

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-026468**Date Inspected:** 04-Oct-2011**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Watson Bowman ACME**OSM Arrival Time:****OSM Departure Time:****Location:** Buffalo, NY**CWI Name:** Reno Davis, John Crabtree**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). KTA-Tator has assigned a new CWI to the project, Mr. John Crabtree who will be covering the night shift. This QAI did verify his CWI certification which was up to date. The verification was performed through the American Welding Society's web page for certifications.

This QAI observed WBA welding personnel Jason Gray performing Flux Core Arc Welding (FCAW) welding on component SEI112667-CA3-2, using Hobart (Tri-Mark) TM-811N1 electrode. The weld joint was identified as a Complete Joint Penetration weld, TC-U4b-F under WPS FCAW-13 (CJP) and WPS FCAW-11 (Multi-pass Fillet) the parameters were checked by ABF QC and verified by QAI. They appeared to be within the specified Welding Procedure Specification's (WPS). Mr. Gray was also observed using a rose bud torch to pre-heat the areas to 93 degrees Celsius (200F). The FCAW-11 is waiting for the single pass soundness test to be passed by WBA. Contractor is proceeding at their own risk with single pass welding which they have been informed.

This QAI also observed WBA welding personnel John DiVirgillio performing Flux Core Arc Welding (FCAW) welding on component SEI112667-CA3-1, using Hobart (Tri-Mark) TM-811N1 electrode. The weld joint was identified as a Complete Joint Penetration weld, TC-U4b-F under WPS FCAW-13 (CJP) and WPS FCAW-11 (Multi-pass Fillet) the parameters were checked by ABF QC and verified by QAI. They appeared to be within the

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specified Welding Procedure Specification's (WPS). Mr. DiVirgillio was also observed using a rose bud torch to pre-heat the areas to 93 degrees Celsius (200F). The FCAW-11 is waiting for the single pass soundness test to be passed by WBA. Contractor is proceeding at their own risk with single pass welding which they have been informed.

All CJP welds were back gouged to visual sound metal and verified by ABF QC prior to performing the welding operations.

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
