

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-030033**Date Inspected:** 17-Sep-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:** Salvador Merino**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 Upper Saddle**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.

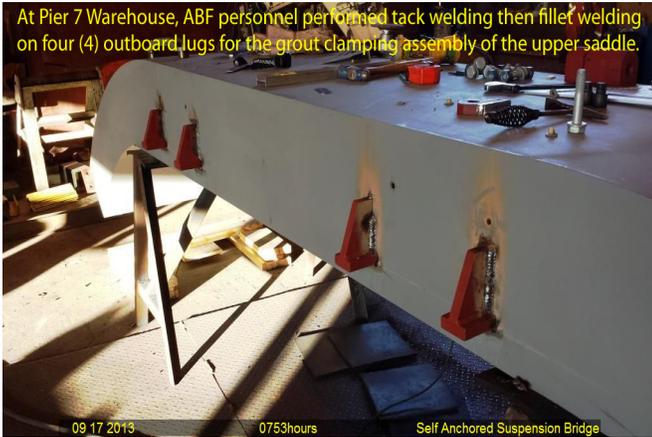
At Pier 7 Warehouse Oakland, CA this QA randomly observed ABF welders Richard Garcia and Rick Choinard continuing to perform Shielded Metal Arc Welding (SMAW) fillet welding between the outboard lugs marked x361-08a2 and inboard lugs marked x361-08pb3 to 3/4" thick upper saddle S10B. The welders were using 3/32" diameter E7018H4R electrode during tack welding and switched to 1/8" diameter E7018H4R during the fillet welding implementing Caltrans approved ABF-WPS-D15-F1200A. The fillet welding of the splice lugs to the upper saddle is being done per Contract Change Order CCO #327 with reference ABF shop drawing #X361-08 Revision A. Prior tack and fillet welding, the welders were noted grinding off the paint then tack welded all eight (8) lugs. After tacking the lugs, the welders preheated the plates using propylene gas torch then performed the fillet welding. ABF personnel have tack/fillet welded four (4) outboard lugs to one side of the upper saddle and four (4) inboard lugs to the other side of the upper saddle. During the shift, ABF QC Salvador Merino was noted on site monitoring the workmanship and parameters of the welders. All eight (8) lugs were completely fillet (3/8") welded during the shift and ABF QC Salvador Merino also performed the visual/dimensional inspection on welded lugs. This QA also performed visual/dimensional verification on completely welded fillet lugs and deemed in compliance to the project requirements.

After the welding completion of the eight inboard/outboard lugs of the grout clamping assembly, ABF QC Salvador Merino informed this QA that he will let the welds cool down to ambient temperature before he will

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

perform Magnetic Particle Testing (MT). ABF QC Salvador Merino performed the MT on the fillet welds as soon as the welds cooled down and found no relevant indications noted during the test. This QA performed the MT verification and noted same result.



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: Riley, Ken

QA Reviewer
