

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011766**Date Inspected:** 22-Jan-2010**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:** 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- (PQR-Fillet test #6):

Caltrans Quality Assurance Inspector Sherri Brannon observed Watson Bowman Acme (WBA) welder Mr. Vincent Gebeczyk performing a flux core arc welding (FCAW) Figure 5.8 WPS Verification - Fillet Weld Soundness test (macroetch) for WPS Qualification - Test Plate (D) qualifying PQR is NY-WBA-08-3J. The QA Inspector observed Mr. Gebeczyk deposit (1) 1/4 inch single fillet weld pass on one side of the fillet weld soundness test plate and (3) multiple fillet weld passes on the other side of the fillet weld soundness test plate. Mr. Gebeczyk was observed welding in the horizontal (2F) position. Base plate material was identified as ASTM A709M Gr. 345 HT#5101277, and vertical plate is identified as ASTM A36-HT#1002469. The QA Inspector observed Mr. Gebeczyk utilizing CO2 100% shielding gas and 1.6 millimeter (mm) diameter Hobart Brothers class E81T1-Nil electrode. The QA Inspector observed Quality Control (QC) Inspector Mr. John Miller and Mr. Greg Ross as they monitored welding parameters. The QA Inspector verified the parameters that Mr. Miller and Mr. Ross recorded utilizing his Fluke 337 True RMS Clamp Meter and a stop watch. The QA Inspector assigned Lot number B208-009-10 as witness to the test. Note: Reference document Request For Information (RFI) ABF-RFI-002017R00. See Caltrans Welding Witness Report, TL-6032 dated January 22, 2010 for additional information.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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 Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
