

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-019218**Date Inspected:** 08-Jan-2011**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:	Gary Ershan 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 lifting lug access hole (LLAH) infill plate to top deck plate welding activities was observed;

1. At OBG 2W-PP17-W4- #1 outside – ABF welder Mike Jimenez was observed continuing to perform 1G Shielded Metal Arc Welding (SMAW) back welding fill pass on the infill plate to top deck plate butt joint. The welder was noted using 5/32” diameter E7018H4R electrode. During the shift, fill pass welding was completed and the welder has moved to #3 LLAH of the same location and performed fit up/ tack welding of the infill plate to top deck plate. After the completion of the fit up, ABF QC Mike Johnson verified the alignment acceptable. QA has concurred the fit up alignment and the welder welded the root pass and followed by fill to cover pass. The welder was noted using 1/8” diameter E7018H4R electrode during the root pass and 5/32” diameter during fill to cover pass. This hole location was also completed and the welder has moved to new location OBG 3W-PP20-W4 #1 where he performed the same tasks as previously mentioned. At the end of the shift, the welder was still continuing to weld fill pass on the butt joint which should remain Monday.

2. At OBG 3W-PP22-W3- #1 and #2 outside - ABF welder Darcel Jackson was observed fit up/tack welding the infill plate to top deck plate. After the completion of the fit up, ABF QC Mike Johnson verified the alignment acceptable. QA has concurred the fit up alignment and the welder welded the root pass and followed by fill to cover pass. The welder was noted using 1/8” diameter E7018H4R electrode during root pass welding and used 3/16” diameter E7018H4R electrode during fill and cover pass welding. After completing the two LLAH, the

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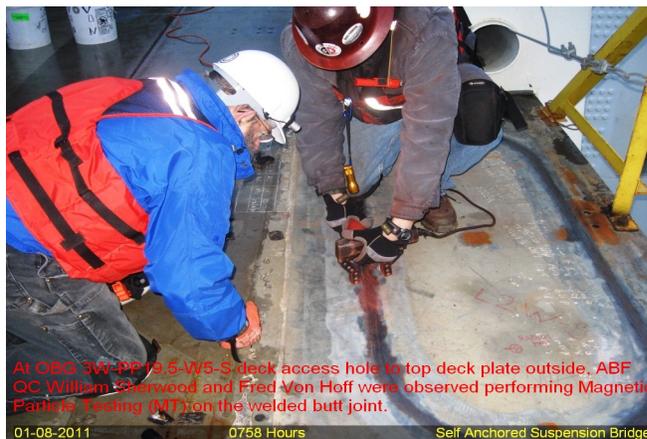
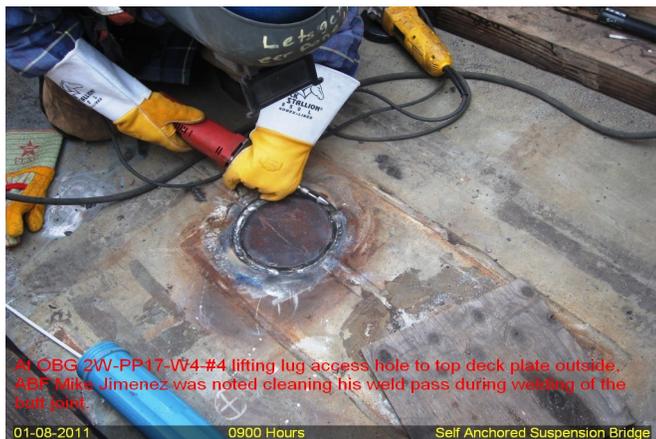
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welder has continued welding fill pass on holes #3 and #4 where they partly welded but not completed. These two LLAH were also completed during the shift and the welder has moved and set up to the new location 3W-PP25-W3 #1 to 4.

The two welders working on the lifting lug access hole (LLAH) mentioned above were noted welding/implementing Caltrans approved welding procedure specification ABF-WPS-D15-1070. The welders and their welding parameters were monitored by ABF QC Mike Johnson.

This QA performed 10% MT verification at the following deck access hole restoration welded butt joints. Please see TL-6028 report for more information.

1. OBG 8W-PP70.5-W5-S deck access hole restoration outside – no defects noted.
2. OBG 4W-PP24.5-W5-S deck access hole restoration outside – no defects noted.
3. OBG 3W-PP23.5-W2-NE deck access hole restoration outside – no defects noted.
4. OBG 3W-PP19.5-W5-S deck access hole restoration outside – no defects noted.



Summary of Conversations:

At OBG 8W/9W top deck plate 'A' outside where welding repairs were made yesterday, a portable electrode oven almost full of E7018H4R electrode was noted cold and left unplugged with the power supply. ABF QC Gary Ersham was informed about this incident and he immediately discarded all the electrodes in question.

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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
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Reviewed By:	Levell, Bill	QA Reviewer
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