

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-027813**Date Inspected:** 23-Jun-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:	Scott Kourtom 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 Tower Base Electro Slag Welding (ESW) 100mm/80mm transition weld butt joint 'V' face A (S-042), QA randomly observed ABF/JV qualified welder Xiao Jian Wan continuing to perform CJP groove welding repair at Y=300mm to Y=580mm with excavation dimensions of 280mm long X 70mm wide x 55 mm deep per Caltrans approved Request for Welding Repair (RWR) #201206-42. The welder was observed welding in the 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1000-Repair Rev. 2. The repair excavation was preheated to more than 300 degree Fahrenheit using propane gas torch prior welding and then switch to Miller Proheat 35 Induction Heating System. During the shift, ABF QC Scott Kourtom was noted monitoring the welder with measured working current of 124 amperes during welding. At the end of the shift, the welding repair of weld joint mentioned above was still continuing and should remain tomorrow.

At Tower Base Electro Slag Welding (ESW) 100mm/80mm transition weld butt joint 'T' face A (S-043), QA randomly observed ABF/JV qualified welder Jin Pei Wang continuing to perform CJP groove welding repair at Y=8660mm to Y=8950mm with excavation dimensions of 290mm long X 60mm wide x 52 mm deep per Caltrans approved Request for Welding Repair (RWR) #201206-38. The welder was observed welding in the 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1000-Repair Rev. 2. The repair excavation was preheated to more than 300

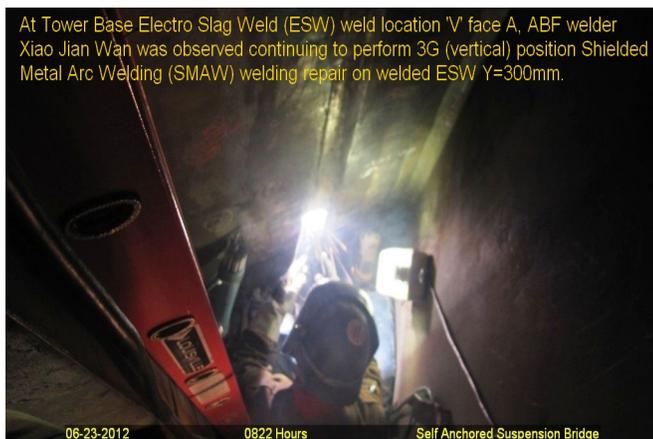
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degree Fahrenheit using propane gas torch prior welding. During the shift, ABF QC Scott Kourtom was noted monitoring the welder with measured working current of 126 amperes during welding. At the end of the shift, the welding repair of weld joint mentioned above was completed and so with the flush grinding on the weld cover.

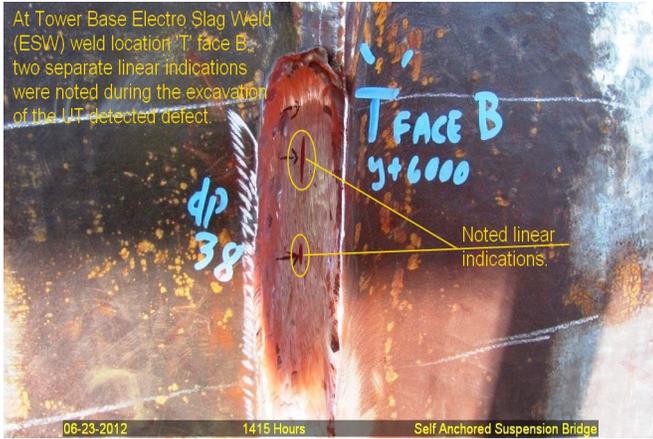
At Tower Base Electro Slag Welding (ESW) 100mm/80mm transition weld butt joint 'T' face A (S-043), QA randomly observed ABF/JV qualified welder Lou Xiao Hua perform CJP groove welding repair at Y=2240mm to Y=2440mm with excavation dimensions of 200mm long X 50mm wide x 52 mm deep per Caltrans approved Request for Welding Repair (RWR) #201206-50. The welder was observed welding in the 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1000-Repair Rev. 2. The repair excavations was preheated to more than 300 degree Fahrenheit using propane gas torch prior welding and then switch to Miller Proheat 35 Induction Heating System. During the shift, ABF QC Scott Kourtom was noted monitoring the welder with measured working current of 124 amperes during welding. At the end of the shift, the welding repair of weld joint mentioned above was still continuing and should remain tomorrow.

At Tower Base Electro Slag Weld (ESW) 100mm/80mm transition weld butt joint 'T' face B (S-043) location Y=6000, ABF welder Jin Pei Wang was observed perform excavation on ESW welded joint due to UT detected defect. The excavation is being performed per Caltrans approved RWR #201206-055. The welder excavated the defect using carbon air arc gouging followed by die grinder. During the excavation at 32mm deep, there were two linear indications noted measuring 25mm long and 10mm long that was separated by approximately 30mm. The welder continued the excavation after the 32mm depth but due to time constraint of the work shift, the welder was not able to complete the excavation.



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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
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