

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-026420**Date Inspected:** 28-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Watson Bowman ACME**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 (WBA) Quality Control (QC) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Reno Davis (Day Shift) and John Gotwald (Night Shift).

This QAI observed WBA welding personnel Gary Janus performing welding, grinding and clean up on (5) Five channel box assemblies identified as SEI112667 CA2-1,4,6, and 8. Mr. Janus was observed as removing weld spatter, grinding weld termination, welding minor deficiencies and a general overall cleaning of the assemblies. The area's that required welding included undercut and start/stop locations behind the stiffeners at the snipe locations. Mr. Janus was observed using a rose bud torch to pre-heat the areas to 107 degrees Celsius (225F). The process used for the welding was Flux Core Arc Welding (FCAW) with Hobart (Tri-Mark) TM-811N1 electrode. The parameters appeared to be within the specified Welding Procedure Specification (WPS) WBA-FCAW-CA-2010. WBA night shift welding personnel James DiVirgillio arrived at WBA to perform welding on the seismic Expansion Joint Hinge A assemblies. This QAI met with Mr. DiVirgillio as he was directed with the welding that was to be performed this night by Mr. Miller. Mr. DiVirgillio continued welding the Complete Joint Penetration (CJP) weld and the reinforcing fillet welds behind the snipe location on assembly CA3 (number 2 fit up). Mr. Miller and Mr. Davis will be monitoring the welding process on the night shift.

A current list of components in process is as follows;

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Fit up and welding

SEI112667-CA3-1

SEI112667-CA3- (?)Not stamped yet

Waiting Base Metal Repair procedure.

SEI112667- CA2-8

Welded (cleaning and visual repairs)

SEI112667-CA2-1

SEI112667-CA2-4

SEI112667-CA2-6

SEI112667-CA1-1

SEI112667-CA1-2

SEI112667-CA2-3

SEI112667-CA2-5

SEI112667-CA2-2

SEI112667-CA2-7 (2- 12" studs needed)

Summary of Conversations:

Basic conservation, 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