

**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-029909**Date Inspected:** 02-Aug-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**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 Bikepath between panel point PP117 and PP121, this QA randomly observed ABF personnel cut four 8" diameter pipe for light pole anchor. The pipes were cut to length and the anchor plate on top of the pipes were beveled in preparation for Partial Joint Penetration (PJP) weld joints. After cutting, the paint coating of the pipes was removed and ground smooth the end of the pipe. The light pole anchor plates were tack welded but not welded during the shift. This task is being done per RFI #003170R01.

At 210 Burma Road, Oakland, CA, where IERBYS Temporary Improvement Building is being renovated, ABF qualified welders Wai Kit Lai and Donald Plum were observed continuing to perform fillet welding on the 4" x 2" x 1/4" thick clip plates and tube steel 6" x 3" x 5/16" thick to the existing building column. Welder Wai Kit Lai was noted using self shielded Flux Cored Arc Welding (FCAW-S) with 0.072" diameter E71T-8 wire electrode implementing the WPS noted as ABF-WPS-D11-F2200 while welder Donald Plum was noted using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing the WPS noted as ABF-WPS-D11-F1200. Welder Wai Kit Lai was noted fillet welding and flare bevel welding the clip plates and tube steel to the existing W-column at columns 10 to 15 of grid line 'C'. ABF QC Salvador Merino was noted on site monitoring the workmanship and welding parameters of the welder. ABF QC has measured the working current of 215 amperes and 19 voltage on the 0.072" diameter E71T-8 wire electrode. This QA randomly verified the workmanship of the required 3/16" fillet welds and flare bevel welds and noted deem acceptable to contract

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

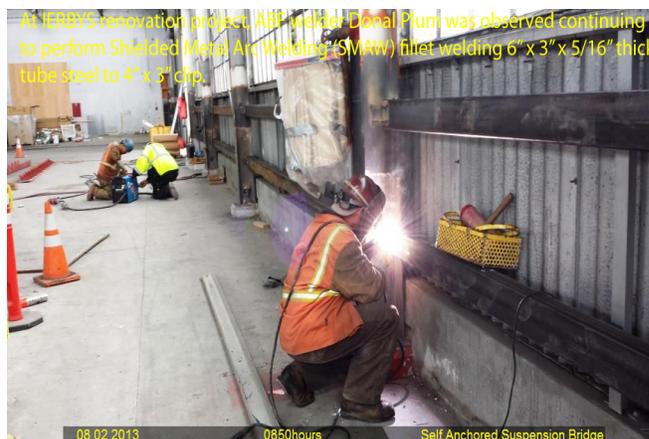
requirements.

FW Spencer:

At panel point PP94 of bikepath , this QA randomly observed FW Spencer qualified welders Tim Esquivel 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 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 the 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" diameter pipe joint at location mentioned below was completed.

Tim Esquivel:

## 1. 94/2.5/121/BE Domestic water 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 Materials for your project.

---

**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

---

**Reviewed By:** Reyes, Danny

QA Reviewer