

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-025253**Date Inspected:** 20-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Steve Jensen and 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:	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.

ABF QC Steve Mc Connell and this QA performed a joint fit up verification on the Electro Slag Welding (ESW) T- joint W-041 at location 'W' which is scheduled to be welded Friday, July 22, 2011. The measured root gap was noted 20.5mm minimum and 25mm maximum. There was no lesser than 16mm nor more than 25mm root gap noted from the bottom to the top of the T-joint. With the measurements that were taken during the fit up verification, the fit up of the weld T- joint was deemed in compliance to the contract requirements.

At OBG 11W/12W edge plate 'F' inside, QA randomly observed ABF/JV qualified welder Fred Kaddu ID # 2188 perform CJP groove welding repair. The welder was observed welding in the 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1000-Repairs. The repair excavation located at Y=660mm and having dimensions of 90mm long x 20mm wide x 8mm deep was preheated to more than 140 degree Fahrenheit using propylene gas torch prior welding. During the shift, ABF QC John Pagliero was noted monitoring the welder. Prior welding, ABF QC John Pagliero was also observed performing Magnetic Particle Testing (MT) on the repair excavation. There were no significant defects noted during the test. After the completion of the MT, the welder started welding the repair and completed it during the shift.

At OBG 10E/11E side plate 'E' outside, ABF personnel were noted removing/grinding off temporary attachments

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

that were used during fit up of the splice butt joint.

FW Spencer:

At location 6W-PP41 to PP44 gridline W5, this QA observed the fillet welding of the pipe supports identified as PS-24. The pipe support being installed is a modified PS-24 per Request for Information (RFI) ABF-RFI-002432R00. The modified support PS-24 beam W10x30 was 6mm fillet welded to the doubler plate welded to the OBG edge plate 'F'. QA randomly observed David Garcia perform all position fillet welding all around the W10x30 beam support to the welded doubler plate. The welder was noted using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode. ABF QC Steve Jensen was noted monitoring the welder. At the end of the shift, the welder has completely welded two PS-24 supports to the doubler plate of the OBG edge plate 'F'.

At location 6W-PP41 to PP44 gridline E5, this QA observed the installation and fit-up of the pipe supports identified as PS-24. The pipe support being installed is a modified PS-24 per Request for Information (RFI) ABF-RFI-002432R00. The modified support PS-24 beam W10x30 was tack welded to the doubler plate welded to the OBG edge plate 'F'. QA randomly observed Rick Kickvee perform tack welding the W10x30 beam support to the welded doubler plate. The welder was noted using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode. ABF QC Steve Jensen was noted monitoring the welder. At the end of the shift, the welder has completely tack welded two PS-24 supports to the doubler plate of the OBG edge plate 'F'.



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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Levell,Bill

QA Reviewer