

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019170**Date Inspected:** 03-Jan-2011**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:	Gary Ersham 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 holes (DAH) and lifting lug access holes (LLAH) infill plate to top deck plate welding activities were observed;

- At OBG 8W-PP70.5-W5-SE (DAH) inside – ABF welder Jorge Lopez 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.
- At OBG 3W-PP19.5-W2-N (DAH) inside - ABF welder Jin Pei Wang was observed continuing to perform flush grinding on the welded butt joint in preparation for the visual inspection and Non-destructive Testing.
- At OBG 3W-PP19.5-W5-S (DAH) inside – ABF welder Han Wen Yu was observed continuing to perform flush grinding on the welded butt joint in preparation for the visual inspection and Non-destructive Testing.
- At OBG 1W-PP11-W4-#4 (LLAH) inside - ABF welder Mike Jimenez was observed back gouging the welded butt joint using carbon arc then ground smooth for Magnetic Particle Testing (MT) and back welding. After the completion of MT, the welder was observed 4G SMAW welding fill to cover pass on butt joint. The welder was

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

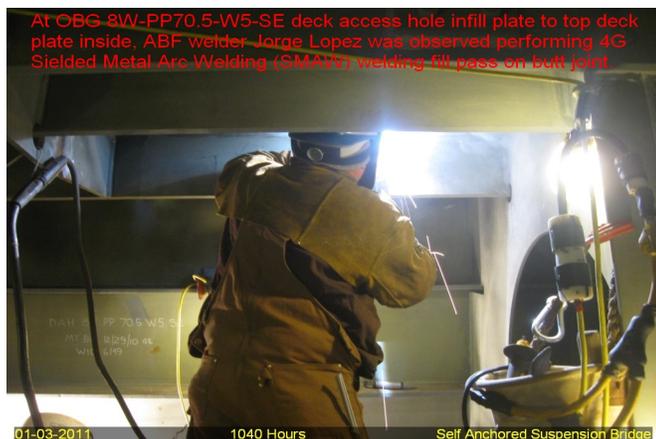
noted using 1/8" diameter E7018H4R electrode. At the end of the shift, fill and cover pass welding on this location was completed.

5. At OBG 1W-PP11-W3-#1 to #4 (LLAH) outside – ABF welder Darcel Jackson was observed 1G SMAW welding cover pass on four LLAH to top deck plate butt joints. After their completion, the welder has moved to 1W-PP9.5-W3-#2 and #4 (LLAH) and continued welding fill pass where these two access holes were previously/partly welded but were not completed. At the end of the shift, LLAH #4 was completed and # 2 was still in progress.

The welders working on the deck access holes mentioned above were noted welding/implementing Caltrans approved welding procedure specification ABF-WPS-D15-1010 Revision 1 for the DAH and ABF-WPS-D15-1070 & ABF-WPS-D15-1110A for the LLAH. The welders and their welding parameters for DAH were monitored by ABF QC Gary Ersham while the welders for the LLAH were monitored by ABF QC Mike Johnson.

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

1. OBG 4E-PP25-E3-#1 to #4 lifting lug access hole restoration outside – no defects noted.
2. OBG 4E-PP27-E3-#1, #3 & #4 lifting lug access hole restoration outside – no defects noted.
3. OBG 1W-PP11-W4- #4 lifting lug access hole restoration inside – no defects noted.
4. OBG 6W/7W side plate 'E' inside – no defects noted.



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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer