

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-026297
Date Inspected: 16-Sep-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Watson Bowman Associates

OSM Arrival Time: 1100
OSM Departure Time: 1930
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 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 QA inspector observed Certified welder Jason Gray #J preparing to fit-up 22x200 mm conical anchor studs (studs) to assembly SEI 112667 CA2 – 8. This QAI received a copy of the MTR and stud base qualification documents and verified the studs were manufactured to ASTM A108.

This QAI requested a copy of WBA's stud welding WPS and have not received it at this time. The fit-up and welding of the studs had not begun at the time of this QAI's departure.

This QAI observed certified welder James DiVirgilio #L welding a fillet weld soundness coupon. The single-pass weld measured 6 mm. The multiple-pass fillet weld measured 10 mm after two passes. QCS Miller decided to end the test and to scrap the coupon. (The goal is to weld a 8 mm single-pass and a 8 mm multiple-pass fillet weld within the heat input parameters of the WBA approved WPS No. FCAW-NY-16. WBA has been able to achieve a 6 mm single-pass weld within the required parameters, only.)

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Summary of Conversations:

AS noted above. QCS Miller said that he intends to run another fillet weld soundness qualification test Tuesday the 9-20-11).

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:	Edmondson,Fred	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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