

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-029945**Date Inspected:** 22-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 the welder Rick Clayborn performing the fit up and the tack welding of the inner rail splice butt joint as required. The welder was observed tack welding the weld joint utilizing self shielded Flux Cored Arc Welding (SMAW) process using the .072" diameter wire electrode. After the completion of the fit up and tack welding of the butt splice joint, Mr. Clayborn performed the 2G/3G/4G CJP welding of the top flange, bottom flange and the web of the traveler rail girder. The field preparation of the top flange, bottom flange and web appeared to be a 60 degree included groove angle with no backing and will be back gouged as per the attached drawing of the Request for Information (RFI) #3407 R00. During the shift, ABF QC Fred Michels was noted monitoring the welding, workmanship and the parameters. At the completion of the CJP welding it was noted by this QA that the ABF personnel started the grinding and the cleaning of the welds in preparation for VT/MT/UT.

At the bike path at panel point PP123.25, this QA randomly observed ABF/JV the welder Rick Clayborn continuing to perform the fillet welding on the C80 x 100 channel to the side of the bike path for electrical support pull box as per the approved drawing ES-6/detail PB-1E. The welder was observed welding in the 2F/3F (horizontal/vertical) position utilizing the self shielded Flux Cored Arc Welding (SMAW) process using the .072" diameter wire electrode as per the welding procedure ABF-WPS-D15-F2200. After the welding of the C-channel to the side of the bike path, a 6" x 4" angle was also welded on top of the C-channel. During the shift, ABF QC

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Fred Michels was noted monitoring the welding, workmanship and parameters. During the shift, fillet welding was completed at panel point PP123.25.

After the completion of the fillet welding mentioned above, another ABF welder Erick Sparks also performed the same 7mm all around fillet welding of the C80 x 100 to the side of the bikepath at the panel point PP125. During welding, the welder was noted utilizing Shielded Metal Arc Welding (SMAW) process using the 1/8" diameter E7018H4R electrode as per the welding procedure ABF-WPS-D15-F2200. After the welding of the C-channel to the side of the bikepath, a 6" x 4" angle was also welded on top of the C-channel. Fillet welding at this location was also completed during this shift. This QA performed random verification on the fillet welding of the C-channel and found deemed acceptable to the contract requirements.



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