

**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-026272**Date Inspected:** 14-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 (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 activity was in-process. Activity on this project included of in-process arc-gouging and grinding of the bevel angle of the top plate to back plate CJP weld on SEI 112667 CA2 - 6 and CA2 - 8 assemblies. The bevel was ground to give a dimension of approximately 16 mm from FACE "C" to the bevel edge at FACE "A". (Unable to measure the bevel-angle with a Bridge Cam Gage – resultant angle may be less than 45 deg. if the depth of back-gouging is greater than 16 mm – TAN of FACE "A" weld width over FACE "C" depth.)

This QAI observed certified welder James DeVirgilio welding a fillet weld soundness coupon. The single-pass weld measured 6 mm. The multiple pass fillet welds measured 10 mm. QCS Miller decided to try again to get a 6 mm single-pass and an 8 mm multiple-pass fillet weld.

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# WELDING INSPECTION REPORT

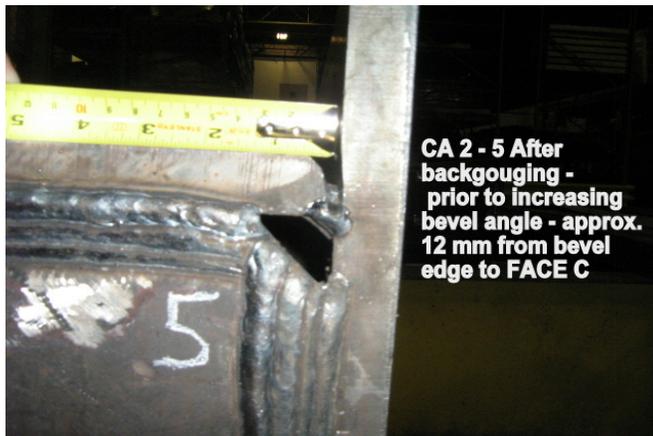
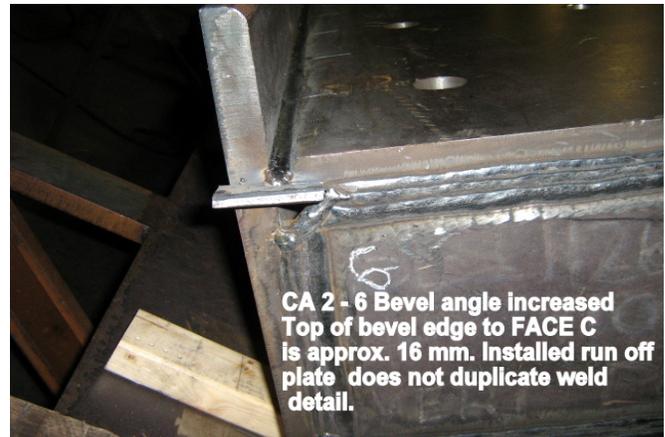
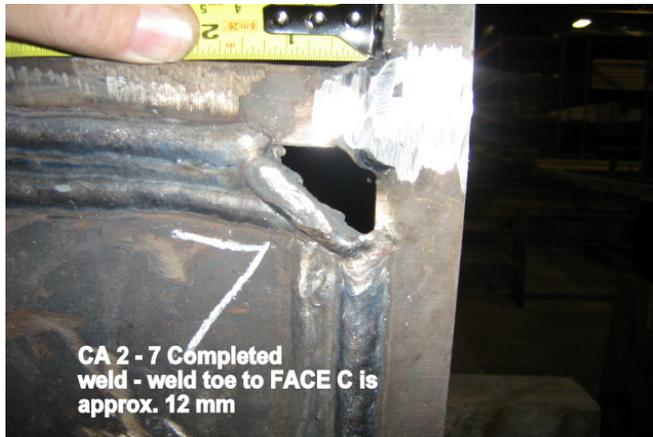
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## Summary of Conversations:

QCS Miller said that he intends to have another weld qualification coupon test Friday the 16th.



## 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