

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-029862**Date Inspected:** 19-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:** 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 East bound E2 north side structure, ABF personnel cut eight holes for the pipe sleeves then ground smooth the cut surface of the plate. The personnel were noted using disc and die grinders to make the surface profile. After the completion of the grinding, ABF personnel have called on ABF QC and QA to check and verify the surface profile of the cut. During the QA verification, the eight cut holes (four from the west side and four from the east side) were noted smooth and deemed acceptable.

After the QA and ABF QC verification of the cut holes on the north on east bound E2, the same personnel have moved to the south side of the east bound E2 structure and performed the same cutting and grinding of eight holes for the pipe sleeves. The personnel performed grinding of the cut holes until the end of the shift

FW Spencer:

At various panel point location of Northwest and Southwest, this QA randomly observed FW Spencer qualified welders Tim Esquivel, Barry Mullaney and 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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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. The welder Tim Esquivel completed the fillet welding all around the channel C5 x 9 on top of welded plate of the deck plate.

Barry Mullaney:

1. 55/4/126/SW Compressed Air service line
2. 56/4/126/SW Compressed Air service line
3. 68/4/118.5/NW Compressed Air service line
4. 69/4/119/NW Compressed Air service line
5. 1/CA2/119/NW Compressed Air service line weldolet

Salvador Gomez:

6. 53/4/127/SW Compressed Air service line
7. 57/4/126.5/SW Compressed Air service line
8. 58/4/127/SW Compressed Air service line

Tim Esquivel:

9. #130719 5" x 9 C-channel pipe support



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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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