

**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-019377**Date Inspected:** 18-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 2130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 230**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

**CWI Name:** Mike Johnson  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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:**

This Quality Assurance Inspector (QAI) was present at the Self Anchored Suspension (SAS) job site. The following items were observed;

Quality assurance inspector (QAI) arrived on site at 2130 hours and met with QAI Joselito Lizardo who reported that stress relief of cable jacking-saddle field fillet weld was in progress. Four heating units were being utilized and 3 had reached the required temperature of 1,100 degrees Fahrenheit. The fourth unit had been replaced and was continuing heating.

QAI noted that stress relief was being performed by Mr. John Callahan and Mr. Dan Jones of ABF joint venture and witnessed by QC Mr. Mike Johnson.

All four heating units reached the required 1,100° F, + or - 75° F at 2225 hours. At this time the 3 hour soak cycle was started. At 2300 hours this QAI observed that one machine was losing heat (dropping from 1,100° to 1,020° F). This was brought to the attention of Mr. Jones who immediately corrected the machine settings to maintain 1,100° F.

At 0125 hours the soak time was completed at the four heating units were set to cool at a rate of 450° F. After 30 minutes, QAI noted that one heating unit had cooled 300° F. This was brought to the attention of Mr. Callahan who stated this was not an issue as long as cooling did not exceed 500° F after one hour. After one hour of cooling the temperature registered for each heating unit was as follows. # 1 - 805° F, # 2 - 786° F, # 3 - 717° F and 760° F for an average cooling rate of 333° F. Mr. Callahan reported that the cable jacking-saddle field fillet weld would

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be allowed to cool at the current rate until all four heating units registered 600° F, at which time the units would be shut off and cooling in still air would continue.



## Summary of Conversations:

As noted above.

## 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 Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lanz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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