

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-025275**Date Inspected:** 21-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:	William Sherwood and Steve Mc			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 location Panel Point PP13 to PP23 of grid line E5, this QA randomly observed FW Spencer qualified welder Rick Kiikee ID-5319 perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on the 2.5" diameter domestic water line. The water line system being welded is field splices along the grid line of E5 of the OBG. The welder was noted welding the root pass with 3/32" diameter E6010 electrode and followed by fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing Caltrans approved procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable propane gas torch prior welding. During welding, ABF QC William Sherwood was noted monitoring the parameters of the welder. At the end of the shift, four (4) 2 1/2" diameter field splices was completed and was visually accepted by QC.

At location 6E-PP41 to PP44 gridline E5 of the OBG, 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 all around 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 William Sherwood was noted monitoring the welder. At the end of the shift, the welder has completely welded two PS-24 supports to the

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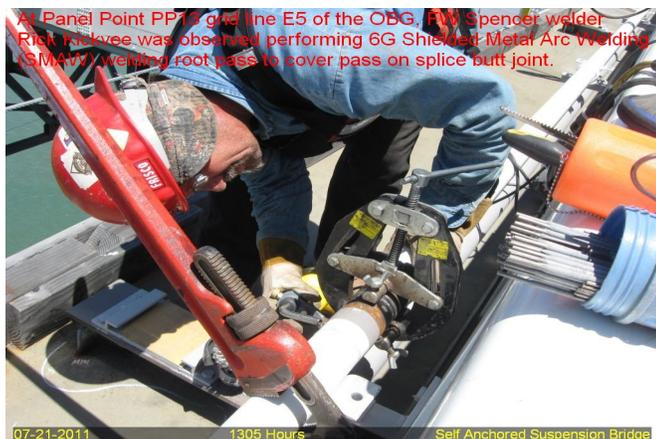
doubler plate of the OBG edge plate 'F'.

At the East bound side of the OBG, ABF welders Erick Sparks and Rick Clayborn were noted 2F tack welding and fillet welding respectively on the cat walk storm tie at various locations. Welder Rick Clayborn was noted utilizing Flux Cored Arc Welding (FCAW) with 1.8mm diameter E71T-8 wire electrode implementing Caltrans approved (WPS) ABF-WPS-D15-F2200-2. ABF welder Erick Sparks who was tack welding ahead of Rick Clayborn was noted using 1/8" diameter E7018H4R electrode. During the shift and welding, ABF QC Steve Mc Connell was noted monitoring the parameters of the welders. At the end of the shift, fillet welding of 6mm x 300mm long on both sides of the plate welded to the top of deck plate was completed at the following locations;

Panel Point Location OBG

1. PP60-PP61 Outboard East Bound
2. PP74-PP75 Inboard/outboard East Bound
3. PP90-PP91 Inboard/outboard East Bound

Other welding related activities noted during the shift include the fillet welding of tie in plate to the top deck of East Bound OBG panel point PP107-PP108 for the Cat Walk Tramway Anchorage. ABF welder Rick Clayborn was noted tack welding then fillet welding the tie in plates to the top deck plate using Flux Cored Arc Welding (FCAW) with 1.8mm diameter E71T-8 wire electrode implementing Caltrans approved (WPS) ABF-WPS-D15-F2200-2. At the end of the shift, fillet welding of the tie in plates was completed and assembly of the Tramway Anchorage was followed.



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

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Reviewed By: Levell,Bill

QA Reviewer