

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-025389**Date Inspected:** 02-Aug-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:** William Sherwood**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 East Bound Bike Path, this QA continuously observed ABF Stud welder Julian Paulk ID#7796 perform stud welding on top of the cantilever beam bike path support. The welder was noted stud welding 7/8" diameter 11 7/8" long with 9 threads per inch pitch threaded stud. The welder was also noted using the Tru Weld Equipment stud machine that was programmed to working current of 1900 amperes and welding time of 1.1 seconds implementing Caltrans approved welding procedure specification ABF-WPS-D15-5001-Stud.

Prior to welding the threaded studs, ABF welder Julian Paulk has welded two test studs similar to the studs to be welded and position that will be welded on top of the bike path cantilever beam. The two welded studs exhibited a full 360 degrees flash after welding. After ABF QC and this QA have completed the VT, the welder bent the two studs to 90 degrees using the 10 pounds sledge hammer exhibiting no fracture occurrence onto the weld and plate material.

The welder was noted welding at flat position using 7/8" diameter ceramic ferrules attached to the end of the stud being welded. The ceramic ferrules intended for flat position were noted new and dry. The top surface of the cantilever beam to be welded was ground and paint coating removed. The plate surface was preheated using a propylene gas torch prior stud welding. During welding, ABF QC William Sherwood was noted monitoring the welding parameters of the welder and checking each stud every panel point location. After QC has visually

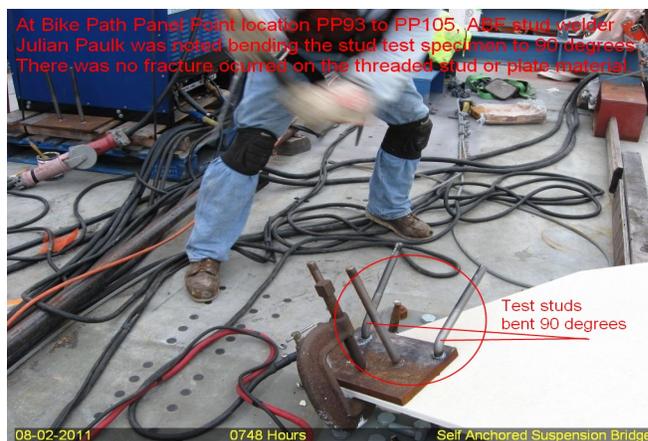
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accepted welded studs on each location, this QA has also verified each welded stud on each location.

The welded threaded studs at the following panel point locations were visually accepted by ABF QC and verified by this QA;

Stud	Panel Point (PP)	Number of Studs	Location	welded	Remarks
1.	PP 93	2	QA VT	Acceptable	
2.	PP97	4	QA VT	Acceptable	
3.	PP99	4	QA VT	Acceptable	
4.	PP101	4	QA VT	Acceptable	
5.	PP103	4	QA VT	Acceptable	
6.	PP105	2	QA VT	Acceptable	



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.

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