

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-028833**Date Inspected:** 06-Dec-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1739**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Jesse Cayabyab**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) 'G' weld joint #S-045 face A, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at locations Y=2000, Y=2090, Y=2100 and Y=2210mm due to UT detected defects. The ABF personnel have resumed the exploratory excavation from 41mm deep where they left off Monday. The personnel were noted using only the disc grinder in every 1mm increments of excavation. ABF QC Jesse Cayabyab was observed performing Magnetic Particle Testing (MT) on the following various depths with three (3) linear indications noted so far. This QA also performed the same test and noted same result. During the shift, the ABF personnel continued the excavation in 1mm increments using the same method of test and verification up to 45mm with three linear indications noted. The shift was completed up to this depth of excavation and ABF is waiting for further instruction if they will excavate deeper into this exploratory excavation.

The starting depth of excavation on this date was a continuation from the previous shift. The results of the exploratory excavations are as follows;

1. 41mm in depth – no significant indication noted.
2. 42mm in depth – 7mm linear indication noted @y=2020mm, X=-10.
3. 43mm in depth – 6mm linear indication noted @y=2045mm, X=-10.
4. 44mm in depth – no significant indication noted.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

5. 45mm in depth –6mm linear indication noted @y=2010mm, X=-10.

The exploratory excavations at this location will be continued on the following shift.

