

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-013962**Date Inspected:** 07-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 Bonifacio Quijano			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.

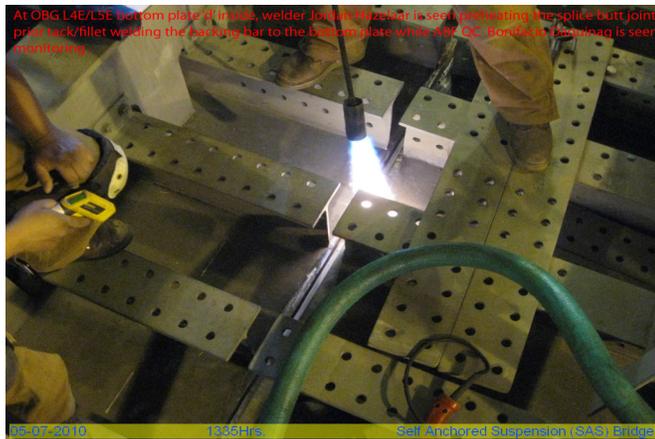
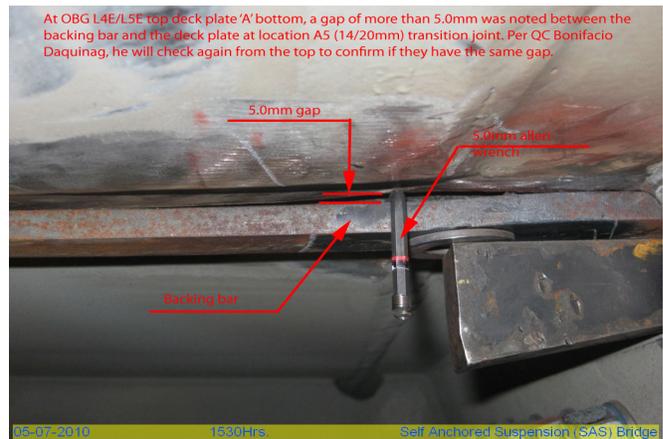
At OBG L3E/L4E side plate 'E' inside, QA randomly observed ABF/JV qualified welder Mitch Sittinger continue perform CJP groove welding repair. The welder was observed welding in the 3G (vertical) position utilizing Shielded metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1000-Repairs. The weld repairs were excavated to a boat shape. 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 six welding repair inside and was working on the seventh repair at the end of the shift.

QA randomly observed ABF/JV qualified welder Jordan Hazelaar perform tack welding backing bar to one side of the splice butt joint at OBG L4E/L5E bottom plate 'D' inside. The welder was using SMAW with 1/8" diameter E7018H4R electrode and implementing Caltrans approved welding procedure ABF-WPS-D15-F1200. Prior to welding, QA and ABF QC Bonifacio Daquinag performed a joint inspection of the butt joint fit up. The root gap was noted greater than 16mm wide minimum and 22mm wide maximum and the misalignment was noted 2.0mm maximum which appears in conformance to the contract requirements. During welding, ABF QC Bonifacio Daquinag was noted monitoring the welder and welding parameters.

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At OBG L4E/L5E top deck plate 'A' inside, QA randomly observed ABF welder Rick Clayborn perform fillet/tack welding temporary attachment U-bar fit up gear to the deck plate as an aid to the installation of the splice butt joint backing bar. The welder was using SMAW with 1/8" diameter E7018H4R electrode and implementing Caltrans approved welding procedure ABF-WPS-D15-F1200. The installation of the U-bar and the backing bar at the bottom of the deck plate was completed. QA and ABF QC Bonifacio Daquinag performed a joint visual inspection of the work and noted that majority of the backing bar seems good except for one area at the North side wherein the joint transition of the deck plate A5 (14/20mm) area was having more than 5.0mm gap to the deck plate measured from the inside. Though the fit up activity was still a work in progress, QC said that he will measure the actual gap from the top of the deck plate as soon as it is ready.



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.

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Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer