

**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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026271**Date Inspected:** 13-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman Associates**Location:** Buffalo, NY**CWI Name:** John Miller**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:** Hinge A Expansion Joint**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Fred Edmondson was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion 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 Manager (QCM) Mr. Gregory Ross, Quality Control Supervisor (QCS) John Miller and (KTA-Tator, American Welding Society Certified Welding Inspector (AWS CWI) Mr. Reno Davis.

This (QA) Inspector met with Watson Bowman Acme Corporation Quality Control (QC) Manager Mr. Gregory Ross, Quality Control (QC) Supervisor John Miller and (KTA-Tator, American Welding Society Certified Welding Inspectors, (AWS CWI) Mr. Reno Davis and Mr. Claude Evans. AWS CWI Evans is assigned to the night shift. This QAI verified that Mr. Evans AWS CWI certification is current and received a copy of the certificate.

This QA inspector observed that welding was not in-process on this project on this date. Activity on this project consisted of in-process back grinding of the top plate to backing plate CJP weld on SEI 112667 CA2-6. In addition, certified welder James DeVirgilio was setting -up the welding machine to practice welding the fillet weld soundness. Mr. DeVirgilio was running weld passes on scrap steel (mock-ups).

This QAI observed the CJP weld of the top plate to backing plate weld profile after back grinding has an approximately 7 mm opening at the root with a crack at one end and a burn-through (grind-through) in the bevel.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

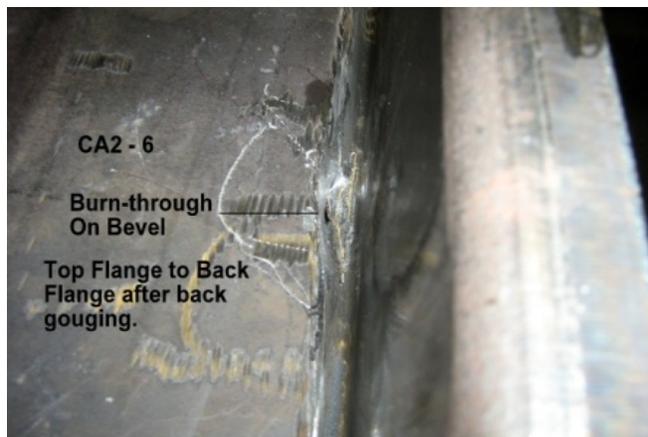
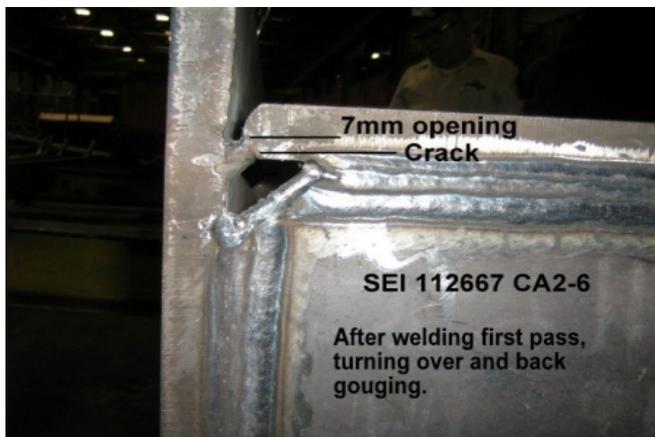
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The depth of back grinding is approximately 18 mm to 22 mm through-out the length of the weld. Reference the attached photographs.

## Summary of Conversations:

QCS Miller commented to this QAI that WBA will run a fillet weld soundness test tomorrow and that they may run a 6 mm single pass instead of an 8 mm single pass fillet weld. AWS CWI Davis informed this QAI that he saw numerous slag inclusions in the deposited weld metal while observing the back grinding of the top plate to back plate CJP weld (CA2 -6).



## 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.

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**Inspected By:** Edmondson, Fred

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer