DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026485
Date Inspected: 06-Oct-2011

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

OSM Arrival Time: 1100
OSM Departure Time: 1900
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:

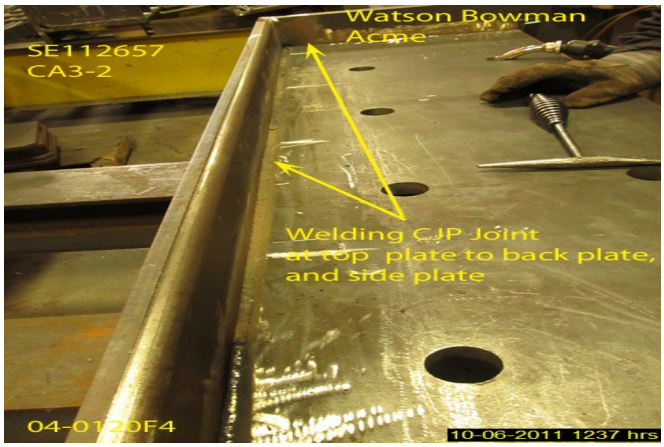
On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

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 top plate to the back plate under and side plate to top plate. WBA is using WPS, FCAW-13 (CJP) TC-U4b-F and WPS FCAW-11 (Multi-pass Fillet) the parameters where 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

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 performeing the welding operations.

This QAI spoke with WBA concerning the removal and transportation of sixteen (16) CA2 top plates that had been previously rejected by WBA due to the 39.5mm holes had been flame cut by WBA sub-contractor. WBA stated that they sent the to Private Sysytem for over boring. WBA stated that if Private Sysytems was able to achieve a true and acruate diminseion then WBA would submit a RFI to the department for approval.



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