

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-030061**Date Inspected:** 19-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:****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 Pier 7 warehouse weld shop, QA randomly observed ABF welder Brandon Chapman continuing to perform flat position stud welding on 5/8" diameter x 6" long stud to the top side of 8" x 8" x 1/2" thick embed plates per Contract Change Order #CCO 331 and ABF shop drawing #CCO331-X-01. The welder has stud welded two (2) pre-production welds then bent to 30 degrees. After welding, ABF QC Salvador Merino inspected the diameter of the welds for 360 degree all around flash. This QA also performed visual verification on the flash of the stud welds and noted same results. The welder then bent tested the test studs to 30 degree using a 10 pounds sledge hammer and noted acceptable results. The welder started the production stud welding as soon as the pre-production test was completed. During the shift, the welder has completed stud welding 4- 5/8" diameter x 6" long Nelson studs on each of the 32 embed plates.

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.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer