

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-029943
Date Inspected: 20-Aug-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

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 & Bikepath	

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.

Underneath the bike path at panel points PP123.5 and PP122, this QA randomly observed ABF/JV the welder Rick Clayborn continuing to perform the 8mm fillet welding of the flange and the 5mm fillet welding of the web on W10 x 8 to a ¾" thick connection plate inner rail hanger as required. The welder was observed welding in the 2F (horizontal) position utilizing self shielded Flux Cored Arc Welding (SMAW) with 0.072" diameter wire electrode implementing welding procedure ABF-WPS-D15-F2200. During the shift, ABF QC Fred Michels was noted monitoring the workmanship and the welding parameters. At the end of the shift, 2F SMAW fillet welding was completed at two locations mentioned above.

The ¾" thick connection plate was cut and removed due to a discrepancy in the length which was done without approval of the Engineer. When ABF QC was asked about the necessary supporting documents about the task being undertaken, Fred Michels informed this QA that ABF has submitted the Request for Information (RFI) but awaiting response from Caltrans.

This QA together with SMR Laura Webb, Caltrans Engineer Thanh Le and two ABF Engineers performed the punch list item inspection to verify for compliance. The following punch list items were verified corrected;

Item	Category	Location	Panel Point	Remarks
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WELDING INSPECTION REPORT

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P00059 Painting West Bound PP125 Completed.
14039 Installation West Bound PP127-PP128 Replaced missing bolt.
D3019 Debris East/West Bound PP8-PP124 Removed temporary attachments from crossbeams.
D3021 Painting East/West Bound PP8-PP124 Painted gap between connection plates on crossbeams.
D3024 Painting East/West Bound PP8-PP124 Repaired painting on the sides of all crossbeams.
P00046 Painting East/West Bound PP94 Replaced missing bolts.
P00030 Coating East/West Bound PP8-PP124 Coating completed.
D2002 Installation West Bound PP16 Completed.
D2004 Installation West Bound PP15-PP16 Replaced missing bolt.
D2013 Painting West Bound PP16 Completed.
D2010 Installation West Bound PP13 Installed cover on barrier.
D1016 Installation West Bound PP10 Tightened loose bolts.
D1002 Painting West Bound PP8 Completed painting on barrier.
H021 Installation East Bound PP4 Removed wooden stake from pipe beam.
H030 Installation East Bound PP2 Installed missing bolts.
14094 Installation East Bound PP128 Completed missing bolts.
13116 Installation East Bound PP123 Completed missing bolts.
13113 Installation East Bound PP122.5 Completed missing bolts.
13095 Installation East Bound PP123 Installed access door.

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
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Reviewed By:	Reyes, Danny	QA Reviewer
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