

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-026323
Date Inspected: 23-Sep-2011

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

OSM Arrival Time: 1530
OSM Departure Time: 2330
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:	OBG	

Summary of Items Observed:

On this date, Quality Assurance Inspector (QAI) Kenneth Riley 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 (ABF), Certified Welding Inspector (CWI) Mr. Claude Evans. Mr Evans is assigned to the night shift.

This QAI observed certified welder Jayson Gray (welder ID#J) using the FCAW process (dual shield, 100% CO₂), filler metal TM-811N1, to perform the fit-up of component number SEI112667 CA3-1, Channel Assembly (1 of 2). The weld joints fit were the top plate to back plate CJP groove weld with a measured root opening of 0 (tight fit) and the stiffener fillet welds to top plate and back plate (tight fit). Also noted was that WBA is in the process of cleaning Components SEI112667-CA2- 1, 4, 6, and 8 for final visual acceptance by the WBA QC department. The sniped areas were being ground to a smooth profile to remove weld termination imperfections along with weld spatter and other various items associated with the final visual acceptance.

Summary of Conversations:

Conversation fundamental to completion of the task at hand occurred between this QAI and WBA personnel.

WELDING INSPECTION REPORT

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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:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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