

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-018432**Date Inspected:** 03-Dec-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**CWI Name:** Mike Johnson and Pat Swain**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.

The following lifting lug access access holes infill plate welding was observed;

1. At OBG 5E-PP31-E2#1 top deck plate outside – ABF welder Earl Espinosa was observed 1G SMAW welding fill to cover pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8” diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1070. During welding, ABF QC Pat Swain was noted monitoring the welder’s welding parameters. During the shift, cover pass welding on this location was completed and the welder has moved to a new access hole #3. The welder also welded fill pass using the same procedure mentioned above. At the end of the shift, fill pass welding was still continuing and should remain Monday.

2. At OBG 1W-PP8.5-E2#3 top deck plate inside - ABF welder Darcel Jackson was observed 4G SMAW back welding fill pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8” diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A. During welding, ABF QC Mike Johnson was noted monitoring the welder’s welding parameters. During the shift, fill pass welding on this location was still continuing and should remain tomorrow. At this same location but different hole (#1), ABF welder Rick Clayborn was noted back gouging the weld joint. The welder was using carbon air arc gouging and after completing the carbon arc, one ABF personnel started

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grinding the groove of the gouged area.

3. At OBG 1W-PP8.5-E4#1 top deck plate inside - ABF welder Mike Jimenez was observed 4G SMAW back welding fill pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A. During welding, ABF QC Mike Johnson was noted monitoring the welder's welding parameters. During the shift, fill pass welding on this location was still continuing which should remain Monday.

Other ventilation access holes at OBG 1W-PP10.5-W5-S and OBG 2W-PP13.5-W5-S, ABF welders Jin Pei Wang and Mick Chan were noted grinding the groove of the back gouged area of the butt joints respectively. The welders were noted using alternately the 4 1/2" disc grinder and die grinder on the joint during grinding.

This QA performed 10% MT verification at the following lifting lug access holes welded butt joints. Please see TL-6028 report for more information.

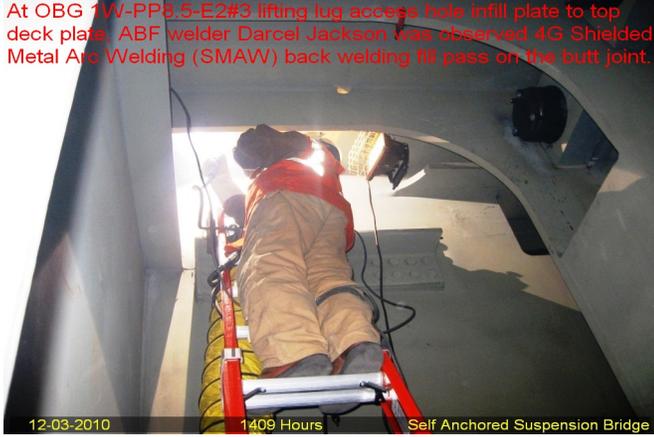
1. 1E-PP11-E4 #1, 2, 3 & 4 outside – no defects noted.
2. 2E-PP15-E3 #2, 3 & 4 outside – no defects noted. Hole no. 1 was noted with linear indication but was gone after grinding.
3. 2E-PP15-E4 #1, 2, 3 & 4 outside – no defects noted.
4. 2E-PP17-E3 #1, 2, 3 & 4 outside – no defects noted.
5. 2E-PP17-E4 #1, 2, 3 & 4 outside – no defects noted.
6. 3E-PP20-E4 #1, 2, 3 & 4 outside – no defects noted.



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At OBG 1W-PP8.5-E2#3 lifting lug access hole infill plate to top deck plate ABF welder Darcel Jackson was observed 4G Shielded Metal Arc Welding (SMAW) back welding fill pass on the butt joint.



At 2E-PF15-E3#1 lifting lug access hole infill plate to top deck plate butt joint a linear indication was noted during the Magnetic Particle Testing (MT) performed by QA.



Summary of Conversations:

No significant conversation 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 Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer