

**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-027030**Date Inspected:** 22-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, Amherst NY**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:** 34-0006**Component:** Seismic Expansion Joint Hinge A**Summary of Items Observed:**

This (QAI) arrived at Watson Bowman Acme, Amherst NY, as requested to monitor progress on fabrication of the Channel Assemblies SEI112667CA2 and the Support Plates SEI112667SP3.

This QAI, while at WBA, observed Joe Kearns performing Flux Cored Arc Welding (FCAW) on component SEI112667-CA2-17; using Hobart (Tri-Mark) TM-811N1 electrode under WPS's FCAW-11 (Multi-pass Fillet weld. The welder was observed using a rose bud torch to pre-heat the areas to 115 degrees Celsius. The weld joints being welded by Joe Kearns at the end plate were the external end plate joining the top and back plate, weld TBA, using an 8mm fillet weld filling a beveled edge of the end plate. Welding parameters per approved WPS are being monitored by Mr. Davis and this QAI.

Also observed by this QAI was Jason Gray, WBA Welder, welding the top plate to the back plate, weld TBA, of channel assembly SEI1122667CA2-18. Welding was being performed using the Flux Cored Arc Welding procedure FCAW-11. The Parameters of the approved WPS were witnessed being monitored by KTA TATOR CWI Reno Davis. An 8mm fillet weld was being applied to the bevel on the top plate.

WBA welder John Ash is in the process of stud welding 7/8" x 8- 1/16" AW108 anchor studs to Support plates SEI112667SP3-13 and 15. Bend tests were performed and witnessed by Reno Davis, KTA Tator CWI. Full flash was noted by this (QAI) at the base of the studs to the support plate.

While at WBA this QAI received a call from SMR Bajhat Dagher, concerning the straightening procedure required from Watson Bowman for the distortion on the (2) channel assemblies SEI112667CA2-6 and 8, that were out of tolerance on 12/15. The area in question is at weld number TB-A weld with the extended section of the back plate being drawn into the assembly 3/8". This QAI spoke with Greg Ross, QC Manager for WBA, about the submittal and informed Mr. Ross that if not submitted by the end of the shift 12/23/11 an Incident Report would be issued.

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# WELDING INSPECTION REPORT

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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.

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<b>Inspected By:</b>	Sullivan, Kevin	Quality Assurance Inspector
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<b>Reviewed By:</b>	Foerder, Mike	QA Reviewer
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