

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-024642**Date Inspected:** 23-Jun-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 Corp.**Location:** Buffalo, NY**CWI Name:** Greg Ross**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:** Seismic Hinge A**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Dustyn Broening was present at the Watson Bowman Acme Corporation (WABO) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A for the San Francisco Oakland Bay Bridge (SFOBB) project.

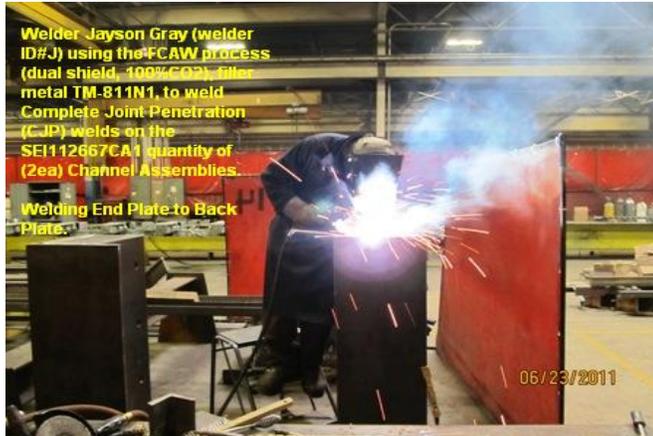
This (QAI) met with Watson Bowman Acme Corporation Quality Control Manager (QCM) Mr. Gregory Ross, Quality Control Supervisor (QCS) John Miller and (KTA-Tator, American Welding Society Certified Welding inspector (AWS CWI) Mr. John Gotwald inspector on the day shift. Welding has not started on the night shift.

This QAI notified the QCM and AWS CWI, Mr. Gotwald that an incident report is to be filled out by this QAI due to welding operations being performed without a Caltrans approved Welding Quality Control Plan (WQCP), which is in direct non conformance with Section 8-3 of the Special Provisions, "Welding".

This QAI observed certified welder Jayson Gray (welder ID#J) using the FCAW process (dual shield, 100% CO₂), filler metal TM-811N1, to weld Complete Joint Penetration (CJP) welds on the SEI112667CA1 quantity of (2ea) Channel Assemblies. The approved FCAW Welding Procedure Specification (WPS) was Watson Bowman - WPS FCAW 13. All welding was being performed in the 1G flat position.

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Summary of Conversations:

The QCM relayed to this QAI that the additional bolts ordered for the Mock-up assembly have not arrived but will notify when bolts arrive. The QCM is aware of the incident report for welding with no WQCP and relayed that revised WQCP will be resubmitted with changes as soon as possible.

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: Broening, Dustyn

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer