

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-026770**Date Inspected:** 15-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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:**

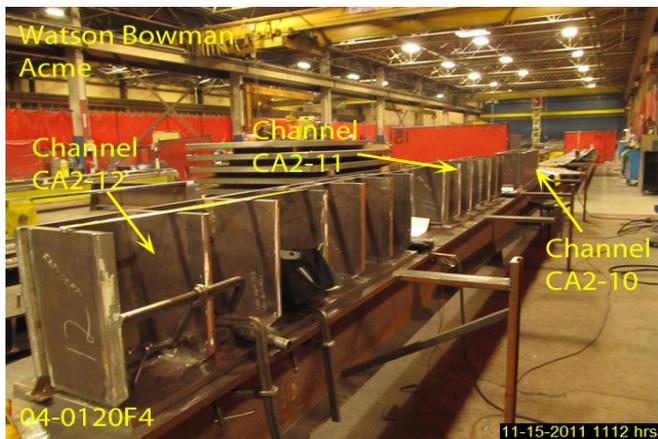
On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

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 WBA and observed Jayson Gray was performing Flux Core Arc Welding (FCAW) welding and fit up on components SEI112667-CA2-11 and 12, using Hobart (Tri-Mark) TM-811N1 electrode under WPS's FCAW-NY-16 (CJP for Joint TC-U5a-GF), FCAW-13 (CJP for joint TC-U4b-GF) and FCAW-11 (Multi-pass Fillet weld). Mr. Gray was observed using a rose bud torch to pre-heat the areas to 107 degrees Celsius (225F). The Complete Joint Penetration (CJP) welds that pass behind the internal stiffeners were welded by removing every other stiffener and cascading the CJP weld at weld numbers TB-B and BB-A. The 10mm fillet welds attaching the top plate and back plate to the stiffeners will be started welding also for weld numbers 2A,B,D,E; 3A, B,D,E; 4A,B,D,E; 5A,B,D,E; 6A,B,D,E. 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). Mr. John Crabtree QC for the night shift is also performing observations and monitoring of the welding for ABF on the night shift. WBA has James DiVirgillio performing welding and fit up on Channel CA2-10.

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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
