

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-026484**Date Inspected:** 05-Oct-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, 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, and Mr. John Crabtree night shift.

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 that joined the bottom plate to the back plate under, WPS FCAW-13 (CJP) TC-U4b-F 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 that joined the Back plate to the bottom plate under, TC-U4b-F under WPS FCAW-13 (CJP) and stiffener to top plate with a 10mm fillet weld under WPS FCAW-11 (Multi-pass Fillet). Also noted was that WBA welder DiVirgillio had performed welding on the stiffeners to bottom plate with

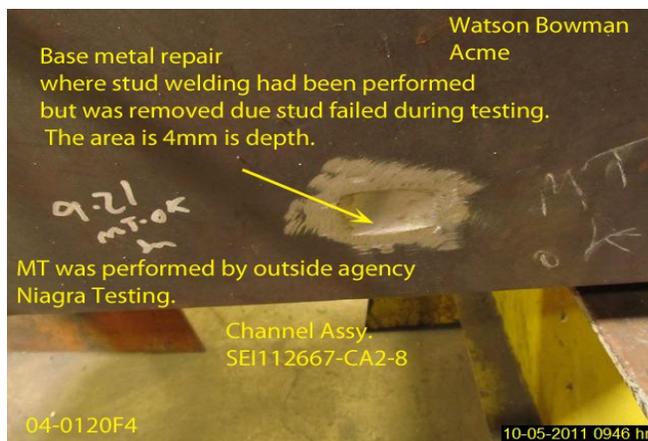
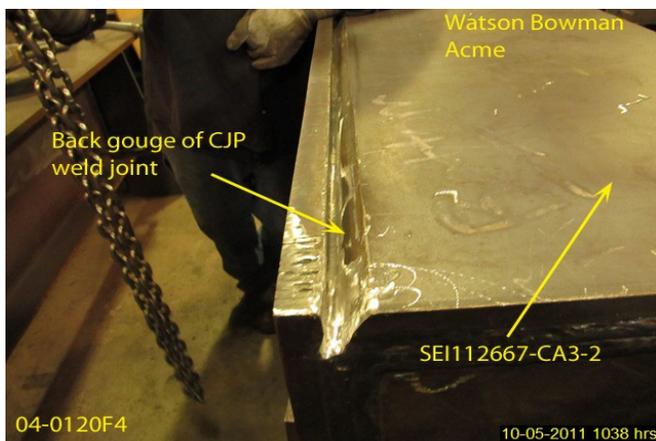
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

a Partial Joint Penetration weld (PJP) with joint detail TC-P5-F as outlined in the revised drawings (revision 11). As of this date WBA does not have an approved WPS for this joint detail. A TL-15 was generated for this discrepancy. WBA is welding at their own risk. 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.

This QAI documented a Base Metal Repair location that had been ground and previously tested with Magnetic Particle Testing (MT) by Niagra Testing. The testing had taken place on Sept. 21, 2011. A MT test report was generated and this QAI received a copy of the report from ABF representative Reno Davis. WBA was informed that they needed to submit the repair procedure under and amendment to the WQCP.



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
