

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-026562**Date Inspected:** 18-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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 along with Structural Material Representative (SMR) 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 (QAI) 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 arrived at WBA along with the SMR Mr. Bahjat Dahjer and met with Greg Ross the QCM and John Miller the QC supervisor for WBA. This QAI and SMR had a meeting regarding outstanding issues for the Seismic Joints Hinge A status. The items discussed were as follows;

- 1) Top Plates
- 2) Base Metal Repairs
- 3) PJP WPS
- 4) Fillet weld soundness test single pass

The SMR spoke with Caltrans Construction in regards to the top plates and the "threaded" holes. It was agreed upon resolution was that the (16) sixteen top plates for the CA2 channels did not conform to the contract documents. There for the plates have been removed from the project and WBA will be ordering new top plates from Samuel's.

The Base metal repair procedure and PJP WPS will be submitted along with the addendum and corrected notes for

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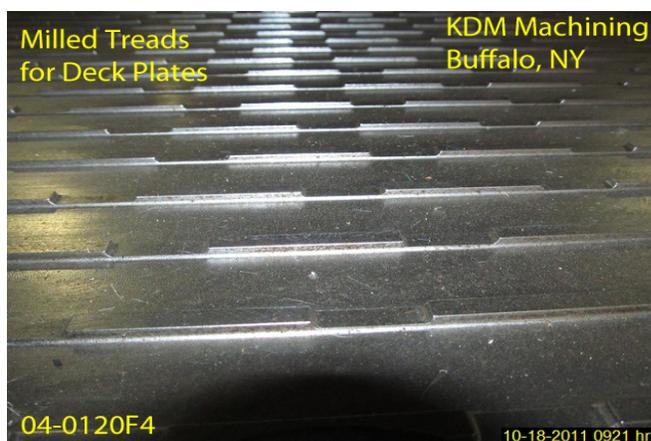
the Welding Quality Control Plan (WQCP). Also included shall be Niagara Testing's NDT procedure and technicians Qualifications due to the Magnetic Particle Testing (MT) requirements for the base metal repairs. The Fillet Weld Soundness test WBA is switching processes from Flux Core Arc Welding (FCAW) to Shielded Metal Arc Welding (SMAW) due to they have an approved SMAW fillet weld WPS.

All the submittals was agreed upon to be submitted by close of business on Friday the 21st of October 2011 by the QCM Greg Ross.

The SMR and this QAI travelled to KDM Machining in Buffalo, NY to observe the deck plates that have been milled for the Seismic Joint Hinge A. We were met by the owner Gary Posloszny and were given a brief tour of the facility and the equipment that the company is using to perform the milling operations. Also noted was a brief observation of the dimension on a couple of the deck plates which appeared to be within the contract documents.

A more thorough dimension check will be made at a later date for release.

No welding was observed on the day or night shift.



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
