

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-029030**Date Inspected:** 19-Jan-2013**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**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) "V" weld joint #W-043 face B, ABF welder Chris Bruce was observed performing the repair welding at the Y coordinates 9490mm and 9600mm. The welder was noted utilizing Shielded Metal Arc Welding (SMAW) as per the Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair Rev. 3. Welding parameter measured during welding was noted as 185 amperes utilizing the 4mm E7018H4R electrode as referenced per the WPS. This weld repair is being performed per the Request for Weld Repairs (RWRs) #201301-032 and #201301-033. During the shift, ABF QC William Sherwood was noted monitoring the welding parameters and workmanship of the repair being welded. The welding was not completed during this shift and will be continued on the next scheduled shift. The welder also performed the Post Weld Heat Treatment (PWHT) as required per the contract documents.

At Tower Base Electro Slag Weld (ESW) "V" weld joint #W-043 face A, ABF welder Eric Sparks was observed performing the excavations of two UT rejects identified and located at Y coordinates 8810mm and 8630mm. The excavations are being performed as per the approved RWR#'s 201301-031 and 201301-031. Prior to the excavation, the welder was noted preheating the repair area to a minimum of 350°F using Miller Proheat 35 Induction Heating System with the heater blanket placed on the outside. After completing the excavation, ABF QC William Sherwood performed Magnetic Particle Testing (MPT) and no rejectable indications were noted. At this time, this QAI performed an MPT to verify the weld and the QC inspection for compliance and at the

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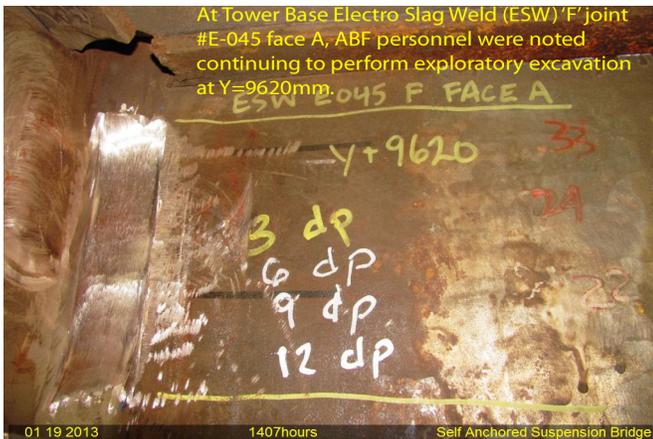
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conclusion of the verification this QAI concurs with Mr. Sherwood's assessment. The dimensions of the excavations are as follows: 130mm long x 45mm wide x 45mm deep for the location at Y=8810mm and 110mm long x 40mm wide x 37mm deep for the location at Y=8630mm. No welding of this excavation was performed during this shift.

At Tower Base Electro Slag Weld (ESW) "F" weld joint #E-045 face A, ABF personnel was observed performing exploratory excavation of the indication found by UT located at Y coordinate 9620mm. The ABF personnel have resumed the exploratory excavation from 3mm deep which was started on the previous scheduled shift. The ABF personnel was observed grinding which was performed at 3mm intervals. ABF QC William Sherwood was observed performing Magnetic Particle Testing (MT) on the following various depths with indications noted below. This QAI performed an MPT to verify the QC testing for compliance and at the conclusion of the testing this QAI concurs with Mr. Sherwood's assessment. During the shift, the ABF personnel have excavated up to 12mm deep.

1. At 6mm deep – no significant indications noted.
2. At 9mm deep - no significant indications noted.
3. At 12mm deep – no significant indications noted.

The exploratory excavations at this location will continue on the next scheduled shift.



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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.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
