

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013945**Date Inspected:** 04-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	William Sherwood and Jim Cunningham			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.

At OBG L1E/L2E bottom plate 'D' outside, QA randomly observed ABF/JV qualified welder Mitch Sittinger perform CJP groove welding repair. The welder was observed welding in the 4G (overhead) position utilizing Shielded metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1000-Repairs. The weld repairs were excavated to a boat shape with one repair having a dimension of 120mm long X 23mm wide X 18mm deep. The repair excavations were preheated to more than 140 degree Fahrenheit using propane gas torch prior welding. During the shift, ABF QC William Sherwood was noted monitoring the welder. Prior welding, ABF QC William Sherwood was also observed performing Magnetic Particle Testing (MT) on the repair excavations. During the shift, the welder has completed three welding repair outside and was noted working on the 4th repair at the end of the shift.

At OBG L4E/L5E, ABF personnel were noted moving the OBG Lift 5E close to OBG L4E. Prior to connecting the two splice together, two ABF personnel were noted grinding the top deck transition of plate A1 (20/14mm) and A5 (14/20mm) at the bottom sides of the plates. QA also observed ABF QC Mike Johnson monitoring the grinding of the two transitions and during conversation with QC, Mike Johnson mentioned to QA about finding the transition appears acceptable.

At OBG L3E/L4E side plate 'C' outside, QA randomly observed ABF/JV qualified welder Rory Hogan ID #3186

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

perform welding on the excavated slag inclusion. The welder was using Shielded Metal Arc Welding (SMAW) with E7018H4R, 5/32" diameter electrode in 4G (overhead) position. During welding, ABF QC Jim Cunningham was noted monitoring the welder and his welding parameters. At the end of the shift, welding was still continuing.

While welder Rory Hogan was welding on the excavated slag inclusion at the side plate 'C', welder Jeremy Dolman was noted preparing their welding equipment in preparation for the 4G FCAW-G welding of the back welding.



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