

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-018516**Date Inspected:** 07-Dec-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:	Mike Johnson and William Sherwood			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 1W-PP8.5-W5-#3 & #4 lifting lug access holes infill plate outside, QA randomly observed ABF welder Mike Jimenez perform Shielded Metal Arc Welding (SMAW) welding fill pass on the infill plate to top deck plate butt joint. The welder was noted welding alternately between the two access holes in 1G (flat) position using 1/8" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1070. During welding, ABF QC Mike Johnson was noted monitoring the welder's welding parameters. At the end of the shift, fill pass welding on both access holes were still continuing and should remain tomorrow.

At OBG 1W-PP10.5-W5-TS transverse stiffener, QA randomly observed ABF/JV qualified welder Jin Pei Wang manually welding the Complete Joint Penetration (CJP) transverse stiffener splice butt joint. The welder was noted welding fill pass to cover pass in the 3G (vertical) position utilizing a SMAW with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint with open root. During welding, ABF Quality Control (QC) Mike Johnson was noted monitoring the welding parameters of the welder. During the shift, SMAW cover pass welding on both sides of the splice butt joint was completed and the welder has moved to another location and started fitting up the ventilation access hole infill plate to deck plate at OBG 1W-PP10.5-W2-N. At the end of the shift, fit up of the infill plate was still ongoing and should remain tomorrow.

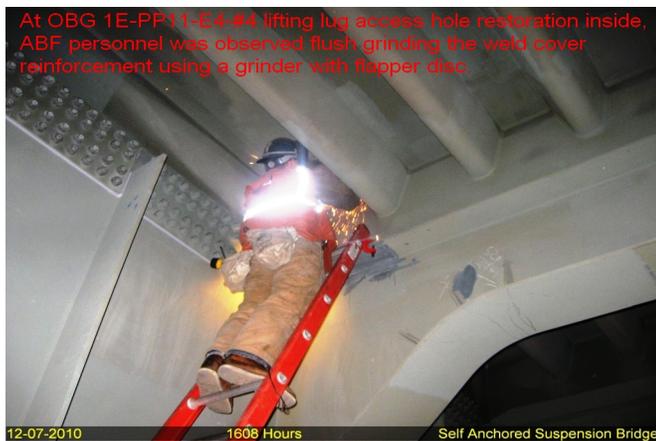
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At OBG 2W-PP13.5-W5-S deck access hole infill plate to top deck plate inside, QA noted ABF welder Mick Chan has completed grinding the groove of the gouged area. The welder has called ABF QC Mike Johnson who performed the Magnetic Particle Testing (MT) on the groove of the ground area. After the completion of MT, QA randomly observed ABF/JV qualified welder Mick Chan perform fill pass back welding on the CJP butt joint. The welder was observed manually welding in the 4G (overhead) position utilizing a SMAW with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint first welded with open root from the top deck. ABF Quality Control (QC) Mike Johnson 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 fill pass welding was still continuing and should remain tomorrow.

At OBG 7W/8W side plate inside (9655mm to 10555mm), QA randomly observed ABF/JV qualified welder Songtao, Huang manually welding the CJP splice butt joint. The welder was noted 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 location being welded has a double V-groove butt joint with backing bar with limited access to the Bug-o track mounted FCAW nozzle holder. During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. During the shift, SMAW cover pass welding on the splice butt joint was still continuing and should remain tomorrow.

At OBG 1E-PP11-E4-#1, 2, 3 & 4 bottom of welded lifting lug restoration, this QA verified the flush grinding/grinding cut orientation and smooth finish verification on these four welded infill plates upon the request of ABF Superintendent Mr. Scott Smith.



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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