

**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-014303**Date Inspected:** 19-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

<b>CWI Name:</b>	William Sherwood and Jesse Cayabyab			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	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 'C2' 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 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 with red magnetic powder as detecting media on the repair excavation. During the shift, the welder has completed five welding repairs inside and that should complete all the repair works on this splice butt joint inside and outside.

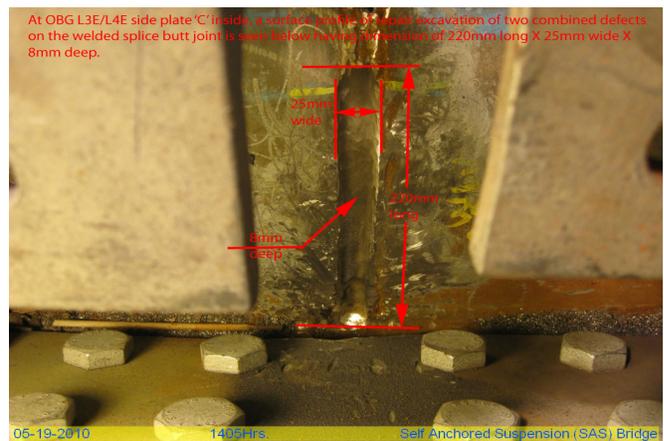
At OBG L4E/L5E top deck plate 'A' outside, QA randomly observed ABF/JV qualified welder Rick Clayborn ID # 2773 perform CJP groove welding repair. The welder was observed welding in the 1G (flat) position utilizing Shielded Metal Arc Welding (SMAW) with 5/32" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1000-Repairs. The repair excavations were preheated to more than 140 degree Fahrenheit using propane gas torch prior welding. During the shift, ABF QC Jesse Cayabyab was noted monitoring the welder. Prior welding, ABF QC Jesse Cayabyab was also observed performing Magnetic Particle Testing (MT) using Parker Contour Probe with red magnetic powder as detecting media on the repair excavation. During the shift, the

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

welder has completed three welding repairs and was working on the fourth repair at the end of the shift. While welding repair is being done on the deck plate, ABF QC Jesse Cayabyab and Tom Pasqualone were noted performing Ultrasonic Testing (UT) on area A1 and A2 of the same plate respectively. QC Tom Pasqualone informed this QA that as of now they have found a total 14 UT repairs for the areas that have been UT'd on this welded splice butt joint.

At L5E/L6E top deck plate 'A' outside, work activities in this location remain idle after the removal of the welded temporary jigs for porta lift/ram and performing Non Destructive Testing (Magnetic Particle Testing and UT/plate lamination check) by ABF QC on their removal. According to ABF QC Bonifacio Daquinag, ABF is waiting further information on the outcome of the unacceptable misalignment that was noted during fit up.



## 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.

---

---

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

<b>Inspected By:</b>	Lizardo, Joselito	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer