

**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-023737**Date Inspected:** 17-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve Jensen**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:** SAS Tower**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 Tower West Shaft Splice #1 @Elevation 50.3meters:

At Northwest (C-D) corner, lower splice plate; this QA Inspector randomly observed ABF welding personnel Salvador Sandoval (#2202) continuing to perform production welding on the top half of the splice plate using the self shielded Flux Cored Arc Welding (FCAW) process. This QA Inspector observed a propylene gas torch was being used to preheat areas prior to welding. This QA Inspector observed QC Inspector Steve Jensen using an infra red temperature gauge to verify the preheat temperature of more than 300°F. This QA Inspector performed a verification of the welding parameters and observed 270 amperes and 22.0 volts with a travel speed of 100 mm per minute with equivalent heat input of 3.56 KJ per mm. The welding appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-3. The welder continued fill pass fillet welding on both sides of the plate until 1000hours when some of the Tower splice joints were seeping water near the interior closure corner and ABF Superintendent Scott Smith has shut down his welding crew. After the first break at around 1015hours, the welder has stopped fillet welding and ABF personnel were noted covering the weld with heater blanket in preparation for the three hours holding of preheat temperature of more than 300°F as required. ABF personnel were using Miller Proheat 35 Induction Heating System to hold the preheat that was programmed to shut off after three hours.

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At Tower West Shaft Splice #1 @Elevation 50.3 meters:

At West (B-C) corner, lower splice plate; This QA Inspector randomly observed ABF welding personnel Morgan Winters continuing to perform production welding on the bottom half of the lower splice plate using the self shielded Flux Cored Arc Welding (FCAW) process. This QA Inspector observed ABF personnel using a propylene gas torch on areas prior to welding. This QA Inspector observed QC Inspector Steve Jensen using a Fluke infra red temperature gauge to verify the preheat temperature of more than 300°F. This QA Inspector performed a verification of the welding parameters and observed 258 amperes and 21.6 volts with a travel speed of 95 mm per minute with equivalent heat input of 3.52 Kj per mm. The welding appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-3. The welder continued fill pass fillet welding on both sides of the plate until 1000 hours when some of the Tower splice joints were seeping water near the interior closure corner and ABF Superintendent Scott Smith has shut down his welding crew. The water seepage was close to the joint where this welder was welding. After the first break at around 1015 hours, ABF personnel were noted covering the welds with heater blanket in preparation for the three hours holding of preheat temperature of more than 300°F as required. ABF personnel were using Miller Proheat 35 Induction Heating System to hold the preheat that was programmed to shut off after three hours.

At Tower North Shaft Splice #1 @Elevation 50.3meters:

At North (C-D) corner, lower splice plate; This QA Inspector randomly observed ABF welding personnel Rick Clayborn perform production welding on the bottom half of the lower splice plate using the self shielded Flux Cored Arc Welding (FCAW) process. This QA Inspector observed ABF personnel using a propylene gas torch on areas prior to welding. This QA Inspector observed QC Inspector Steve Jensen using a Fluke infra red temperature gauge to verify the preheat temperature of more than 300°F. This QA Inspector performed a verification of the welding parameters and observed 273 amperes and 22.1 volts with a travel speed of 85 mm per minute with equivalent heat input of 3.56 Kj per mm. The welding appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-3. The welder continued fill pass fillet welding on both sides of the plate until 1000 hours when some of the Tower splice joints were seeping water near the interior closure corner and ABF Superintendent Scott Smith has shut down his welding crew. After the first break at around 1015hours, ABF personnel were noted covering the welds with heater blanket in preparation for the three hours holding of preheat temperature of more than 300°F as required. ABF personnel were using Miller Proheat 35 Induction Heating System to hold the preheat that was programmed to shut off after three hours.

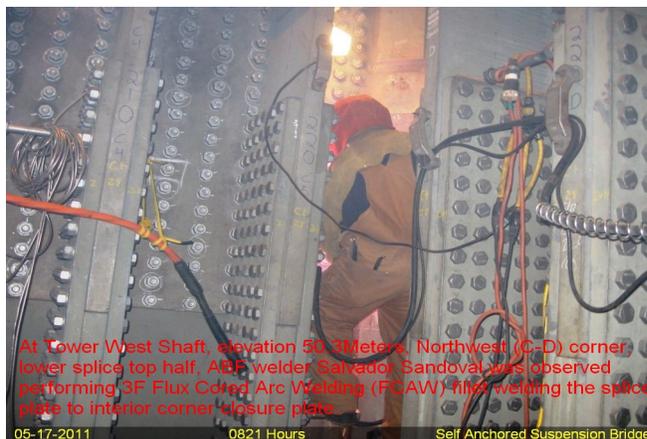
This QA updated various charts and summaries of QA tracking logs at the job site. That also includes reviewing of Welding Procedure Specifications on files and updating of pending reports.

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## Summary of Conversations:

It was rainy day today and water seepage was going through the tower splice joints that were noted in one of the splice joint that was being welded. Due to the bad weather condition and this incident, ABF Superintendent Scott Smith has shut down the tower splice welding at 1100 hours.

## 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.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer

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