

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-028258**Date Inspected:** 25-Aug-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 Kourtum and John Pagliero			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 OBG		

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 13W-W2.5-@5030mm outside, ABF welder Lin E Yun was observed continuing to perform repair welding. The welder has excavated UT detected defect using carbon air arc gouging then ground smooth the groove of the excavation. ABF QC Scott Kourtum was noted performing the Magnetic Particle Testing (MT) on the defect removal with no relevant defect noted during the test. The second time repair which was located at Y=4220 was excavated at the wrong location Y=3590mm. This erroneous excavation was brought to the attention of ABF QC Scott Kourtum and Lead QA Danny Reyes. Since the wrongly excavated repair location was a first time repair, it was decided by both parties, QA and QC to proceed with the repair. During welding repair, the welder was observed welding in the 4G (overhead) position utilizing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1004-Repairs. The repair area was preheated to required temperature of >325°F using Miller Proheat 35 Induction Heating System during welding and 450°F PWHT after welding for one hour as required. During the shift, ABF QC Scott Kourtum was noted monitoring the welder with measured working current of 130 amperes on 3.2mm E7018H4R electrode. During the shift, repair welding at location mentioned above was completed. The welder has moved to another location after welding above mentioned repair.

At OBG 13W-PP122.5-W2.8 BF2 drop-in floor beam inside, ABF welder Lin E Yun was observed continuing to perform repair welding. Prior to perform the repair, the welder was noted excavating the UT detected defect using

WELDING INSPECTION REPORT

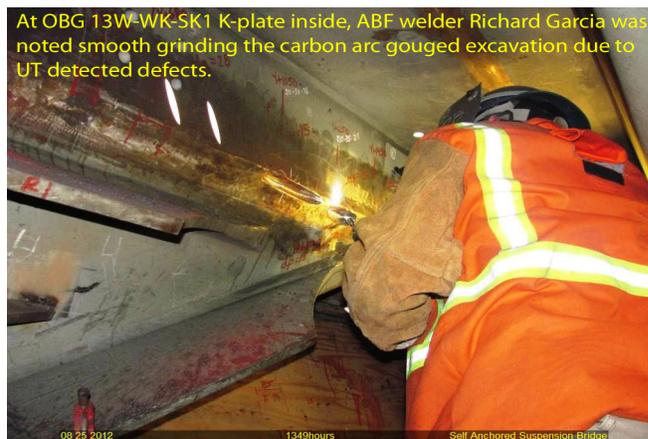
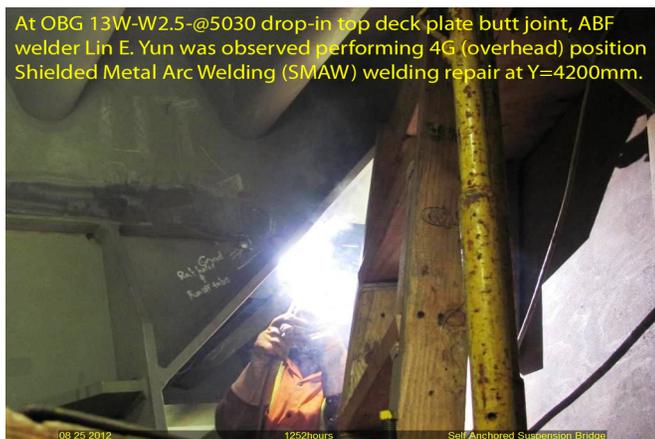
(Continued Page 2 of 3)

carbon air arc gouging then ground smooth the groove of the excavation. ABF QC Scott Kourtum was noted performing the Magnetic Particle Testing (MT) on the defect removal with no relevant defect noted during the test. The repair was located at Y=160 and having boat shape excavation profile of 130mm long x 30mm wide x 17mm deep. After the completion of the MT, welder Lin E Yun was observed welding in the 4G (overhead) position utilizing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1000-Repairs. During the shift, ABF QC Scott Kourtum was noted monitoring the welder with measured working current of 120 amperes on the 3.2mm E7018H4R electrode. During the shift, repair welding at location mentioned above was completed.

At OBG 13W-WK-SK1 K-plate inside, ABF welder Richard Garcia was observed continuing to perform repair welding. Prior to perform the repair, the welder was noted individually excavating the UT detected defects using carbon air arc gouging then ground smooth the groove of the excavation. ABF QC John Pagliero was noted performing the Magnetic Particle Testing (MT) on the defects removal with no relevant defects noted during the test. After the completion of the MT, welder Richard Garcia was observed welding in the 2G (horizontal) position utilizing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode. The welder preheated the repair area and its vicinity to more than 200°F during welding. During the shift, ABF QV John Pagliero was noted monitoring the welder with measured working current of 125 amperes on the 3.2mm E7018H4R electrode. The following four (4) first time repairs were noted excavated and welded during the shift;

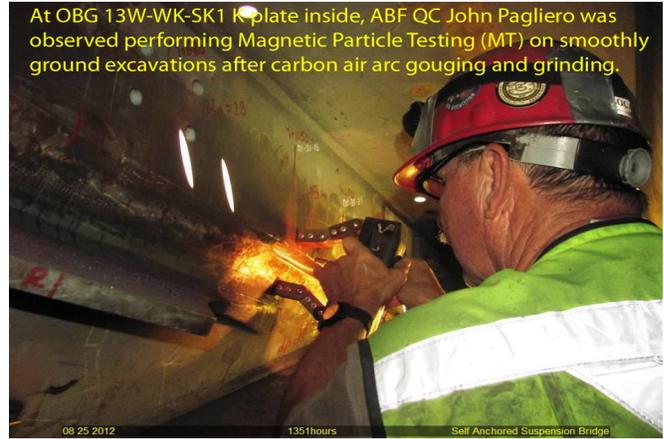
Y-location Length Width Depth Remarks

1. 50mm 100mm 25mm 13mm Completed.
2. 400mm 120mm 30mm 18mm Excavated.
3. 1050mm 210mm 30mm 18mm Excavated.
4. 1250mm 120mm 35mm 24mm Excavated.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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

Reviewed By: Levell, Bill

QA Reviewer