

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-029910**Date Inspected:** 03-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 the Hinge 'K' west bound south side of the steel barrier, this QA randomly observed Rick Clayborn continuing to perform Partial Joint Penetration (PJP) welding 1/2" thick infill plate to steel barrier. The 6" round/square infill plate is being welded to cover the holes that were used as an access to pour concrete on the steel barrier. The welder was noted using self shielded Flux Cored Arc Welding (FCAW-S) with 0.072" diameter E71T-8 wire electrode. This task is being done per Contract Change Order (CCO) #216 and RFI #3370. During the welding ABF QC Fred Michels was on site monitoring the workmanship and the welding parameters. At the end of the shift, PJP welding as well as flush grinding on the cover of the completed weld joints were still continuing and should remain tomorrow.

At Bikepath expansion joint near hinge A, ABF personnel were noted cutting the two posts for the bikepath handrail due to interference with the newly installed expansion cover plate. After cutting the handrail post from the base plate, ABF personnel took the measurements then tack welded the same base plate to the handrail post. ABF personnel also cut the end plate cover of the 3" diameter pipe handrail due to interference with the same newly installed expansion cover plate. ABF welder Gue Wu Chen was noted performing the tack welding and PJP welding of the end plate using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode. During the shift, ABF QC Fred Michels was on site monitoring the workmanship and welding parameters of welder Gue Wu Chen.

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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