

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-029947**Date Inspected:** 24-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 Crossbeam**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 crossbeams # 17, 12, 7, 4 and 1, this QA randomly observed ABF/JV qualified welder Rick Clayborn continuing to perform 5mm fillet welding on 4" long x 2" wide x 3/8" thick plate as door lock for the access door. The task is being undertaken per Contract Change Order (CCO) #340. 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 completion of the welding on each crossbeam, ABF QC Fred Michels performed Magnetic Particle Testing (MT) with no significant indications noted during the test. During the shift, ABF QC Fred Michels was also noted monitoring the welding, workmanship and parameters.

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At crossbeam #17, ABF welder Rich Clayborn was noted fillet welding 4" long x 2" wide x 3/8" thick plate for the crossbeam access door lock.



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
