

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-013963**Date Inspected:** 10-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:** 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 L3E/L4E plate D1 to D2, two certified ABF welders Mitch Sittinger (ID #0315) and Jordan Hazelaar (ID #2135) were noted performing flat (1G) Submerged Arc Welding (SAW). The welders were utilizing F7A6-EM12K-H8, 3.2mm electrode with corresponding Esab OK Flux 10.62 flux and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-4042B-1. The plates were preheated to >150 degree Fahrenheit prior welding and the flux were preheated to 380 degree Fahrenheit before use. Welding parameters were monitored by ABF/QC Jim Cunningham. Parameters measured by the ABF QC during welding were 550 amperes, 31.0 volts and 381mm per minute travel speed. QA noted the welding parameters, the workmanship and appearance of the completed fill and cover passes satisfactory and were deemed acceptable to contract requirements. During the shift, the welders have completed welding the 6300mm length of the splice butt joint. The welders have repositioned their track mounted wire feeder/nozzle SAW machine and started welding the North side (1400mm long) where original position of the machine cannot reach. SAW welding at this location was not completed at the end of the shift and the welders will continue tomorrow.

At OBG L4E/L5E top deck plate 'A' outside, welding of the backing bar to both sides of the plates was seen complete. During the shift, three ABF personnel were noted grinding/cleaning the continuous tack weld from end to end of the splice butt joint in preparation for the Submerged Arc Welding to be performed to the joint. Both corners of the deck were also welded 5 inches to the top (deck plate "A") and 5 inches to the side (edge plate 'B')

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and 'F').



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