

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-026125**Date Inspected:** 19-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:** 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.

At Tower Base Elevation 13Meters, Electro Slag Welding (ESW) T-joint N-041 location 'N', QA randomly ABF welder Jeremy Dolman continuing to perform 3G SMAW first time welding repair (R1) on the Ultrasonic Testing (UT) detected defect on the vertical weld of the ESW per Repair Welding Request (RWR) #201108-013. 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 boat shape repair located at Y=9450mm was excavated to dimensions of 170mm long x 75mm wide x 40mm deep. The excavation was previously tested using Magnetic Particle Testing (MT) by ABF QC John Pagliero and fellow QA Danny Reyes. The repair excavation and the adjacent base metal was preheated to more than 300°F using propylene gas torch prior welding. During the shift, ABF QC Steve Mc Connell was noted monitoring the welder. Measured welding parameter during welding was 120 amperes on a 1/8" diameter E7018H4R electrode. At the end of the shift, cover pass welding of the repair mentioned above was completed.

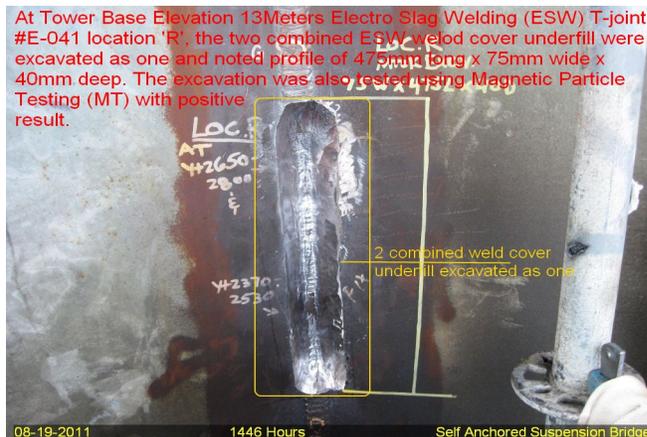
At Tower Base Elevation Electro Slag Welding (ESW) T-joint #E-041 location 'R', ABF welder Richard Garcia was noted continuing to excavate the weld cover underfill that was noted after the ESW. The welder was using carbon air arc gouging and die grinder to excavate the gouged groove of the excavation. At the end of the shift, the excavation was completed at Y=2330mm with boat shape profile of 475mm long x 75mm wide x 40mm deep. This excavation was a combination of two (2) underfill that were close to each other that the welder has excavated.

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The excavation was tested by ABF QC Steve Mc Connell using Magnetic Particle Testing (MT) and verified by this QA with positive result.

At the lay down barge near the Tower Base, ABF welder Rory Hogan was noted cutting the edges of the elevation 13 Meters center diaphragm due to excessive length and width. The welder has cut the edges using oxygen-propylene gas torch with nozzle attached to a track with the same bevel profile. The face of the bevel was also noted ground smooth. Other diaphragms that were installed at the end of the shift were inner East, inner West and outer West.



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