

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-026157**Date Inspected:** 20-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 and Fred Von Hoff			OSM 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 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 to excavate the cover underfill and die grinder to smooth ground the gouged groove of the excavation. At the end of the shift, the excavation was completed at Y=6460mm with boat shape profile of 225mm long x 75mm wide x 40mm deep. The excavation was tested by ABF QC Fred Von Hoff using Magnetic Particle Testing (MT) and verified by this QA with positive result.

At the lay down barge anchored near the Tower Base, ABF welder Rory Hogan was noted cutting the edges (2-sides) of the elevation 13 Meters north diaphragm due to excessive length and width. The welder has cut the edges using oxygen-propylene gas torch with nozzle attached to a track. The face of the bevel was also noted ground smooth. Minor touch up SMAW welding was performed on the bevel face due to notches that occurred during cutting. The welder was noted using 1/8" diameter E7018H4R electrode. The plate was also preheated to 150°F prior welding. ABF QC Fred Von Hoff was noted monitoring the welder's parameter during welding. After the work completion of the north diaphragm plate, this QA verified the bevel depth of more than 39mm and bevel angle of 45 degree as required. This diaphragm was put in place during the shift.

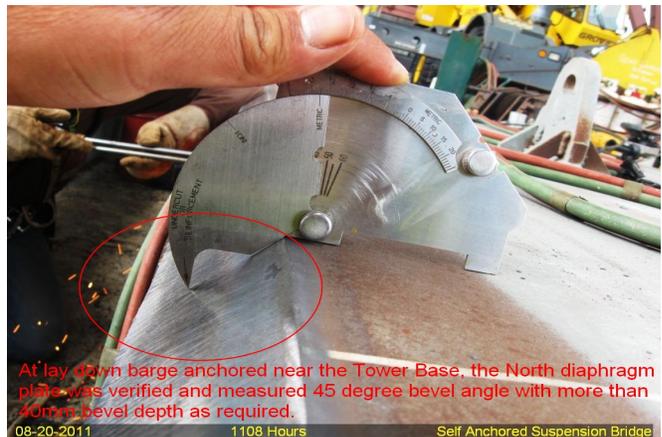
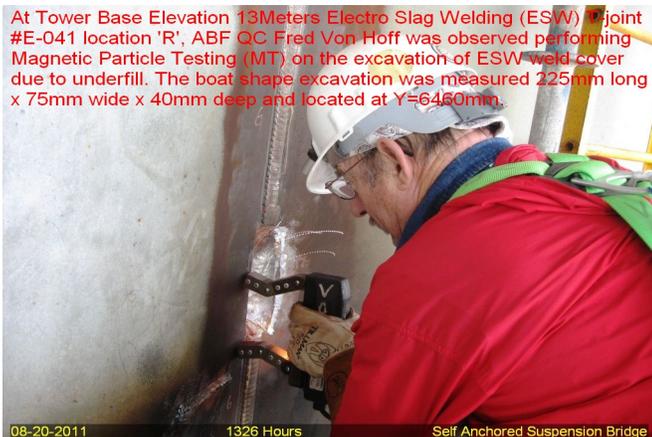
The elevation 13Meter south diaphragm was also needed to be cut on 2-sides of the plate due to excessive length

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and width. ABF welder Rory Hogan was noted cutting the edge of the plate using oxygen-propylene gas torch with nozzle attached to a track. One side of the diaphragm plate was noted cut and being ground smooth at the end of the shift. According to the welder, the other side of the diaphragm plate will be cut and ground smooth on Monday.

At various ESW weld locations, ABF QC Steve Mc Connell and William Sherwood were observed performing Magnetic Particle Inspection (MT). The vertical ESW weld joints at locations 'N', 'W', 'R' and 'S' were MT'd from the inside with noted grinding remarks marked on the plates to be later performed by ABF personnel.



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