

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-018590**Date Inspected:** 09-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:	William Sherwood and Mike Johnson			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-W4-#3 lifting lug access holes infill plate inside, QA randomly observed ABF welder Mike Jimenez perform Shielded Metal Arc Welding (SMAW) back welding cover pass on the infill plate to top deck plate butt joint. The welder was noted welding in 4G (overhead) position using 1/8" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110B. During welding, ABF QC Mike Johnson was noted monitoring the welder's welding parameters. At the end of the shift, cover pass welding on the location mentioned above was completed. After the welding completion, ABF QC Mike Johnson has requested this QA to verify the flush grinding/grinding cut orientation and smooth finish of the bottom side welding which this QA has concurred.

At OBG 6W-PP46.5-W5-S access hole infill plate to top deck plate outside, QA randomly observed ABF/JV qualified welder Jorge Lopez perform Complete Joint Penetration (CJP) groove fill pass welding. The welder was observed welding in the 1G (flat) position utilizing SMAW with 1/8" diameter E7018H4R electrode implementing Caltrans approved welding procedure ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint. ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. At the end of the shift, fill pass welding of the butt joint at location mentioned above was still continuing and should remain tomorrow.

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At 2W-PP13.5-W5-TS top deck ventilation access hole, QA randomly observed ABF/JV qualified welder Mick Chan was observed manually welding on the (CJP) transverse stiffener splice butt joint 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. During welding, ABF Quality Control (QC) John Pagliero was also 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 started flush grinding the weld covers. Flush grinding of the weld cover reinforcement was also completed during the shift.

At OBG 4W-PP24.5-W5-S deck access hole inside, QA randomly observed ABF/JV qualified welder Han Wen Yu 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 WPS ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint welded with open root from the top deck. ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. Prior welding, QA observed QC William Sherwood perform MT on the ground groove of the joint. At the end of the shift, SMAW fill pass welding was still ongoing and should continue tomorrow.

At OBG 3W-PP23.5-W2-N deck access hole inside, QA randomly observed ABF/JV qualified welder Kenneth Chappell 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 WPS ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint welded with open root from the top deck. ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. At the end of the shift, SMAW fill pass welding was still continuing and should remain tomorrow.

At OBG 1W-PP10.5-W2-TS top deck ventilation access hole inside, QA noted ABF/JV qualified welder Jin Pei Wang ID #2930 has completely welded the CJP transverse stiffener splice butt joint. After completing the transverse stiffener butt joint, the welder has started welding the root pass of the deck access hole infill plate to top deck plate at the same access hole. The welder was observed manually welding in the 4G (overhead) position utilizing a SMAW with 1/8" diameter E7018H4R electrode and implementing Caltrans approved WPS ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint. During welding, ABF Quality Control (QC) William Sherwood was also noted monitoring the welding parameters of the welder. During the shift, SMAW root pass welding underneath the butt joint was still continuing and remain tomorrow.

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

1. OBG 6W/7W edge plate 'F' inside - no defects noted.
2. OBG 1W-PP8.5-4W #1, & 2 outside – no defects noted.
3. OBG 1W-PP8.5-5W #1, & 2 outside – no defects noted.

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At OBG 1W-PP8.5-W4-#3 lifting lug access hole infill plate to top deck plate inside, ABF welder Mike Jimenez was observed 4G Shielded Metal Arc Welding (SMAW) back welding fill pass on the butt joint.



At OBG 6W PP46.5-W5-S deck access hole infill plate to top deck plate outside, ABF welder Jorge Lopez was observed Shielded Metal Arc Welding (SMAW) welding fill pass on the butt joint.



At OBG 1W-PP10.5-W2-N deck access hole infill plate to top deck plate inside, ABF welder Jin Pei Wang was observed 4G Shielded Metal Arc Welding (SMAW) welding root pass on the butt joint.



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