

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014681**Date Inspected:** 07-Jun-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:	Steven Mc Connell and Bonifacio			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 L5E/L68E top deck plate 'A' outside, QA randomly observed ABF/JV qualified welder Mitch Sittinger and Fred Kaddu perform CJP groove welding repair. The welders were observed welding in the 1G (flat) 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 Steven Mc Connell was noted monitoring the welder. Prior welding, ABF QC Steven Mc Connell was also observed performing Magnetic Particle Testing (MT) using Parker Contour Probe with red magnetic powder as detecting media on the repair excavation prior welding. During the shift, welder Fred Kaddu has completed two welding repairs at A5 and has moved inside L1E/L2E bottom plate 'D' inside while welder Mitch Sittinger has finished one repair at A1 and has moved to L1E/L2E bottom plate 'D' outside. Both welders were noted excavating more welding repairs until the end of the shift.

At OBG L1W/L2W side plate 'C' outside, QA randomly observed ABF/JV qualified welder James Zhen 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 repair excavation having a dimension of 90mm long X 20mm wide X 16mm deep was preheated to more than 140 degree Fahrenheit using propane gas torch prior welding. During the shift,

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ABF QC Bonifacio Daquinag was noted monitoring the welder. Prior welding, ABF QC Bonifacio Daquinag 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, while welder James Zhen was welding another welder Chun Fai Tsui was noted excavating the weld repairs to a boat shape and getting ready to be welded. The welder has completed two welding repair and was working on the third repair at the end of the shift.

At OBG L2W/L3W side plate 'C' outside, ABF welders Rory Hogan and Jeremy Dolman were observed on standby due to malfunctioning welding machine. Instead, they were noted fixing their welding machine and changing some of their welding equipment.

At OBG L3E/L4E bottom plate 'D' outside, QA observed two ABF welders Bryce Howell and Mike Maday continue perform plasma arc gouging on the backing bar. The welders were noted using an Esab plasma arc machine with the cutting nozzle mounted to a motorized track.



Summary of Conversations:

As stated above.

Comments

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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
