

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-030060
Date Inspected: 18-Sep-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: 1630
Location: Job Site

CWI Name:				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 Tower Head		

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 cable saddle on top of Tower Head elevation 155 meters, this QA together with SMR Saied Khan were tasked to perform after the fact visual verification on previously welded stainless steel ducting for the cable dehumidification system. The visual verification was from top of saddle cover plate all the way to the flange to flange connection of the stainless steel ducting to the shroud cable cover. The 150/100mm stainless steel ductings were previously welded by FW Spencer welder Craig Perry.

During the visual verification, the 150mm diameter stainless steel started from a 150mm diameter carbon steel pipe outlet from cable saddle bolted flange to flange connection and then branched out to a 150/100mm Y-reducer that led to a 100mm diameter line on each shroud cable cover. In between the 100mm diameter stainless steel line, there was also a stainless steel flexihose that was fillet welded to a flange on both ends that were flange connected to the 100mm diameter line.

This QA together with SMR Saied Khan went on each of the stainless steel ducting at the west side north and south cable and east side north and south cable. This QA has noted that the east and west sides ducting system was having typical stainless steel dehumidification ducting that were welded at the job site. The welded butt joints were visually verified and deemed in conformance to the job requirements.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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