

**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-011552**Date Inspected:** 18-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 / K.D.M.**Location:** Amherst / Buffalo, NY**CWI Name:** Greg Ross**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:** 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:**

QA Inspector Brannon randomly observed WBA personnel flame cutting steel plates for the purpose of fabricating seismic joint A. The QA observed WBA in the process of using a cnc burning machine to cut the ASTM A709 345M steel plates for the top, bottom and vertical steel plates for channel assembly SEI112667CA1 and SEI112667CA2. The identified heat number for the steel plates being cut is heat # 9105797. During QA observation, QA observed no problems in the cutting process. Quality Control Mr. John Miller informed QA Inspector Brannon that a total of 24 top plates, 4 bottom plates and 36 vertical plates for the channel assembly have been cut to date.

**K.D.M. Die Co., Inc.**

QA Inspector Brannon traveled with WBA Quality Control Mr. Greg Ross to K.D.M. Die Co., Inc. QA Inspector Brannon and WBA Mr. Greg Ross met with K.D.M. Mr. Gary Posluszny Owner. Mr. Greg Ross, Mr. Posluszny and QA Inspector Brannon reviewed WBA drawings for machining details for the ASTM A709 345M 3-1/2" x 70 3/8" x 130 deck plates. After review of the drawings Mr. Posluszny gave Mr. Ross and QA Inspector Brannon a tour the K.D.M. facility. Mr. Posluszny explained their Quality Control (QC) program as the steel plates moves throughout the machining process and introduced us to some of the production personnel at various points throughout the tour.

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# WELDING INSPECTION REPORT

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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.

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**Inspected By:** Brannon, Sherri

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer