

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-026716**Date Inspected:** 10-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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:** Hinge A**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 (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 Eagle Fabrication the Sub Contractor for Watson Bowman Acme (WBA) who had performed the 19mm taper last week (Friday 11-4-11) on SP1. This QAI along with Eagle fabrication personnel and WBA QCM Greg Ross was onsite to record plate measurements of SP3 which had been flattened with rollers at Eagle fabrication. After using a straight edge it was observed that the plate was within 1mm of flatness which was observed by this QAI and WBA Greg Ross. Eagle fabrication then applied the 19mm taper at which time the taper was measured along the full width by all parties and observed the 19mm taper. It was then suggested that WBA contact ABF personnel on which direction to proceed and that WBA should consider drafting and submitting a Request For Information (RFI) to the department for either clarification of the tolerance or moving forward with flattening all 28 plates prior to applying the 19mm Taper.

Arriving at WBA this QAI noted that welder Jayson Gray was performing Flux Core Arc Welding (FCAW) welding on component SEI112667-CA2-9, using Hobart (Tri-Mark) TM-811N1 electrode. The Complete Joint Penetration (CJP) welds identified as 7A, 7B, 7C 7D, 7E and 7F had been completed. The welder was in process

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of welding CJP joint BB-B with the intermediate weld passes. QC personnel Reno Davis was observed onsite and monitoring the welding of these joints. Also he was noted as checking the welding parameters for compliance to the Welding Procedure Specification (WPS).

John Crabtree QC for the night shift is monitoring the welding for ABF on the night shift were James DiVirgillio is performing welding and fit up of CA2-10. It was noted that Mr. DiVirgillio had completed the 10mm fillet welds (2A,B,D,F; 3A,B,D,F; 4A,B,D,F; 5A,B,D,F; 6A,B,D,F) and Partial Joint Penetration weld (PJP) to the bottom plate (2C,F; 3C,F; 4C,F; 5C,F; 6C,F). At this time the welder is working on CJP welds TB-A and BB-B with the opposite side of these welds completed.



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
