

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-018906**Date Inspected:** 23-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Fred Von Hoff and Gary Ersham			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 7E/8E side plate 'C' inside, QA randomly observed ABF/JV qualified welder Fred Kaddu ID # 2188 continuing to perform CJP groove welding repair. The welder was observed welding in the 3G (vertical) position utilizing Shielded metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1001-Repairs. The boat shape repair excavations having various dimensions were preheated to more than 140 degree Fahrenheit using propane gas torch prior welding. During the shift, ABF QC Fred Von Hoff was noted monitoring the welder. Prior welding, ABF QC John Pagliero was also observed performing Magnetic Particle Testing (MT). There were no defects noted during the test. The following first time repairs were noted excavated and completely welded at the end of the shift;

Location	Y-dimension	Length	Depth	Remarks
1. C1	4060mm	100mm	10mm	Completed
2. C2	420mm	80mm	12mm	Completed
3. C2	1850mm	80mm	11mm	Completed

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

1. At OBG 3W-PP23.5-W2-N inside – ABF welder Jin Pei Wang was observed continuing to perform 4G

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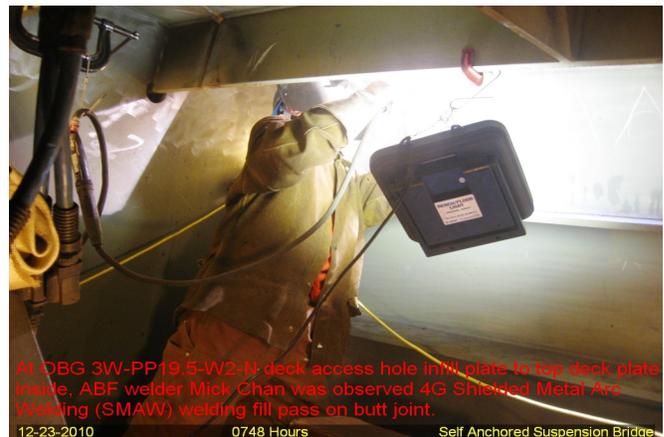
Shielded Metal Arc Welding (SMAW) back welding fill pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8" diameter E7018H4R electrode. At the end of the shift, fill pass welding was still in progress and should continue tomorrow.

2. At OBG 3W-PP19.5-W5-S inside - 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 3W-PP19.5-W2-N 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 3W-PP61.5-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 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 Gary Ersham.



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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