

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 #: 72.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027026**Date Inspected:** 12-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Lubrite**Location:** Meadville, PA**CWI Name:** N/A**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 Expansion Joint Hinge A**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kevin Sullivan and Kenneth Riley traveled to Lubrite in Meadville, Pennsylvania as requested, for in process observations.

These (QA) Inspectors met with QC manager Brad McWright who accompanied the QA inspectors through the facility. Mr. McWright informed the QAI of the products and what stage of fabrication these products were in. Lubrite is fabricating the Spherical Bushing Ring Bearings (Hinge K). The following is the part and the status of the components;

5- Housing Halves rough milled

1-housing half poured and is in process of cleaning and rough mill, to be green tagged next week for heat treatment.

4 – Bronze bearings, 1 completed and 3 in process.

32- Segmented Anchor rings

The QAI was given a tour of the facility associated with the casting and milling operations related to the project. This QAI witnessed Lubrite applying the bearing medium used for the retention Cavities (trepanning) for the self-lubricated bearings (the items observed were for information only as to how it was applied due to the components was not SAS). This QAI was informed that Lubrite will need observation from Caltrans next week for the purpose of the pull test from the heat treatment that was performed. This QAI informed Mr. McWright to submit an Inspection Request for the date needed. Also performed was a Material on Hand inspection as requested. This was performed by QAI Kenneth Riley. See report TL-6049 on this date by Mr. Riley

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Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and WBA Personell.

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.

Inspected By:	Sullivan, Kevin	Quality Assurance Inspector
Reviewed By:	Foerder, Mike	QA Reviewer
