

**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-029880  
**Date Inspected:** 30-Jul-2013

**Project Name:** SAS Superstructure  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV  
**Contractor:** American Bridge/Fluor Enterprises, a JV

**OSM Arrival Time:** 700  
**OSM Departure Time:** 1730  
**Location:** Job Site

<b>CWI Name:</b>	Salvador Merino	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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.

This QA together with ASMR Laura Webb, Caltrans Engineer Thanh Le and two ABF Engineers performed punch list items inspection/verification after they were corrected. The following punch list items were verified corrected;

Item	Category	Location	Panel Point	Remarks
7097-	Installation..	West Bound....	PP57.....	Replaced missing bolt.
8065-	Installation..	West Bound....	PP64.....	Replaced missing bolt.
8083-	Installation..	West Bound....	PP70.....	Replaced long bolts and missing nuts
9071-	Installation..	West Bound....	PP75.....	Replaced missing bolt.
9089-	Installation..	West Bound....	PP80.....	Replaced missing bolts, short bolts and tightened loose bolts.
10061-	Installation.	West Bound...	PP92.....	Replaced missing bolts, short bolts and tightened loose bolts.
13011-	Installation.	West Bound...	PP118.5.....	Replaced short bolts.
13013-	Installation.	West Bound...	PP119.....	Replaced short bolts.
13037-	Installation.	West Bound...	PP123.....	Replaced missing bolt.
14026-	Installation.	West Bound...	PP128.....	Replaced missing bolt.
1025-	Installation..	East Bound....	PP8.....	Replaced missing bolt.

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1010- Painting..... West Bound....PP20.....Repaired finish coat/paint.

FW Spencer:

At various panel points location of Northwest and Southwest, this QA randomly observed FW Spencer qualified welders Tim Esquivel, Barry Mullaney and welder Salvador Gomez continuing to perform the Complete Joint Penetration (CJP) welding using the Shielded Metal Arc Welding (SMAW) process to weld the 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 welding of the fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing the 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 Salvador Merino was noted on site 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. 83/2.5/117/BE Domestic water line
2. 84/2.5/117/BE Domestic water line
3. 78/2.5/111/BE Domestic water line

Salvador Gomez:

4. 48/4/118/SW Compressed Air service line
5. 49/4/118/SW Compressed Air service line
6. 48/2.5/118/SW Domestic water line
7. 49/2.5/118/SW Domestic water line

Barry Mullaney:

At location W2 panel point PP128, FW Spencer Barry Mullaney was observed performing the all position all around fillet welding the angle 2" x 2" x 3/8" thick (to previously welded plate to barrier) pipe support. The welder was noted using Shielded Metal Arc Welding with 1/8" E7018H4R electrode implementing the welding procedure specification identified as Fillet Murex. During welding, ABF QC Salvador Merino was noted on site monitoring the welding and the workmanship. During the shift, fillet welding of the pipe support mentioned above was completed.

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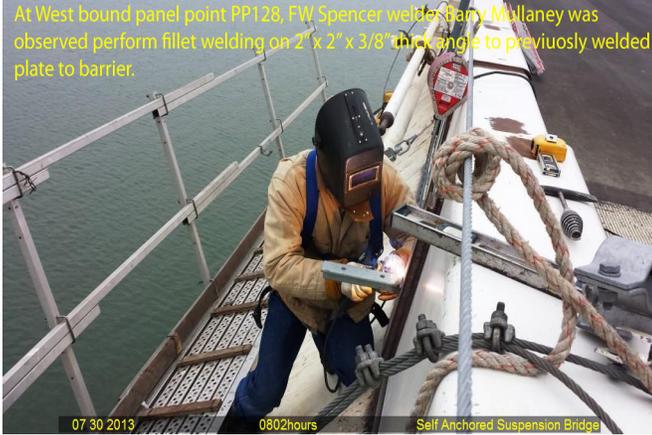
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At West bound panel point PPI28, PW Spencer welder Gary Mullaney was observed perform fillet welding on 2" x 2" x 3/8" thick angle to previously welded plate to barrier.



## 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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<b>Inspected By:</b>	Lizardo, Joselito	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

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