

**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-029944**Date Inspected:** 21-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:** 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 point PP121, this QA randomly observed ABF/JV personnel cut approximately 6" of the W10 x 8 inner rail hanger due to the excessive gap and replace it with approximately 9" long pop piece as required. The ABF personnel used a flame cutting torch to cut the existing hanger rail then put the 30 degree bevel on top, bottom flanges and web. After cutting the existing rail, the ABF personnel ground smooth the ends where the cut was done. ABF personnel took the measurement and cut the pop piece to be added to the rail from the extra rail. The ABF personnel was noted cutting and grinding the existing top piece. This task is being undertaken per the approved Request for Information (RFI) #3407 R00.

FW Spencer:

The QAI observe the ongoing installation, field fit-up and tack welding of the utility pipe support PS#5 along the east bound grid line located on top side of the crossbeam #19. The 6" x 3" angle was welded to the previously welded 3" x 3" angles to the top plate of the cross beam. The QC inspection was performed by Fred Michels utilizing the Welding Procedure Specification (WPS) identified as Fillet Murex to monitor the tack welding and fillet welding. The welding parameters were observed and recorded as 120 amps utilizing the 3.2 mm E7018H4R electrodes with the welding performed in the 2F and 3F position. The tack welding and fillet welding was performed by Tim Esquivel on the fillet weld joints designated as 130821-01, 130821-02 and 130821-03.

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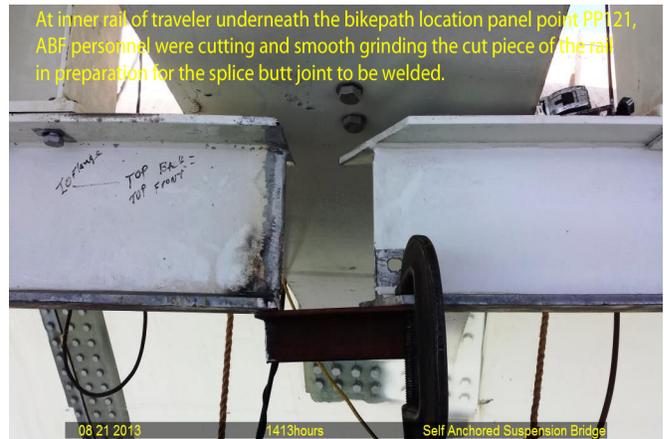
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# WELDING INSPECTION REPORT

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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.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

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**Reviewed By:** Reyes, Danny

QA Reviewer