

**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-026771**Date Inspected:** 17-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 along with Senior Structural Material Representative (SMR) Mazen Wahbeh, Resident Engineer Bill Casey and Design Mike Whitehouse 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 Manager (QCM) Greg Ross for meetings and tour of the facility. During the meeting with all personnel listed it was determined that due to Watson Bowman Acme could proceed with the flattening process of the support plates prior to applying the 19mm taper. This will insure that the 19mm taper will be applied evenly through the cross section of the support plates. Mr. Casey and Mr. Wahbeh also stated that WBA QC needed to take measurements prior to flattening of each plate and after flattening of each plate to be submitted with the RFI to the department for additional process. Also discussed was the seal weld applied to the face of the stiffeners. Mr. Wahbeh stated that WBA should grind the face flush until they see the transition line of the 2 plates and then grind both welds on each side of the plates at a 45 degree angle. This would fall under a weld repair and elevate the need for an RFI. Also discussed was the lifting lugs and erection aides that were welded to the channels using the single pass FCAW fillet weld and the removal process being used. WBA agreed to perform and document each location with Magnetic Particle Testing to ensure sound material. These components were welded at their own risk due to WBA did not have an acceptable single pass fillet weld soundness test.

Also noted this day was welders Jayson Gray and Joe Kearns performing Flux Core Arc Welding (FCAW)

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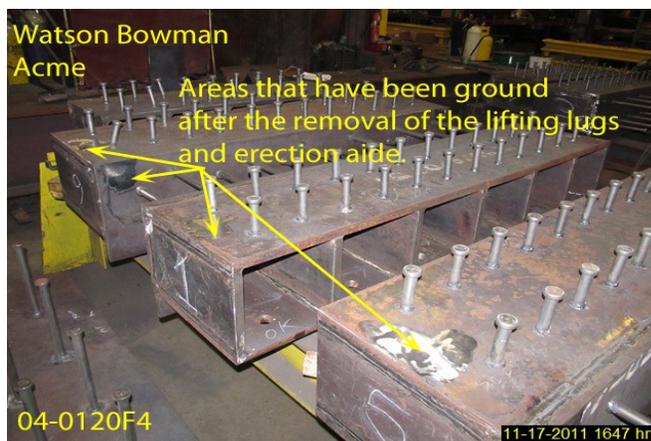
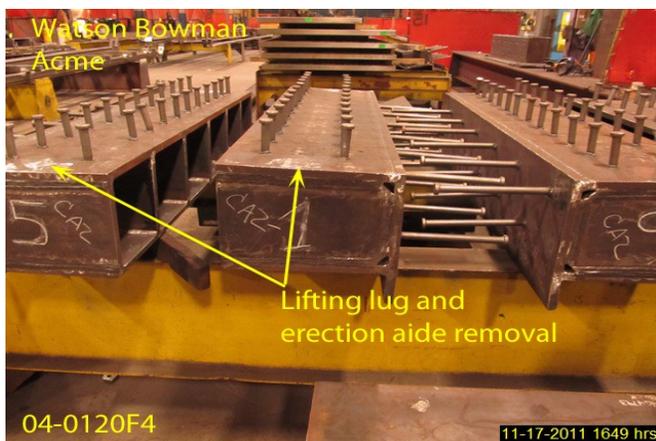
# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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welding and fit up on components SEI112667-CA2-11 and 12, using Hobart (Tri-Mark) TM-811N1 electrode under WPS FCAW-13 (CJP for joint TC-U4b-GF). Mr. Gray and Mr. Kearns were observed using a rose bud torch to pre-heat the areas to 107 degrees Celsius (225F). The Complete Joint Penetration (CJP) welds were; CA2-11, 6D, 6E and 6F and CA2-12, 6D, 6E and 6F. Also noted is Gary Janas removing the lifting lugs and erection aides that were welded to the channels using the single pass FCAW fillet weld. These components were welded at their own risk due to WBA did not have an acceptable single pass fillet weld soundness test. Mr. Janas was observed using an oxygen/acetylene torch to cut the components off approximately 3-4mm above the base metal then grind the remaining material off. It was also noted that WBA would perform Magnetic Particle testing at each location to ensure sound material prior to re-welding. 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.



## 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.

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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