

**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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026962**Date Inspected:** 16-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Watson Bowman Acme**Location:** 95 Pineview Drive, Amherst, MA**CWI Name:** Reno Davis**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:** 34-0006L/R**Component:** Seismic Joint Hinge A**Summary of Items Observed:**

This Quality Assurance Inspector (QAI), Kevin P Sullivan arrived at Watson Bowman Acme as requested to inspect in process fabrication of the support plates, deck plates and channel boxes per approved drawings B-24952.

The following items were observed:

This (QAI) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspector (CWI), Mr. Reno Davis to discuss final inspection of units completed. ABF Representatives are the Quality Control personnel for this location.

Channel Assemblies that have been completed were reviewed by this (QAI), Reno Davis (CWI) and John Miller (WBA QC) to approved drawings B-24985 sheet 4 of 12 Rev 3 and sheet 5 of 12 Rev 12. The dimensions, weld details and cleaning, and flatness tests appeared to be in general conformance with the contract documents. A total of (11) Channel Assemblies were Green Tagged and released by this (QAI). Channel Assemblies released were SEI112667CA1-2, SEI112667CA2-1, 2, 3, 7, 8, 11, 14, 15, 16 and SEI112667CA3-2. See TL-6011 generated for this date.

Also shipped to Regal Painting, Donora, PA were (2) deck Plates SEI112667AB which were previously Green tagged by Ken Riley (QAI). A Certificate of Compliance was received from Greg Ross, WBA QC Supervisor, as well as copies of MTR's and Bill of Lading.

The QA inspector periodically observed Mr. John Ash (WBA Welder) perform heat straightening per approved procedure to Channel Assembly SEI112667CA2-8. The back plate had pulled back 10mm (3/8") during welding

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# WELDING INSPECTION REPORT

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of the Complete Joint Penetration weld (CJP). The plate was heated with the use of a rosebud to 900 deg F with temperature indicating crayons being used, clamped to the table and allowed to cool. Finished flatness achieved was within 6.4 mm (1/4") acceptance limits.

**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>	Ahrary,Shoaib	Quality Assurance Inspector
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<b>Reviewed By:</b>	Foerder, Mike	QA Reviewer
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