

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-028834**Date Inspected:** 07-Dec-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:** 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 46mm 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 50mm with five (5) 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. 46mm in depth – 6mm linear indication noted @y=2210mm, X=-10.
2. 47mm in depth – 6mm linear indication noted @y=2210mm, X=-10.
3. 48mm in depth – 2mm linear indication noted @y=2210mm, X=-10.
4. 48mm in depth – 2mm linear indication noted @y=2060mm, X=-10.

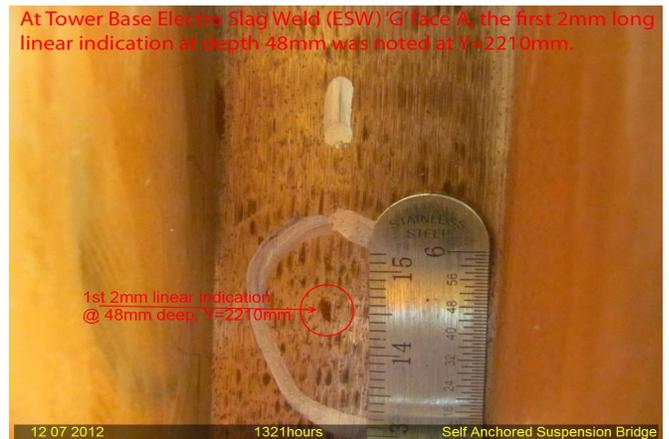
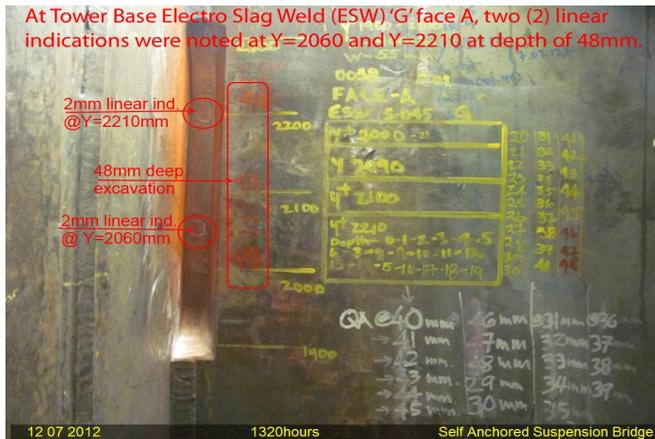
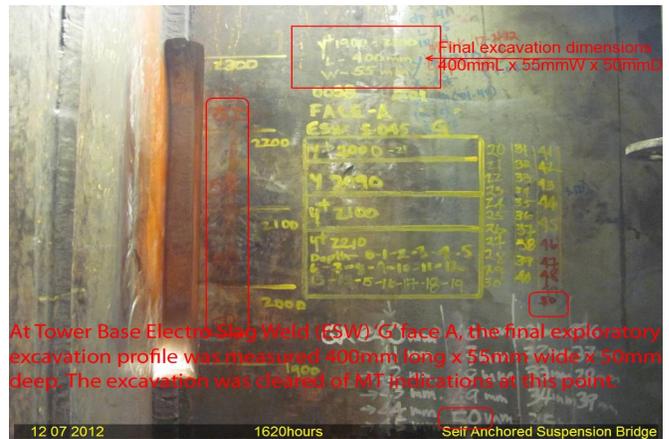
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5. 49mm in depth –2mm linear indication noted @y=2210mm, X=-10.

6. 50mm in depth - no significant indication noted. All linear indications that were previously noted have all been removed.

The exploratory excavations at this location has stopped with final excavation profile of 400mm long x 55mm wide x 50mm deep. ABF QC and other personnel were told that the next exploratory excavation will be the continuation of excavation at ESW 'V' face B with Y location from Y=915mm to Y=1300mm..



Summary of Conversations:

No significant conversation 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.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer