

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-018724**Date Inspected:** 16-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.

The following deck access hole infill plate to top deck plate welding was observed;

1. At OBG 1W-PP10.5-W2-N inside – ABF welder Jin Pei Wang was noted completely back welded the butt joint from the inside. He is now grinding/cleaning the weld in preparation for the inspection.
2. At OBG 4W-PP24-W5-S outside - ABF welder Han Wen Yu was observed continuing to perform 4G Shielded Metal Arc Welding (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. At the end of the shift, fill pass welding was still in progress and should continue tomorrow.
3. At OBG 2W-PP13.5-W5-S inside – ABF welder Mick Chan was observed continuing to perform 4G Shielded Metal Arc Welding (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. At the end of the shift, fill pass welding was still in progress and should continue tomorrow.
4. At OBG 8W-PP70.5-W5-S outside - ABF welder Jorge Lopez was observed 1G Shielded Metal Arc Welding (SMAW) welding fill pass on the infill plate to top deck plate. The welder was noted using 5/32" diameter

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E7018H4R electrode. At the end of the shift, fill pass welding on this location was still continuing which should remain tomorrow.

The welders working on the deck access hole mentioned above were noted welding/implementing Caltrans approved welding procedure specification ABF-WPS-D15-1010 Revision 1. All welders and their welding parameters were also monitored by ABF QC William Sherwood.

At OBG 1W-PP9.5-W4-#3 & #4 lifting lug access infill plate to top deck plate outside, ABF welder Mike Jimenez was observed continuing to perform 1G SMAW welding fill pass on the infill plate to top deck plate butt joint. The joint being welded has a 45 degrees single bevel groove joint with copper backing plate. The welder was noted using 5/32" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1070. ABF QC Mike Johnson was noted monitoring the welder's welding parameters. During the shift after welding several fill passes at the joint, the welder has left the area and has moved to 1W-PP8.5-W4-#3 & #4 and welded fill to cover pass. At the end of the shift, cover pass welding on this location was still continuing which should remain tomorrow.

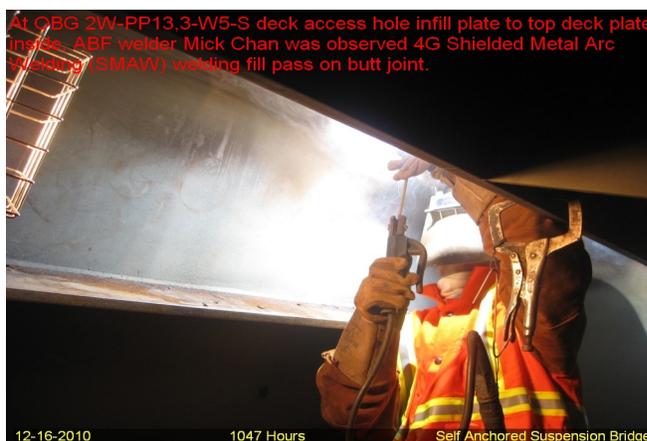
At OBG 1W-PP11-W3-#2 & #1 lifting lug access infill plate to top deck plate outside, ABF welder Darcel Jackson was observed continuing to perform 1G SMAW welding fill pass on the infill plate to top deck plate butt joint. The joint being welded has a 45 degrees single bevel groove joint with copper backing plate. The welder was noted alternately welding the two access holes using 3/16" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1070. ABF QC Mike Johnson was noted monitoring the welder's welding parameters. At the end of the shift, fill pass welding on this location was still ongoing and should continue tomorrow.

At OBG 6E/7E LS4, LS5 & LS6 longitudinal stiffeners inside, this QA performed 10% MT verification on the welded splice butt joint. QA found no defects during the verification. Please see TL-6028 report for more information.



At OBG 4W-PP24-W5-S deck access hole infill plate to top deck plate ABF welder Han Wan Yu was noted grinding/cleaning his weld pass during the welding process.

12-16-2010 1038 Hours Self Anchored Suspension Bridge



At OBG 2W-PP13,3-W5-S deck access hole infill plate to top deck plate inside ABF welder Mick Chan was observed 4G Shielded Metal Arc Welding (SMAW) welding fill pass on butt joint.

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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 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
