

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-026413
Date Inspected: 26-Sep-2011

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

OSM Arrival Time: 800
OSM Departure Time: 1600
Location: Buffalo, NY

CWI Name:	Reno Davis	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:

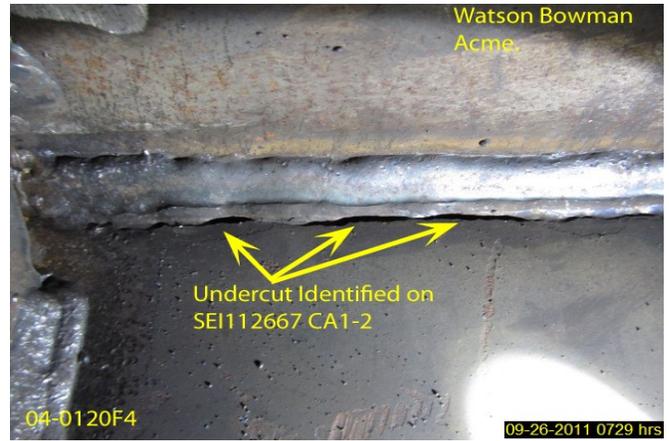
On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QA) Inspector met with Watson Bowman Acme Corporation Quality Control (QC) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Reno Davis.

This QAI observed WBA personnel Gary Janus performing grinding and clean up on (4) four channel box assemblies identified as SEI112667 CA2-1,4,6, and 8. Mr. Janus was observed as removing weld spatter grinding weld termination and a general overall cleaning of the assemblies. WBA QC supervisor Mr. Miller informed ABF representative Reno Davis that these assemblies were ready for his inspection. This QAI inspector accompanied Mr. Davis with the inspection and noted multiple discrepancies with the weld and snipe areas. These discrepancies included undercut, arc strike, and stop starts not fused within the snipe location. After discussing these issues with Mr. Davis it was determined that WBA QC needed to re-evaluate these components and address these issues prior to presenting them to ABF and Caltrans for final acceptance. It was noted that WBA has not continued with the welding process of the Seismic Expansion Joints as of date. They have delivered the single pass fillet weld soundness test for evaluation to a local testing facility. Mr. Davis is to witness this testing tomorrow at 0830 hrs. for conformance to the contract documents. Test results are to be submitted at that time.

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Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC , and WBA personnel .

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
Reviewed By:	Levell, Bill	QA Reviewer
