

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-027335**Date Inspected:** 16-Mar-2012**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:** 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 Tower Base 9 meter outer West external diaphragm, this QA Inspector randomly observed ABF personnel Jin Pei Wang continuing to perform 4F (overhead position) fillet production welding on the C10 channel to 45mm thick diaphragm plate fillet weld joint W098-2. The welder was noted welding 6mm fillet between one side of the channel top flange and diaphragm plate per detail 1 of the ZPMC drawing number FW3. The welder was using the 5/32" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. This QA Inspector observed ABF personnel using propylene gas torch to preheat the plates being welded prior welding. This QA Inspector observed QC Inspector Bernie Docena using a Fluke infra red temperature gauge to verify the preheat temperature of more than 150°F. This QA Inspector performed a verification of the welding parameters and observed 158 amperes on the 5/32" diameter electrode. The welding appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-F1200A. At the end of the shift, the welder has completed the 6mm fillet weld on West side of the outer West diaphragm.

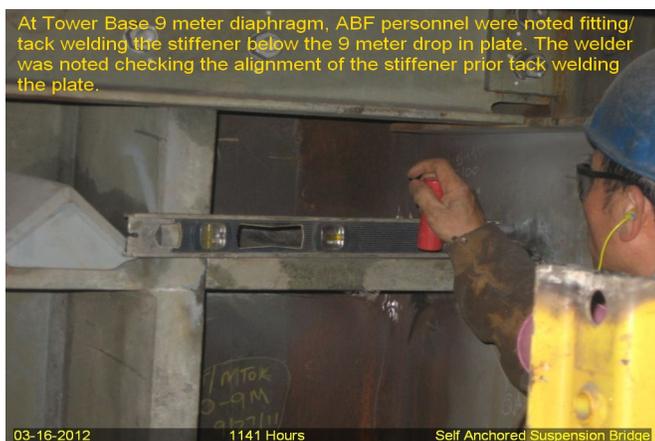
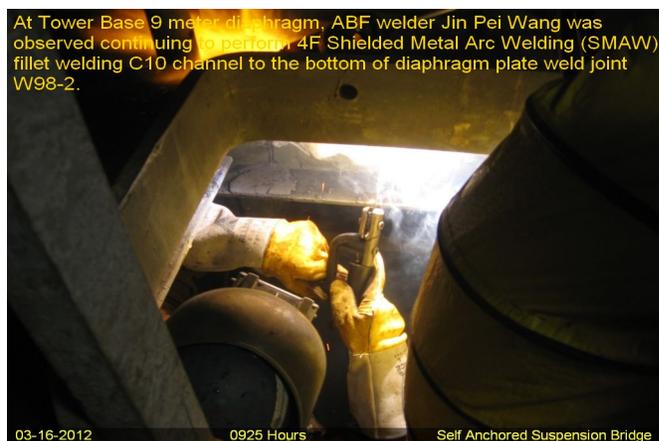
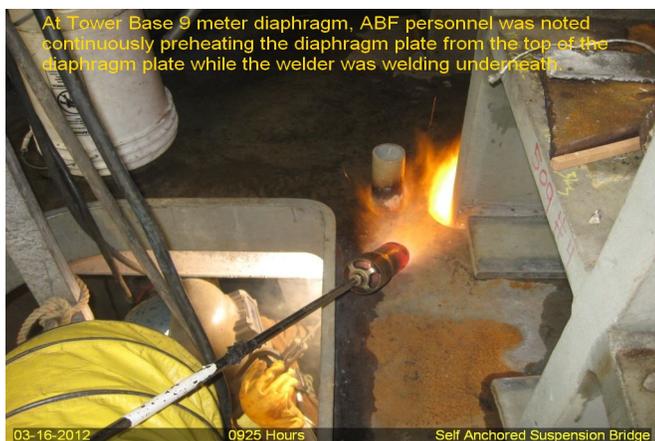
At Tower Base 9 meter outer West external diaphragm, this QA Inspector randomly observed ABF personnel Xiao Jian Wan continuing to perform 4F (overhead position) fillet production welding on the C10 channel to 45mm thick diaphragm plate fillet weld joint W098-1. The welder was noted welding 6mm fillet between one side of the channel top flange and diaphragm plate per detail 1 of the ZPMC drawing number FW3. The welder was using the 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification

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(WPS) ABF-WPS-D15-F1200A. This QA Inspector observed ABF personnel using propylene gas torch to preheat the plates being welded prior welding. This QA Inspector observed QC Inspector Bernie Docena using a Fluke infra red temperature gauge to verify the preheat temperature of more than 150°F. This QA Inspector performed a verification of the welding parameters and observed 160 amperes on the 5/32" diameter electrode. The welding appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-F1200A. At the end of the shift, the welder has completed the 6mm fillet weld on South side of the outer West diaphragm.

At Tower Base 9 meter South external diaphragm below drop in plates SD1-A55 and SD1-A53, ABF welder Han Wen Yu was observed performing fit up/tack welding on the two (2) stiffener plates to shear plate and diaphragm plate. The welder was noted using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode. At the end of the shift, fit up tack welding of the stiffener plates for the South external diaphragm was still continuing and should remain Monday.



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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