedere bench. The pipe butt joints were welded per work order #SK-3300R00-02. The six (6) weld butt joints were inspected by ABF QC Salvador Merino and verified by this QA were marked bench #5, 6 and 7. The workmanship of the completed 4" diameter butt joints were deemed acceptable to the project requirements.

FW Spencer:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

At location bikepath E panel point PP77 and Northeast PP126, this QA randomly observed FW Spencer qualified welders Tim Esquivel, Barry Mullaney and a new welder Salvador Gomez continuing to perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on 2.5" diameter domestic water line and 4" diameter compressed air field butt joints. The welders were 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 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 2.5" and 4.0" diameter pipe joints at various locations were completed;

Tim Esquivel:

1. 57/2.5/77/BE Domestic water service line

Barry Mullaney:

2. 46/2.5/126/NE Domestic water service line
3. 1/CA2/124/NE Compressed Air service line

Salvador Gomez:

4. 47/4/126/NE Compressed Air service line
5. 47/2.5/126/NE Domestic water service line
6. 50/2.5/126/NE Domestic water service line



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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
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Reviewed By:	Reyes, Danny	QA Reviewer
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