

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012639**Date Inspected:** 15-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2000**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernie Docena and Jesus Cayabyab			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:	Orthotropic Box Girder		

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. The following observations were noted;

1. Orthotropic Box Girder (OBG) L1E/L2E Plate C2 splice welding
2. Orthotropic Box Girder (OBG) L3E/L4E Plate D splice fit-up

1. The QAI randomly observed manual welding of plate C2 splice utilizing gas shielded Flux Cored Arc Welding (FCAW-G). Two American Bridge Fluor/Joint Venture (ABF/JV) welders Rory Hogan (welder ID 3186) and Jeremy Dolman (welder ID 5042) were noted welding in vertical position using wire electrode E71T-1M with 1.6mm diameter, implementing Welding Procedure Specification (WPS) ABF-WPS-D15-3042A-1. The two mentioned ABF/JV welders were noted alternately welding the joint to avoid eye flash burn. It was also noted that they were preheating the joint prior welding. During welding, ABF/JV Quality Control Inspector (QCI) Bernie Docena was noted monitoring the welding parameters. At noon, QCI Bernie Decena left the job site and according to him he was heading to Pier 7. He was then replaced by another ABF/JV QCI Jesus Cayabyab who performed the monitoring until the welding of plate C2 was complete. After completion of 1E-2E-C, segment C2, the welding crew working on this plate was noted moving to another splice location plate 1E-2E-E.

2. The QAI observed the installation and fillet welding of temporary fit up aids on the bottom plate D at OBG lifts 3E/4E field splice. The temporary fillet welding was performed using shielded metal arc welding (SMAW) with 1/8" E7018 electrodes. The QAI observed the QC Inspector Jesus Cayabyab monitoring the welding of the fit up

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aids at this location. The QAI noted that the workmanship appeared to be generally conforming to the contract requirements.



Summary of Conversations:

As stated above.

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 Mohammad Fatemi (916) 227-5298, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
