

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-026840**Date Inspected:** 08-Dec-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.

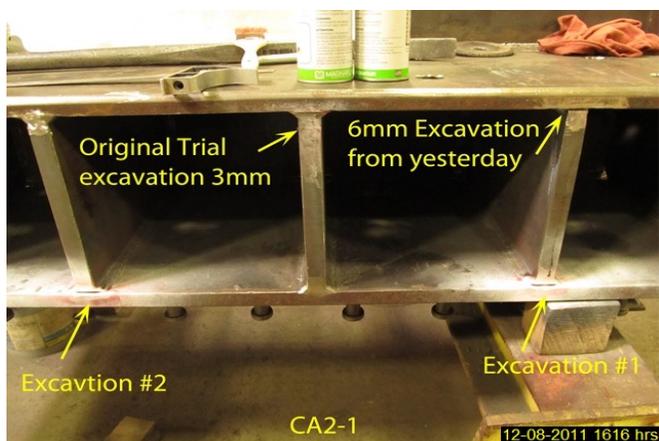
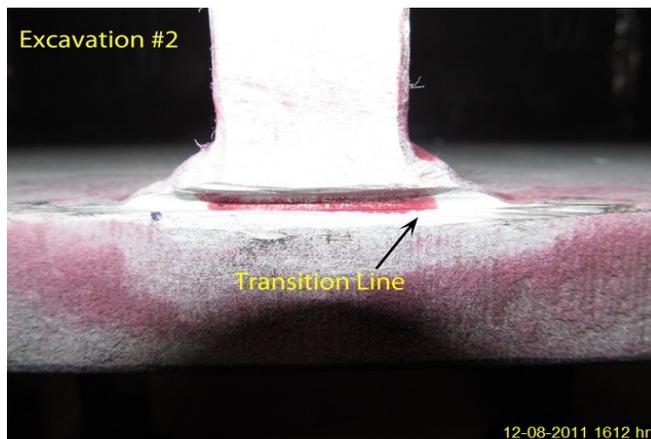
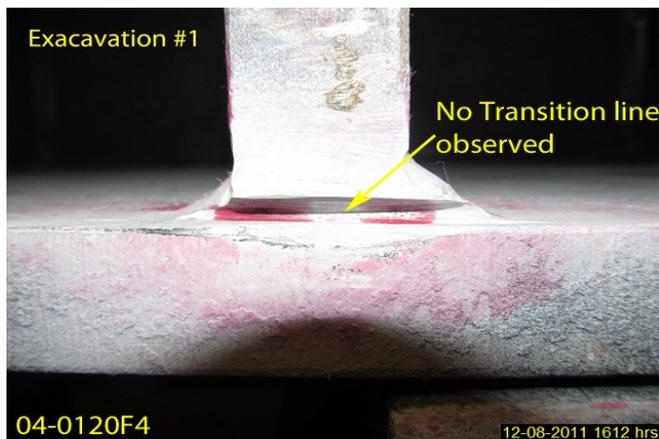
This (QAI) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Mr. John Crabtree. ABF Representatives are the Quality Control personnel for this location.

This QAI arrived at WBA and observed welder John Ash performing the removal of the seal weld on channel CA2-1. Mr. Ash was using a grinder with a 1.6mm (1/16) cutting disk to remove the seal weld up to 6mm deep at the transition from stiffener to top plate. Mr. Ash removed had removed the seal weld of the stiffener to bottom plate (10mm fillet weld) yesterday but did not penetrate to the transition line. Upon a discussion with QCM Greg Ross it was agreed that Mr. Ash would continue grinding this location due to the agreement that the welder may had ground at an angle and was not level going in. Mr. Ash continued grinding this location up to 6mm deep; it was observed that the transition line was not achieved. At this point the welder stopped and was not going to grind any further due to causing damage to the fillet welds. This QAI spoke with the SMR and informed him of the status of this location, in turn the QAI was informed to stop grinding until other locations could be ground and the transition could be identified. At this time WBA welder Mr. Ash ground another stiffener to bottom plate location and used die penetrant (for information only) to achieve the transition line. Once the welder ground into the seal weld area 6mm the welder then used die penetrant to observe the transition line for this location. After completion of the grinding, Welder John Ash was performing stud welding on the SP3 support plates. The studs being placed

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were 300mm in length x 22mm in diameter. Approximately 48 studs being welded per SP3 plate. The QC inspector Reno Davis was observed onsite and monitoring the welding of these components. Mr. Davis was also noted as checking the welding parameters for compliance to the Welding Procedure Specification (WPS). Mr. John Crabtree is the QC for the night shift and is monitoring all welding and inspection at night for the SFOBB project at this facility.



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
