

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-028656
Date Inspected: 26-Oct-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:	William Sherwood and 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 12E-E2.1-C corner drop-in side plate outside, QA randomly observed ABF/JV qualified welders continuing to perform CJP groove welding repair at various Y locations. The repair welding is being performed per Caltrans approved Request for Weld Repair (RWR) #201210-013. The welders were observed manually welding in the 4G (overhead) position utilizing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018H4R electrode implementing Caltrans welding procedure ABF-WPS-D15-1004 Repair. The second time repair excavations were preheated to more than 225 degree Fahrenheit using Miller Proheat 35 Induction Heating System/propylene gas torch prior excavation. During the shift, ABF QC William Sherwood was noted monitoring the welders with measured working current of 165 to 170 amperes on the 4.0mm E7018H4R electrode and adjusted preheat temperature of 325°F during welding. During the shift where welder has completed the welding repair as mentioned below, ABF personnel have performed the Post Weld Heat Treatment (PWHT) of 450°F and held it for one (1) hour after welding as required. After the completion of the bake out of the just concluded repair, the welder will move to another location of the same side plate and perform the same task implementing the same WPS. Listed below were excavated and welded during the shift.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder Y-location Length Width Depth Remarks

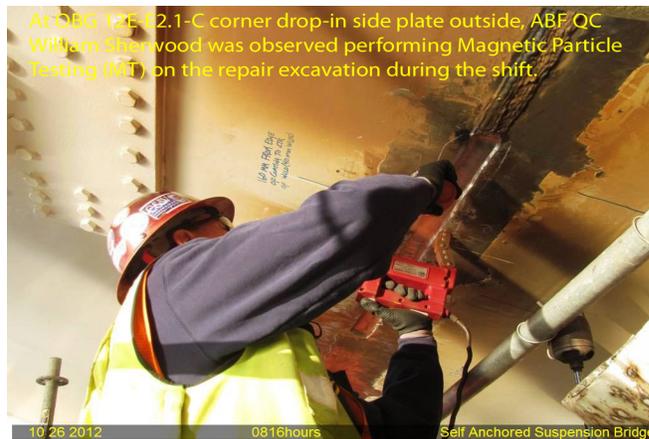
1. Ric Chouinard Y=13600mm 1000mm 60mm 10mm SPCM/R2-completed.
2. Mike Jimenez Y=5600 1000 60 10 SPCM/R2-completed.
3. Richard Garcia Y=9600 1000 60 10 SPCM/R2-in progress.
4. Cris Bruce Y=28400 1000 50 11 Non-SPCM/R2-in progress.

FW Spencer:

At Tower location elevation 53 meter, this QA randomly observed FW Spencer qualified welder Damian Llanos continuing to perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on 3" domestic utility water line field splice butt joints. The welder was noted welding the root pass with 3/32" diameter E6010 electrode and followed by fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing Caltrans procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable propane gas torch prior welding. During welding, ABF QC Barry Drake was noted monitoring the parameters of the welder. At the end of the FW Spencer shift, CJP welding on one (1) 3" diameter domestic utility water line was completed.

Line Service Pipe Size Panel Point Location Joint Designation

1. Compressed Air 3" 42 Tower elev. 53 7/3/42/T53



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 Gary Thomas (916) 764-6027, 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: Reyes, Danny

QA Reviewer