

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-027980
Date Inspected: 14-Jul-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
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 Electro Slag Weld (ESW), this QA observed ABF welder Han Wen Yu (who took over from James Zhen) continuing to perform repair excavation at location 'Q' face B (E-043) Y=4060mm and Y=6160mm due to Ultrasonic Testing (UT) detected defects. The repair excavation is being undertaken per Caltrans approved Request for Weld Repair (RWR) #201206-083 and RWR #201206-084 respectively. The welder was noted using carbon air arc gouging followed by grinding using a die grinder. The excavation was alternately gouged and ground then Magnetic Particle Testing (MT) tested by ABF QC Bernie Docena and this QA until all the defects are removed. The following excavation events were noted during the repair excavation;

ESW location Y-dim Depth of excavation Noted defect:

- 'Q' (B) 4060mm 55mm All linear indications removed.
- 'Q' (B) 6160mm 20mm No relevant defect noted.
- 'Q' (B) 6160mm >20mm Excavation in progress.

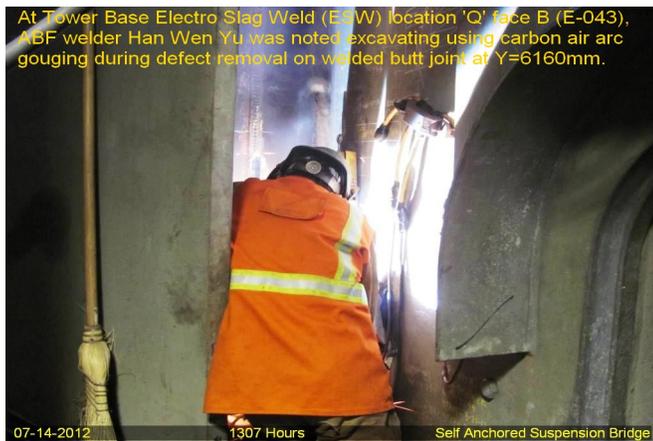
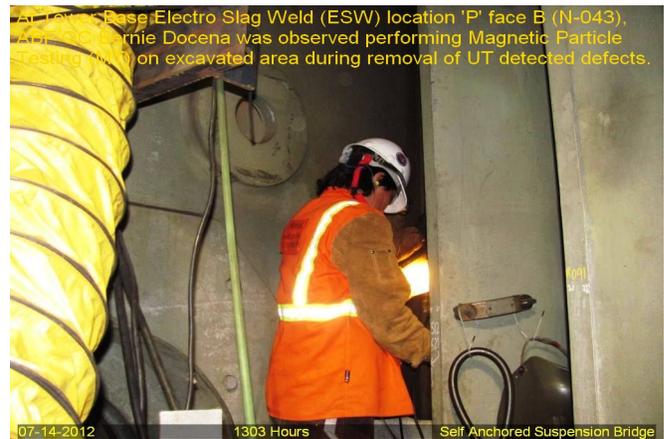
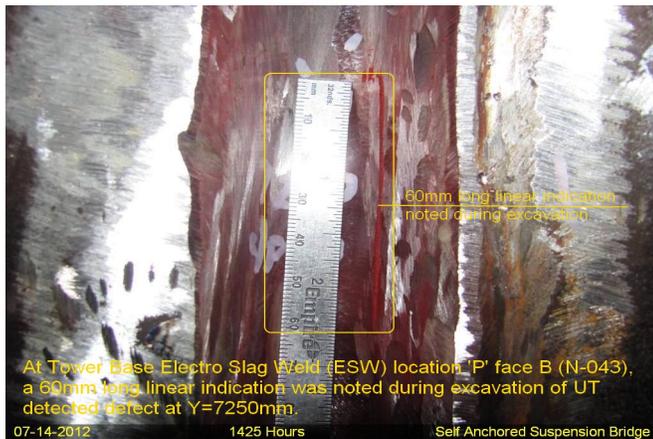
At Tower Base Electro Slag Weld (ESW), this QA observed ABF welder Lou Xiao Hua continuing to perform repair excavation at location 'P' face B (N-043) Y=7860mm and Y=7250mm due to Ultrasonic Testing (UT) detected defect. The repair excavation is being undertaken per Caltrans approved Request for Weld Repair (RWR) #201206-076 and RWR #201206-075 respectively. The welder was noted using carbon air arc gouging followed

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

by grinding using a die grinder. The excavation was alternately gouged and ground then Magnetic Particle Testing (MT) tested by ABF QC Bernie Docena and this QA until all the defects are removed. The following excavation events were noted during the repair excavation;

ESW location	Y-dim	Depth of excavation	Noted defect
1. 'P' (B)	7860mm	25mm	No relevant indication noted.
2. 'P' (B)	7860mm	35mm	1-35mm & 2-8mm long linear indications.
3. 'P' (B)	7860mm	45mm	1-35mm, 1-12mm & 1-3mm long linear ind.
4. 'P' (B)	7860mm	50mm	All linear indications removed.
5. 'P' (B)	7250mm	30mm	1-60mm long linear indication noted. .
6. 'P' (B)	7250mm	>30mm	Excavation in progress.



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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
----------------------	-------------------	-----------------------------

Reviewed By:	Levell, Bill	QA Reviewer
---------------------	--------------	-------------