

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026518**Date Inspected:** 12-Oct-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:	John Pagliero and Bernie Docena			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 OBG 8E-PP70.5-E5-NE access hole infill plate to top deck plate outside, QA randomly observed ABF/JV qualified welder Salvador Sandoval continuing to perform CJP groove cover pass welding. The welder was observed welding in the 1G (flat) position utilizing Shielded Metal Arc Welding (SMAW) with 5/32" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1010 Revision 1. The joint being welded has a double V-groove butt joint with open root welded from the bottom. ABF Quality Control (QC) Fred Von Hoff was noted monitoring the welding parameters of the welder. Measured welding parameter during welding was 195 amperes on a 5/32" diameter E7018H4R electrode. During the shift, cover pass welding on the infill plate to the top deck was completed and the welder flush ground both sides of the weld joint reinforcement in preparation for the QC VT/NDT.

At OBG 10W-PP92-W4-#2 & 4 lifting lug hole infill plate to top deck plate outside – ABF welder Mike Jimenez was noted flush grinding the weld cover of the bottom weld. The flush grinding of the lifting lug hole #2 was completed while lifting lug hole #4 was still in progress when the welder was pulled out and went to another assignment.

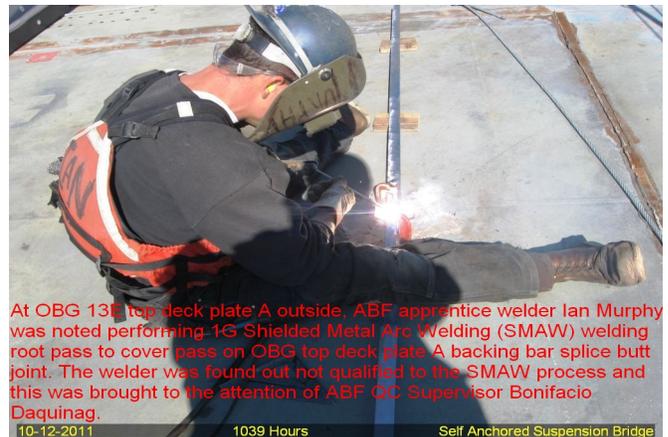
At OBG10W-PP88-W4-#1, 2, 3 & 4 lifting lug hole infill plate to top deck plate outside, ABF QC John Pagliero was observed performing Ultrasonic Testing (UT) on the welded lifting lug hole butt joints. After the completion

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of the UT, QC has found lifting lug holes 1 and 2 acceptable but holes 3 and 4 rejectable.

At OBG 13E top deck plate A outside, ABF apprentice welder Ian Murphy was noted performing 1G Shielded Metal Arc Welding (SMAW) welding Complete Joint Penetration (CJP) backing bar splice butt joint. The welder was noted using 1/8" E7018 electrode during welding. The joint being welded has a single vee joint preparation without root opening. After the welding completion from one side, the joint was turned upside down and the joint was back gouged using a disc grinder. During the shift, the apprentice welder has completely welded three (3) of the splice butt joints. When the welder was asked about his qualification, he replied to this QA that he got qualification paper. This QA verified the welder's qualification and found out that he was only qualified on stud welding. This was brought to the attention of QC Supervisor Bonifacio Daquinag since there was also no QC around during welding. The QC Supervisor clarified to this QA that ABF has not required a QC to monitor the welding since the backing bar will be removed through back gouging then back welded after the Submerged Arc Welding (SAW) of the top deck plate A. This clarification was relayed to Lead QA Danny Reyes.



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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