

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-025903**Date Inspected:** 02-Aug-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 Joint 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 Quality Assurance Inspector (QAI) met with Watson Bowman Acme Corporation (WBA) 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.

This QAI observed certified welder Jayson Gray (welder ID#J) using the FCAW process (dual shield, 100%CO₂), filler metal TM-811N1, to weld fillet welds on the SEI112667CA2 quantity of (4ea) of (24ea required) Channel Assemblies were completed at this time. Welds were performed on the Bottom Plate to Channel Leg connections.

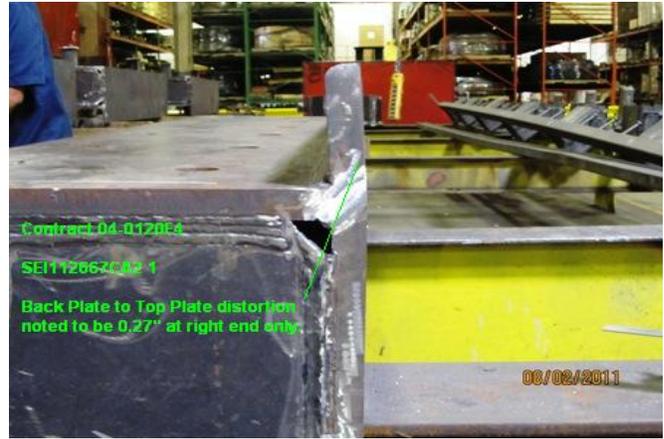
All welding was being performed in the 2F position. QAI informed QCM, QCS and AWS CWI that Incident Report #87 will be issued for Welding without an approved 2F position, FCAW process Welding Procedure Specification (WPS) within the Welding Quality Control Plan (WQCP). WPS used was WPS #FCAW-11.

Dimensions were checked per SMR Bahjat Dagher request and flatness of Top Plate was verified to be acceptable.

It was noted that 3/16" to 1/4" distortion exists within the Top Plate to Back Plate area on SEI112667CA2 2, SEI112667CA2 3, SEI112667CA2 4 and found to be acceptable. However on SEI112667CA2 1, it was noted to be in excess of 1/4" distortion tolerance and was measured to be 0.27". SMR Bahjat Dagher was notified of distortion issue on SEI112667CA2 1.

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Summary of Conversations:

Other basic communication was performed between the QA Inspector and the QC Manager during this visit.

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: Edmondson, Fred

QA Reviewer