

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022496**Date Inspected:** 13-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman Acme Corporation**Location:** Buffalo, NY

CWI Name: Gregory Ross
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Seismic Joint A - Mockup**Summary of Items Observed:**

On this date, Quality Assurance Inspector Fred Edmondson was present at the Watson Bowman Acme Corporation (WABO) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Joint Hinge a Mock-up lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QA) Inspector met with Watson Bowman Acme Corporation Quality Control (QC) Manager Mr. Gregory Ross and (KTA-Tator, American Welding Society Certified Welding inspector (AWS CWI), Mr. John Gotwald and was informed that welding was in-process on the two SEI112667CA2 Channel Assemblies for the mock-up. AWS CWI inspector Gotwald will be the quality control (QC) welding inspector on the day shift. Welding has not started on the night shift.

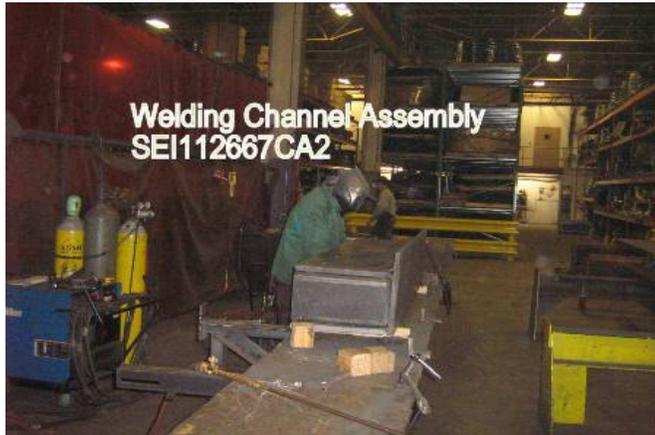
This QA inspector observed that certified welder Jayson Gray was using the FCAW process to weld Complete Joint Penetration (CJP) welds on the SEI112667CA2 Channel Assemblies for the mock-up. The approved FCAW Welding Procedure Specification (WPS) was Watson Bowman - WPS FCAW 13. All welding was being performed in the flat, 1G position.

This QA inspector observed that no work was in-process on the deck plates (Part No. SEI112667AC) for the mock-up. QC manager Ross provided this QA inspector with a copy of the RFI-WBA-000002 R00 disposition that calls for welding and reshaping the traction patterns by hand on the deck plate with the handling dings. Welding and reshaping work has not started. This QA inspector observed (same plate) that the 90mm dia.x38mm depth counter bores had been measured to be 34.9mm in depth (reference WABO Dwg. B24952, Page No. 10 OF 12 and Detail No.3, Page No. 9 OF 12. QC Manager Ross commented that the counter bores dimensions are

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identical for both plates.



Summary of Conversations:

Basic conversation, fundamental to completion of the task at hand, occurred between this QA Inspector, QC manager Ross and QC Inspector Gotwald.

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 Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Edmondson, Fred

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer