

**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-011649**Date Inspected:** 20-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**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 was informed by WBA QC Mr. John Miller that WBA will not be cutting any steel plates for Caltrans Seismic Joint today. Mr. Miller went on to say the WBA will be machining a 45 degree bevel on the vertical plates for the channel assembly. QA Inspector Brannon randomly observed WBA personnel machining a 45 degree bevel on the width sides of the vertical plates for the channel assembly. Work observed appeared to comply with contract documents.

Watson Bowman Acme (WBA) Quality Control Manager Mr. Greg Ross informed QA Inspector Brannon that WBA has received a Stop Fabrication letter from American Bridge/Fluor Enterprises. Mr. Ross stated that WBA has stopped fabrication and has informed Mr. Gary Posluszny with K.D.M. Die co., Inc. to stop fabrication on the machining for the deck plates. Mr. Ross also, stated that WBA will continue with the WPS verification testing. QA Inspector Brannon was informed by SMR. Mr. Jim Devey of the stop fabrication State Letter No: 05.03. 01-006421 and that WBA will continue with the WPS verifications.

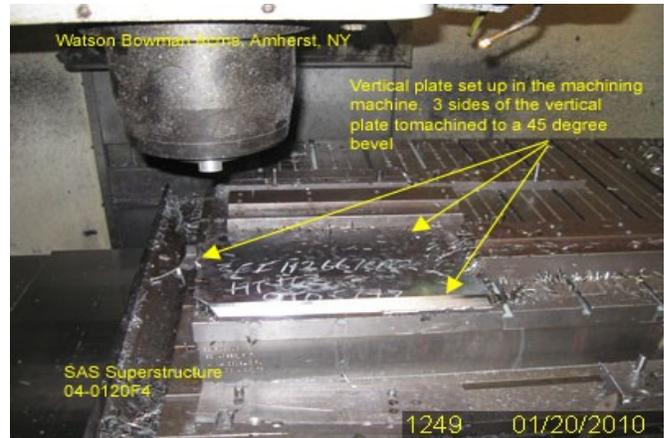
The following digital photograph below illustrates observation of the activities being performed.

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# WELDING INSPECTION REPORT

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## 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

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**Reviewed By:** Levell, Bill

QA Reviewer