

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-013981**Date Inspected:** 13-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 'C' outside, QA randomly observed ABF/JV qualified welder Mitch Sittinger continue 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 and having various dimension of (1) 270mm long X 18mm wide X 13mm deep, (2) 185mm long X 17mm wide X 13mm deep and (3) 100mm long X 19mm wide X 14mm 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) using Parker Contour Probe and red magnetic powder as detecting media on the repair excavation. During the shift, the welder has completed three welding repairs outside and was noted flush grinding the repaired areas and fixing the temporary welding attachment removal.

At OBG L5E/L6E bottom plate 'D' inside, ABF welder Jordan Hazelaar was noted preparing his Submerged Arc Welding (SAW) equipment. At the outside of the same OBG plate, ABF personnel have installed the Miller Proheat 35 Induction Heating System located at the opposite side of the plate for preheating and maintenance prior/during welding. At the end of the shift, the preheating system was turned on but no welding has started yet.

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At OBG L5E/L6E top deck plate 'A' inside, ABF welder Rick Clayborn was observed installing the backing bar at the bottom of the plate in preparation for welding of the splice butt joint. During the installation, the welder was noted welding 'U-bar' temporary attachment using 1/8" diameter E7018H4R electrode and also pushing 2-wedges against the U-rib connection plate to put the backing bar in place. While the welder was installing the backing bar at the bottom of the deck plate, ABF QC Bonifacio Daquinag was also noted measuring the gap between the deck plate and backing bar. There were at least 14 locations found and marked by QC that have more than 2.0mm gap between the backing bar and the deck and so QC have asked the welder Rick Clayborn to adjust some more of the wedges/U-bar to minimize the gap. Installation of the backing bar was seen complete but still needs adjustment to get more acceptable readings.



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

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Reviewed By: Levell,Bill

QA Reviewer