

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-024925**Date Inspected:** 01-Jul-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);

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 N-043 at location 'P' in preparation for the next ESW that was scheduled to be welded Tuesday July 5, 2011. 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 have exceeded the maximum allowed;

Y-location	Offset	Length
8350mm to 8800mm	2mm	450mm
7830mm to 8350mm	5mm	520mm
3770mm to 7830mm	6mm	4060mm
3330mm to 3770mm	7mm	440mm
2670mm to 3330mm	6mm	660mm
2500mm to 2670mm	5mm	170mm
1800mm to 2500mm	2mm	630mm

WELDING INSPECTION REPORT

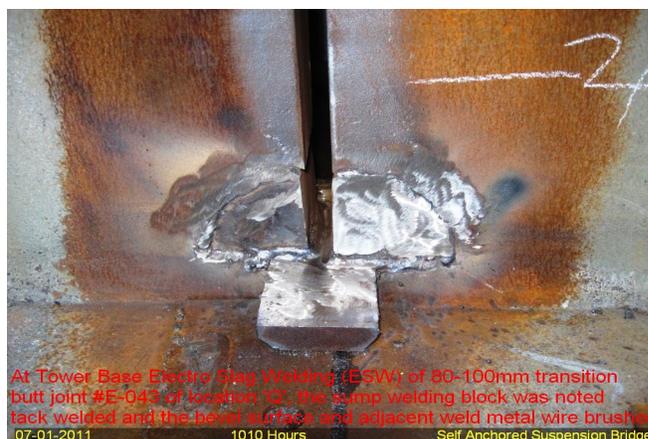
(Continued Page 2 of 2)

The root gap measured was 16mm minimum and 19mm maximum which appears in compliance to the approved WPS.

ABF personnel were noted preparing the Hilti MI-90 strut column and its brackets that will hold the weld shoe in place and access ladders for the next new location at 80-100mm transition butt weld joint E-043 location 'Q' which is tentatively scheduled to be welded Thursday June 30, 2011. ABF welder Jeremy Dolman was noted tack welding the run off tab at the top of the joint. The welder was 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. Other welding related activity noted was the cleaning/wire wheeling of the bevel surface and its adjacent weld metal.

Today at the job site, ABF has cut short the work schedule of its personnel to four hours due to the forthcoming July 4th Independence Day Holiday.

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