

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-026841**Date Inspected:** 07-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.

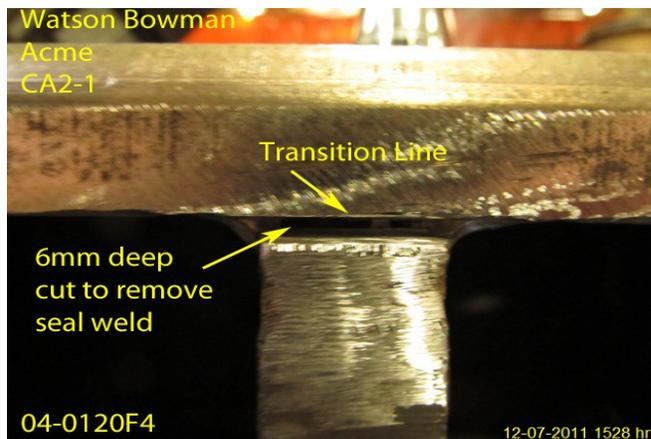
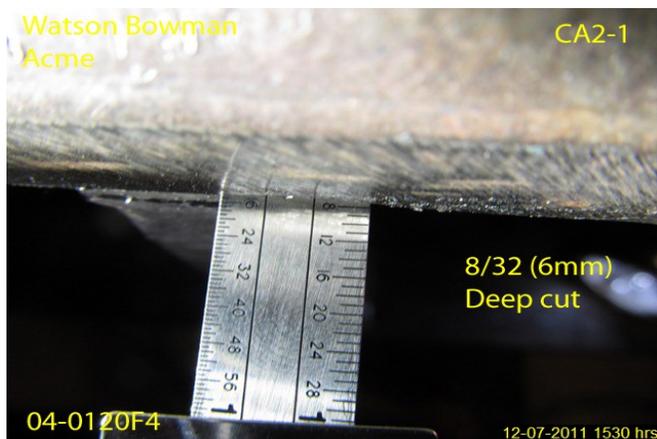
This (QAI) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Mr. John Crabtree. ABF Representatives are the Quality Control personnel for this location.

This QAI arrived at WBA and observed Joe Kearns performing Flux Core Arc Welding (FCAW) on component SEI112667-CA2-16; using Hobart (Tri-Mark) TM-811N1 electrode under WPS's FCAW-11 (Multi-pass Fillet weld). The welder was observed using a rose bud torch to pre-heat the areas to 107 degrees Celsius (225F). The weld joints being welded by Joe Kearns at the end plate were the internal stiffener plates joining the stiffeners to the top plate and back plate using a 10mm fillet weld. This QAI 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 this are and also performed grinding at a 45 degree angle to step back the welds for the size of the weld (10mm). Upon a close observation of the area it was noted that the transition line could be seen. This information and photos was sent to the SMR for further evaluation. During the observation it is noted that the bottom stiffener to bottom plate welds channels CA2-1~4 and CA1-1~2 had 10mm fillet welds placed at all three sides (6 welds) of the stiffeners. The bottom plate to stiffener welds were later changed to a double bevel PJP (partial Joint Penetration) weldment on 8-3-11 as noted on the shop drawings. QC personnel Reno Davis was observed onsite and monitoring the welding

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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
