

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-018725**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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. Due to continuous rain that was experienced at the job site, welding activities were minimal and most of the welders were noted inside the OBG.

1. At OBG 4W-PP24-W5-S inside - ABF welder Han Wen Yu was noted grinding/cleaning the back welded butt joint in preparation for inspection.
2. At OBG 2W-PP13.5-W5-S inside – ABF welder Mick Chan was noted grinding/cleaning the back welded butt joint in preparation for inspection.
3. At OBG 8W-PP61.5-W5-S inside – ABF personnel was noted grinding the groove of the gouged area of the welded butt joint.
4. At OBG 6W-PP46.5-W5-S inside - ABF welder Jorge Lopez was observed preparing to perform 4G Shielded Metal Arc Welding (SMAW) back welding fill pass on the infill plate to top deck plate. The welder was noted covering the weld outside and placed a diverter to keep the rain water from going to the weld joint while welding. The welder was all prepared to weld but due to inadequate ventilation inside he was not able to fire up.

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At OBG 1W-PP11-W4-#1 lifting lug access infill plate to top deck plate inside, ABF welder Mike Jimenez was observed back gouging the welded butt joint using carbon air arc gouging. After gouging, the welder performed the grinding. ABF QC William Sherwood performed the Magnetic Particle Testing (MT) on the ground back gouging. The welder was observed 4G SMAW back welding fill pass on the infill plate to top deck plate butt joint after the completion of MT. The welder was noted using 5/32" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A. ABF QC William Sherwood was noted monitoring the welder's welding parameters. During the shift, back welding of the joint was completed and QC performed the visual inspection and accepted the joint. QA also performed verification on the completed joint and noted in compliance to the contract requirements.

At OBG 1W-PP11-W3-#2 and OBG 5E-PP31-E3-#2 lifting lug access infill plate to top deck plate inside, ABF welders Darcel Jackson and Salvador Sandoval were observed back gouging the welded butt joints using carbon air arc gouging respectively.

At OBG 1W-PP8.5-W3 inside, ABF welder Eric Sparks was observed performing/cutting the lifting lug #4. The welder was using oxy-acetylene gas torch during cutting. ABF QC William Sherwood was noted monitoring the cutting process.



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