

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011464**Date Inspected:** 14-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman Acme**Location:** Amherst, New York

CWI Name: John Miller, Greg Ross
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Seismic Joint (Hinge AW & AE)**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Watson Bowman Acme (WBA) facility in Amherst, New York for the purpose of observing Procedure Qualification Record (PQR) test fabrication of the Seismic Joint (Hinge AW & AE).

WBA Shop- (PQR-1G):

QA Inspector Brannon witnessed WBA welder Mr. Mike Armitage welding Procedure Qualification Record (PQR) test verification number FCAW-CA-PQR-2010. QA Inspector Brannon observed WBA QC CWI Mr. John Miller monitoring the PQR test. See Caltrans Welding Witness Report, TL-6032 dated January 14, 2010 for additional information.

WBA Shop- (PQR-Fillet test #1):

QA Inspector Brannon witnessed WBA welder Mr. Mike Armitage welding Procedure Qualification Record (PQR) number FCAW-fillet weld soundness. QA Inspector Brannon observed WBA QC CWI Mr. John Miller monitoring the PQR test. Mr. Armitage deposited one pass on the FCAW-fillet weld soundness test. QC Mr. Miller performed visual inspection on the test plate after the first pass and rejected the fillet weld soundness test.

WBA Shop- (PQR-Fillet test #2):

QA Inspector Brannon witnessed WBA welder Mr. Mike Armitage welding Procedure Qualification Record (PQR) number FCAW-fillet weld soundness. QA Inspector Brannon observed WBA QC CWI Mr. John Miller monitoring the PQR test. QA Inspector Brannon observed WBA QC CWI Mr. John Miller monitoring the PQR test. QC Mr. Miller performed visual inspection on the fillet weld soundness test and rejected the test plate for

WELDING INSPECTION REPORT

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undercut.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

As stated within this report.

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 James Devey, (510) 301-0162, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
