

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-028795**Date Inspected:** 28-Nov-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Steve Jensen and William Sherwood			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.

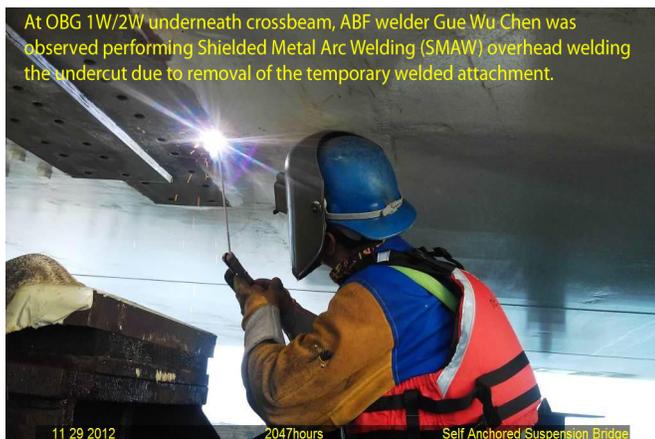
At OBG 12W-W2.1-C1.1 corner drop-in side plate outside, QA randomly observed ABF/JV qualified welder Ric Chouinard continuing to perform CJP groove welding repair on a Seismic Performance Critical Member (SPCM) due to Ultrasonic Testing (UT) detected defect on welded butt joint at location Y=18000mm to Y=19000mm. The repair has an excavation profile of 1000mm long x 45mm wide x 10mm deep. The repair welding is being performed per Caltrans approved Request for Weld Repair (RWR) #201211-005. The welder was 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 first time repair excavation was preheated to more than 225 degree Fahrenheit using Miller Proheat 35 Induction Heating System with the heater blanket put in place on top of the side plate prior excavation. During the shift, ABF QC William Sherwood was noted monitoring the welder with measured working current of 170 amperes on the 4.0mm E7018H4R electrode and adjusted preheat temperature of 325°F during welding. During the shift, the welder has completed the welding repair mentioned above and performed the Post Weld Heat Treatment (PWHT) of 450°F and held it for one (1) hour after welding as required.

At OBG 1W/2w outside, ABF welder Wu Gue Chen was observed overhead welding/fixing the removal of welded temporary attachments. The welded temporary attachment shims are located underneath the OBG particularly where the cross beams are bolted. During the initial inspection where access were available, welded temporary

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attachments at cross beams number 1 and 2 along the West bound were noted having undercut that requires fixing through welding. This was brought to the attention of the Lead QC Bonifacio Daquinag and also Task Leader Danny Reyes. During the shift, ABF welder Gue Wu Chen has ground smooth the removal of some of the welded temporary attachment and welded those that require welding. Together with ABF QC Steve Jensen, this QA performed visual inspection and Magnetic Particle Testing (MT) on the removal of some of the attachments. This should continue on all cross beams along the East and West bound.



Summary of Conversations:

Today's weather at the job site was windy and rainy. Due to this weather condition, the welders were instructed to perform welding only where it is dry.

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.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer
