

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-026842**Date Inspected:** 06-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 components SEI112667-CA2-16, using Hobart (Tri-Mark) TM-811N1 electrode under WPS's FCAW-NY-16 (CJP for Joint TC-U5a-GF). 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 7 D~F with reinforcing 8mm fillet welds. These welds on the channel boxes join the end plate to top, back and bottom plate. Also noted was welders John Ash and Jayson Gray had welded the 75mm x 19mm flat bar to deck plates SEI112667AA-1 and AB-1 with a 6mm single pass fillet weld. ABF QC has not performed their inspection at this time. Welder Jayson Gray was observed placing single pass SMAW fillet welds for the erection aides (flat plate to angles) for the support plates. Welder John Ash was observed performing stud welding on the channel box CA2-10. The studs being placed were 100mm in length x 22mm in diameter. Approximately 24 studs being welded on the bottom plate. QC personnel 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.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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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.

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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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