

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-017612**Date Inspected:** 22-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

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|------------------------------------|--------------------------------|-----------|------------|----------------------------------|------------------------|-----------|------------|
| CWI Name: | Tom Pasqualone and William She | | | 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.

Today's weather was bad and it was raining at the bridge. Due to this weather condition, welding activities were limited except grinding, cutting and beveling on the following locations; Work hours for today was also shortened to just eight hours.

1. At OBG 6W/7W side plate 'E' outside, QA randomly observed ABF personnel Rory Hogan and Jeremy Dolman

perform plasma arc gouging on the backing bar removal of the splice butt joint. The personnel were using an Esab plasma arc gouging machine that has the nozzle holder attached to a Bug-o track. Gouging of the backing bar was not completed today and should continue on Monday.

2. At OBG 6W/7W edge plates 'B' and 'F' inside, ABF welder Songtao, Huang was observed grinding the welded

corner transition to side plates 'C' and 'E' respectively. After completing the grinding of the transition on the two corners, the welder was told to move to east bound OBG and prepare the welding equipment to weld the side plate at OBG 7E/8E.

3. At OBG 7W/8W bottom plate 'D' outside, QA observed ABF welder Kenneth Chappell perform grinding on

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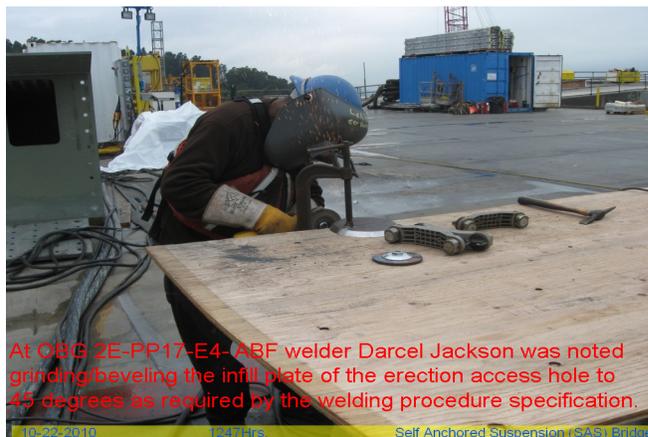
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the removal of fitting gear/temporary attachments. At the end of the shift, grinding was still continuing and should continue on Monday.

4. At 2E-PP17-E3- # 1-4 and 2E-PP17-E4- # 1-4 OBG lifting access holes outside, QA observed four ABF personnel perform grinding/beveling the infill plates to 45 degrees. All four personnel were using a 4 ½” disc grinder to make the bevel as required in the welding procedure specification. At the end of the shift, grinding of the plates’ bevel was still continuing and should remain Monday.

5. At 8W-PP70.5-W2-NE ventilation access hole outside, ABF welder Mike Maday was noted cutting the plate from the top deck plate. The welder was using oxi-acetylene cutting torch to cut the plate. At the end of the shift, cutting of the plate ventilation access hole was completed and grinding the edges should follow.

At OBG 2E-PP17-E3- ABF welders Rick Clayborn, Eric Sparks and Ian Smith were noted grinding/beveling the infill plate of the erection access holes to 45 degrees as required by the welding procedure specification.



At OBG 6W/7W side plate 'E' outside, ABF welders Rory Hogan and Jeremy Dolman were noted performing plasma arc gouging on the backing bar removal of the welded (from one side) splice butt joint.



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

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remedial efforts please contact SMR Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

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| Inspected By: | Lizardo, Joselito | Quality Assurance Inspector |
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| Reviewed By: | Levell, Bill | QA Reviewer |
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