

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-024757**Date Inspected:** 28-Jun-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: Jesse Cayabyab
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:** 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 Base Elevation 13Meters Shear Plate Electro Slag Welding (ESW);

After the electro slag welding (ESW) completion of the transition weld joint N-042 at location 'J', ABF personnel were noted continuing to dismantle the Hilti MI-90 strut column and its brackets that were used to hold the water cooled weld shoes during welding and so with the access ladders. ABF personnel were noted preparing access ladders for the next new location at weld joint N-043 location 'P' which is tentatively scheduled to be welded Wednesday June 29, 2011. ABF welders Jeremy Dolman and Richard Garcia were noted tack welding brackets to the tower skin plate and shear plate to hold the access ladder in place. The welders were noted using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and the plates were preheated to more than 225°F prior tack welding. ABF QC Jesse Cayabyab was noted monitoring the welders during the shift.

At Tower Base Elevation 13Meters Shear Plate Electro Slag Welding (ESW);

This QA together with ABF QC Jesse Cayabyab performed a joint fit up inspection/verification on the alignment of the 80-100mm transition butt joint E-043 at location 'Q' in preparation for the next ESW that is scheduled tomorrow. The root gap and offset were measured from bottom to top. The result noted on the offset verification was less than 3.0mm on most of the part except on the following which has exceeded the maximum allowed;

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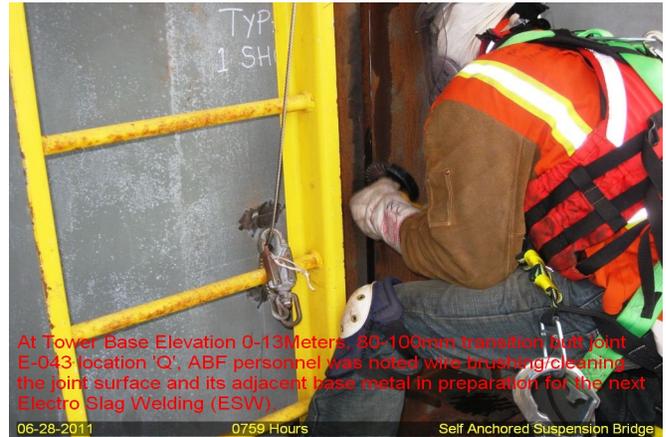
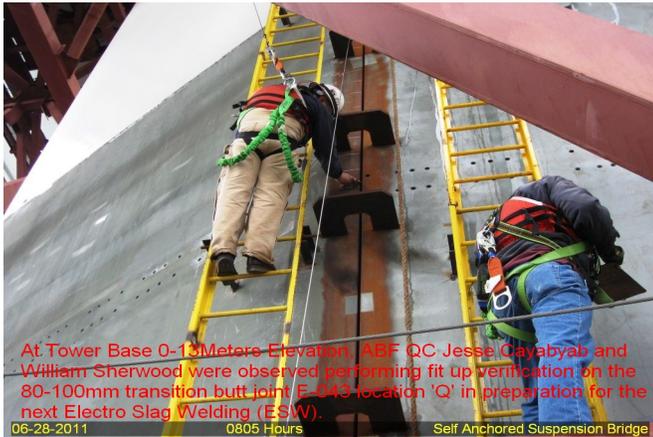
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Y-location Offset/Misalignment Length
5100mm to 9780mm 6mm 4680mm
4640mm to 5100mm 4mm 460mm
2030mm to 4640mm 2mm 2610mm

The root gap measured was 16mm minimum and 25mm maximum which appears in compliance to the approved WPS.

The weather at the job site today was bad with heavy rain. Due to this weather condition, all the ABF personnel at the job site were sent home at 1100hours.

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.



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