

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016819**Date Inspected:** 14-Sep-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:	Tom Pasqualone and John Paglieri			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 6E/7E edge plate 'B' outside, QA randomly observed ABF/JV qualified welder James Zhen ID #6001 perform root pass welding on the Complete Joint Penetration (CJP) splice butt joint. The welder was observed manually welding in the 3G (vertical) position utilizing a Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040B. The joint being welded has a single V-groove butt joint with copper backing bar. The use of the 1" thick x 2" wide x 51" long (length of the joint) copper backing bar was earlier questioned by Lead QA Rick Bettencourt to ABF but still awaiting a formal response. Nevertheless, welding still continued and during welding, ABF Quality Control (QC) Tom Pasqualone was noted monitoring the welding parameters of the welder. QA randomly monitored the welding parameter with reading of 130 amperes which appears in conformance to the contract requirements. At the end of the shift, SMAW welding was still continuing and should remain tomorrow.

At OBG 6E/7E edge plate 'F' outside, QA randomly observed ABF/JV qualified welder Xiao Jian Wan ID #9677 perform root pass welding on the CJP splice butt joint. The welder was observed manually welding in the 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040B. The joint being welded has a single V-groove butt joint with backing bar. The use of the 1" thick x 2" wide x 51" long (the length of the joint) copper backing bar was earlier questioned by Lead QA Rick Bettencourt to ABF but still awaiting a

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formal response. Nevertheless, welding still continued and during welding, ABF Quality Control (QC) Tom Pasqualone was noted monitoring the welding parameters of the welder. QA randomly monitored the welding parameters with reading of 135 amperes which appears in conformance to the contract requirements.

At OBG 1E panel point PP10.5 south inside, QA randomly observed ABF welder Fred Kaddu perform 4G (overhead position) SMAW welding on the CJP of the butt joint of manhole cover to the top deck plate 'A'. The welder was using 1/8" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1030 Revision 1. The joint being welded had a single V-groove (around 60 degrees inclusive angle) butt joint without backing bar and 3.0mm root gap. The joint is being welded from one side and after its completion it will be back gouged from the other side and back welded. During welding, ABF Quality Control (QC) John Pagliero was noted monitoring the welding parameters of the welder. At the moment, the joint is only being welded overhead.

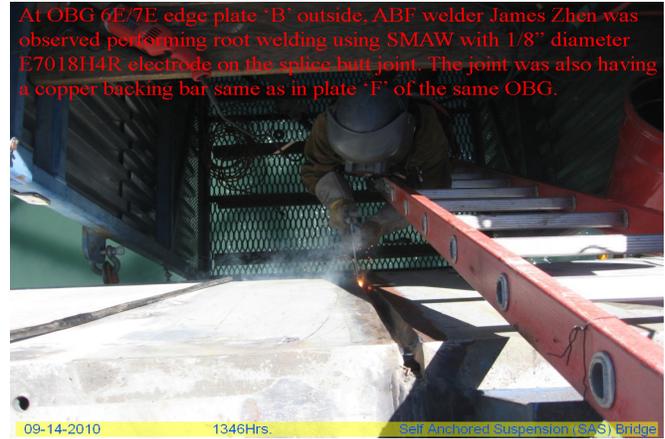
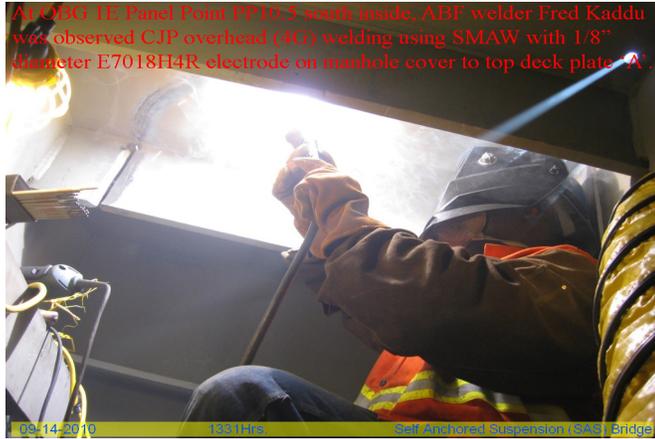
At OBG 4W/5W side plate 'E' outside, QA observed ABF QC Jesse Cayabyab perform Ultrasonic Testing (UT) on the welded splice butt joint. QC had not completed the UT on the whole length of the splice joint and should continue tomorrow. While this side of the plate was being UT'd, the other side of the plate 'C' weld cover reinforcement of the same OBG was still being flush ground as required. At the end of the shift, flush grinding of the weld cover reinforcement was still continuing and should continue tomorrow.

At OBG 6E/7E side plate 'C' outside, ABF/JV welder Rick Clayborn (I.D. 2773) performed the overhead (4F) fillet welding of the temporary attachment fitting gear to side plate 'C'. The welder was using Shielded Metal Arc Welding (SMAW) with 1/8" E7018 H4R electrode implementing Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. During welding, the welder was noted preheating the plates prior welding and ABF QC Bonifacio Daquinag was also noted monitoring the welding parameters.



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Summary of Conversations:

No significant conversation occurred today.

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) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer