

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-021492**Date Inspected:** 05-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve Mc Connell**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.

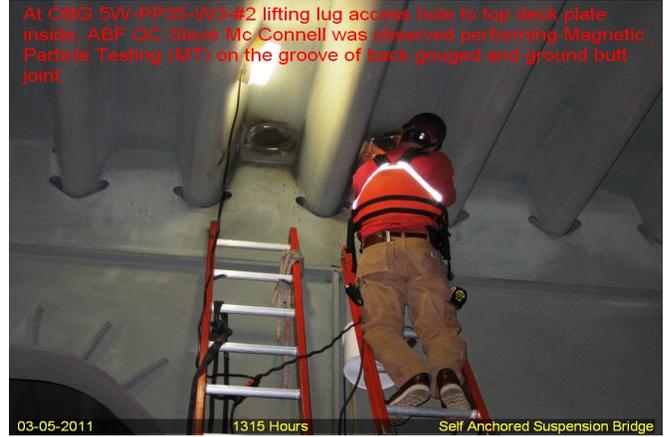
At OBG 5W-PP35-W3-#1 & 3 lifting lug access hole to top deck plate inside - ABF welder Darcel Jackson was observed perform 4G SMAW back welding fill pass to cover pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A. During welding, ABF QC Steve Mc Connell was noted monitoring the welder's welding parameters. During the shift, cover pass welding on this location was completed and the welder flush ground the cover reinforcement of the weld joint. After the completion of the grinding, the welder called QC for the inspection of the weld cover flush grinding. QA noted QC performed the inspection and accepted them. QA performed the visual test (VT) verification of the flush ground cover of the weld joint. During the verification, the flush grinding of the weld cover was noted smooth and the grinding cut of the flush grinding was parallel to the direction of the bridge as required.

After the acceptance of the two lifting lug holes, the welder has moved to lifting lug holes number 2 and 4 of the same location. In here, the welder performed back gouging using carbon air arc and smooth grinding of the groove after gouging. QA noted ABF QC perform Magnetic Particle Testing (MT) on the groove surface of the back gouged and ground butt joints. QC found no indications during the test and the welder resumed welding. The welder has completed back welding fill pass to cover pass of the lifting lug holes # 2 & 4 and was flush grinding the weld cover reinforcement when the shift has ended.

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The welder was also scheduled to perform welding on the shear tab of the newly installed OBG 11W but was cancelled due to limited time.



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
