

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-028306**Date Inspected:** 31-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:** Barry Drake**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 12W/13W side plate C1.1 inside, QA randomly observed ABF/JV qualified welder Mike Jimenez continuing to perform CJP groove welding repair on a Seismic Performance Critical Member (SPCM) welded splice butt joint from Y=0mm to Y=2400mm per Caltrans approved Request for Weld Repair (RWR) # 201208-093. ABF personnel were noted using the Miller Proheat 35 Induction Heating System to preheat and maintain the required temperature of 325°F during welding. ABF welder Mike Jimenez was observed performing 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) welding repair on welded splice butt joint. The welder was noted using 4.0mm E7018H4R electrode implementing Caltrans approved welding procedure ABF-WPS-D15-1004 Repair. ABF QC Barry Drake was also noted monitoring the welder with measured working current of 180 amperes. With the absence of ABF welder Rick Clayborn, Mike Jimenez continued 3G SMAW repair welding by himself till the end of shift wherein he was not able to complete the repair. The welder held the preheat of 450°F for one hour after welding as required. Repair welding will continue.

In observance of the forthcoming Labor Day, ABF personnel were given half day work day for today. This QA performed updating of reports and various tracking on completed welding of OBG 13W.

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At OBG 12W/13W side plate C1.1 inside, ABF welder Mike Jimenez was observed performing 3G (overhead) position Shielded Metal Arc Welding (SMAW) welding repair on welded splice butt joint from Y=0mm to Y=2400mm.



At OBG 12W/13W side plate C1.1 outside, ABF personnel were noted using the Miller Proheat 35 Induction Heating System to preheat, maintain and PWHT with the heater blanket put in place outside the weld joint during welding.



At OBG 12W/13W side plate C1.1 inside, ABF personnel were noted using Miller Proheat 35 Induction Heating System to preheat, maintain and Post Weld Heat Treatment (PWHT) the repair during welding.



Summary of Conversations:

In observance of the forthcoming Labor Day, ABF personnel were given half day work day for 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
