

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-026522**Date Inspected:** 13-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 (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Reno Davis Day Shift, and Mr. John Crabtree night shift. ABF Representatives are the Quality Control personnel for this location.

This QAI observed WBA personnel Gary Janus performing grinding and clean up on (12) twelve channel box assemblies identified as SEI112667 CA2-1 and 2; CA2-1~8 and CA3-1 and 2. Mr. Janus was observed as removing weld spatter grinding weld termination and performing welding where visual discrepancies have been noted by ABF QC along with a general overall cleaning of the assemblies. Noted was ABF QC Reno Davis performing visual inspection on these components and identifying the discrepancies. Also noted was on Channel CA3-1 where the 1mm misalignment had been discovered. WBA performed grinding on the base metal and CJP reinforcement to reduce the base metal thickness by 1mm. By performing this grinding within this area and reducing the base material thickness the misalignment is now at 2.5~3mm which was measured by this QAI. The length of the ground area was also measured and was 711mm in length. See attached photos.

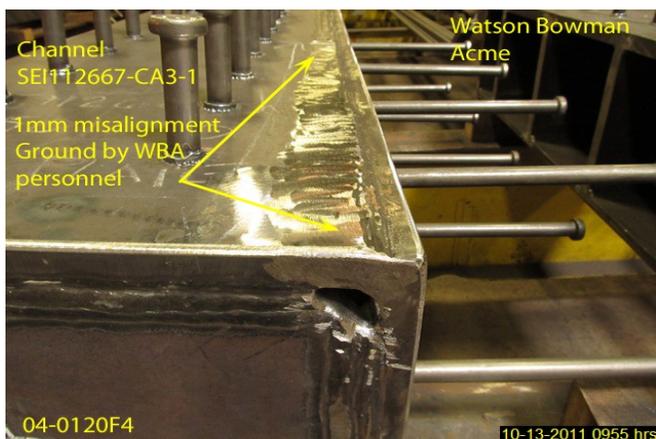
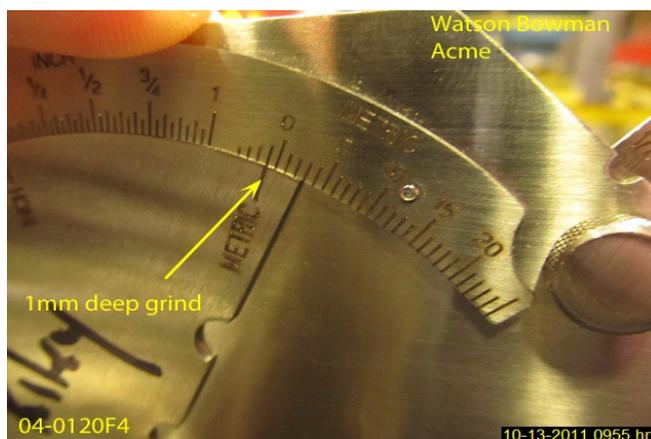
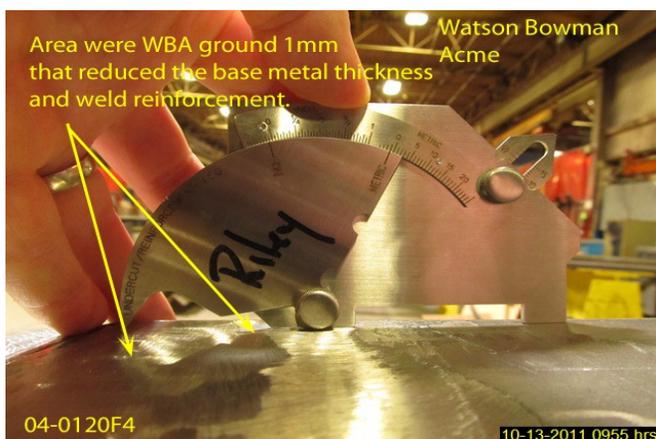
This QAI performed a visual observation on 4 components identified as CA2-3, CA1-2, CA2-5 and CA2-6. This observation was for visual inspection of the fillet, PJP and CJP welds located within the identified components. The visual observation appeared to meet the visual criteria only due to outstanding issues that have not been resolved as of this date. These issues have been identified in previous reports that include, single pass fillet weld

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soundness test, approved WPS for the TC-P5-F PJP weld detail, and Base Metal Repair procedure. The observation was to clear visual discrepancies only.

WBA welding personnel Nikolas Mattoon was performing grinding and clean up on (12) twelve channel box assemblies identified as SEI112667 CA1-1; CA2-1, and 7~8 and CA3-1 and 2. Mr. Mattoon was observed as removing weld spatter grinding weld termination and performing welding where visual discrepancies have been noted by ABF QC along with a general overall cleaning of the assemblies. Noted was ABF QC John Crabtree performing visual inspection on these components and identifying the discrepancies.



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
