

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-025078**Date Inspected:** 09-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:	Mike Johnson and Steve Mc Conn			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 Base Elevation 13Meters Shear Plate Electro Slag Welding (ESW);

This QA was present at the Tower Base to observe the Electro Slag Welding of the weld number W-042 located at 'M' position per ABF weld map. The weld joint to be welded is a 60mm shear plate to Tower West Shaft skin plate (70mm) 'A', T-joint located at the corner of Tower West shaft skin plates 'A' and 'B'. ABF intends to implement Caltrans approved welding procedure ABF-WPS-ESW-150T in performing the ESW.

Upon QA's arrival, ABF personnel were noted preparing to weld the shear plate butt joint by checking all the necessary electrical and water hose weld shoe cooling connections are all in place prior to commence ESW. It was noted that three weld shoes were in position at each opposing side of the joint and so with the consumable guide tube that was placed in between the joint gap which was separated by consumable ceramic insulators. Other ABF personnel that were noted assisting the preparation of the ESW include ABF Production Manager John Callaghan and ABF Engineer Daniel Hester.

The fit up alignment was previously checked by ABF QC Jesse Cayabyab and this QA. The root gap was measured from bottom to top and the result noted was 17mm minimum and 23mm maximum which deemed in compliance to the WPS.

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At 1020hours, ABF Operations Superintendent Dan Ieraci and ABF QC Mike Johnson performed the check list verification and noted it was all OK.

At 1026hours, all ABF personnel involved in the ESW converged and performed a pre-operations meeting reminding each and everyone's role in performing their job. After the meeting, each personnel went to their own respective assignment and positioned themselves and got ready for the start. Just After the meeting from 1026hours to 1047hours, there were two power outages that occurred to the job site due to unknown reason.

Initial firing of the ESW has started at 1059 hours but just barely one minute welding the power went down again but recovered few seconds later and continued until the completion of the joint at around 1514 hours. During the course of the ESW, this QA went down to the bottom of the weld sump and checked the status of the weld that was performed during the power outage. It appeared that the ESW was still at the weld sump when the power outage has occurred.



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

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for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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