

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-026145**Date Inspected:** 15-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 SEI112667CA2 5, SEI112667CA2 6, SEI112667CA2 7 and SEI112667CA2 8 (4 assemblies) of (24ea required) Channel Assemblies are being worked on at this time. Welds are being performed on the Bottom Plate to Back Plate inside connections. All welding was being performed in the 2F position and are being installed within the parameters of unapproved WPS #FCAW-11 (reference Incident Report #87). Dimensions were checked per SMR Bahjat Dagher request and were verified to be acceptable at time of inspection. See attached photos.

This QAI then traveled to K.D.M. Die Co. Inc. at 620 Elk St. Buffalo, NY to observe machine shop operations where Deck Plates are currently being machined. Upon arrival at machine shop QAI met with K.D.M. owner and manager Mr. Gary Posluszny. This QAI observed that (9ea) completed Deck Plates SEI112667AC have been completed and are awaiting final QC/QA inspection. Deck Plate SEI112667AC 1, has been verified for dimensions by this QAI and QCM on 7/05/11.

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Summary of Conversations:

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

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
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Reviewed By:	Edmondson,Fred	QA Reviewer
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