

**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-015166**Date Inspected:** 24-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

<b>CWI Name:</b>	Jim Cunningham and Bernie Docena			<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 L4E/L5E side plate 'C' (7400mm to 9855mm) inside, QA randomly observed ABF/JV qualified welder Sungtao, Huang ID # 3794 perform CJP groove (splice) welding root then fill pass. The welder was observed perform automatic welding in the 3G (vertical) position utilizing a dual shield Flux Cored Arc Welding (FCAW-G) with E71T-1M, 1/16" diameter wire electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042A-1. The joint being welded has a single V-groove butt joint with backing bar. The splice joint was preheated and maintained to greater than 200 degree Fahrenheit using Miller Proheat 35 Induction Heating System located at the opposite side of the plate prior/during welding. During welding, ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters of the welder. At the end of the shift, welding of the fill passes on the splice butt joint was not completed and should continue tomorrow.

QA randomly observed ABF/JV qualified welder Mitch Sittinger perform CJP groove (splice) back welding fill pass on Orthotropic Box Girder (OBG) L4E/L5E bottom plate 'D' outside. The welder was observed welding in the 4G (overhead) position utilizing a dual shield Flux Cored Arc Welding (FCAW-G) with E71T-1M, 1/16" diameter wire electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3040A-4. The welder was using a track mounted welder holder assembly that was remotely controlled. The joint being welded has the backing bar gouged using the Esab Plasma Arc machine and was

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ground smooth. The gouged and ground splice butt joint was also Non Destructive Testing (NDT) tested using the Magnetic Particle Testing (MT) which was performed and accepted by ABF QC Jim Cunningham. The splice joint was preheated to greater than 150 degree Fahrenheit prior welding and the vicinity was properly protected from wind and other deleterious environmental conditions. During welding, ABF Quality Control (QC) Jim Cunningham was noted monitoring the welding parameters of the welder. At the end of the shift, the fill pass welding of the splice butt joint back weld was not completed and should continue tomorrow.

At OBG L2W/L3W side plate 'E' inside, QA performed 100% visual on the completely welded cover reinforcement. The weld was noted having no surface profile defects such as undercut, underfill, excessive reinforcement etc. and it appears in compliance to the contract requirements.



## Summary of Conversations:

Since the welding of the splice butt joint at L4E/L5E side plate 'C' inside (7400mm to 10555mm) was not completed, QA reminded QC Bernie Docena to hold the preheat maintenance (>200 degree Fahrenheit) for three hours from the time the welder has stopped welding as required. QC agreed to this and informed this QA that he will talk to Superintendent Dan Ieraci to conform with this requirement.

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

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