

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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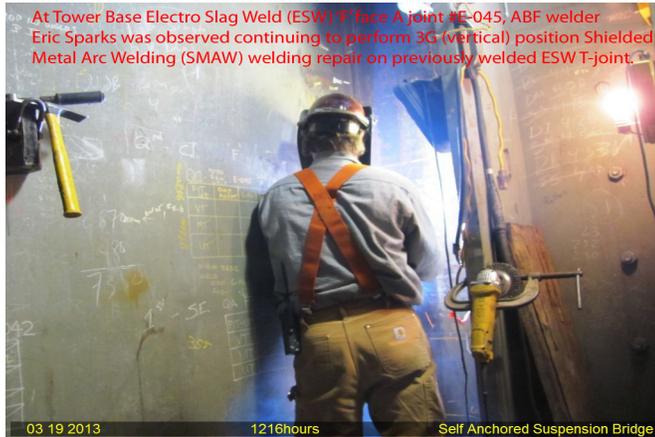
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029325**Date Inspected:** 19-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Andrew Keech**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 Electroslag Welding (ESW) T-joint #E-045 location 'F' (face A), this QAI randomly observed the ABF welder Eric Sparks perform repair welding due exploratory excavation that was noted with linear indications. The previously excavated repair was having dimensions of 145mm long x 40mm width x 45mm deep. Prior to welding, a 30mm linear indication was noted during Magnetic Particle Testing (MT) and at this time the welder stated carbon arc gouging to remove the linear indication that was noted at 21mm depth. After the completion of the removal of the linear indication and grinding of the excavation to a bright metal, Mr. Keech performed the MPT of the excavation and no significant indications were noted. This QA also performed a verification test at the request of Mr. Keech. At the conclusion of the test this QAI concurs with QC inspector's assessment. At the completion of the test, the welder was observed performing the repair welding utilizing the Shielded Metal Arc Welding (SMAW) using the 5/32" diameter E7018H4R electrodes as per the welding procedure ABF-WPS-D15-1000-Repair Rev. 2. The repair excavation and the adjacent base metal were preheated to approximately 300°F using Miller Proheat 35 Induction Heating System with the heater blanket placed at the opposite side of the shear plate. During the welding, Mr. Keech was noted monitoring the welding and the welding parameters which were noted and recorded as 175 amperes. The repair welding of the ESW located at the Y dimensions 7260mm to 7620mm was not completed on this date and will be continued on the next scheduled shift. The ABF welding personnel performed the Post Weld Heat Treatment (PWHT) to 350 degrees Fahrenheit as required.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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