

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027031**Date Inspected:** 23-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 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 where 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.

WBA welder John Ash is in the process of stud welding 7/8" x 8- 1/16" AW108 anchor studs to Support plates SEI112667SP3-23. 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. Mr. Ash also had to change the stamping on (2) of the finished plates as he had mistakenly stamped them with a CA3 instead of the required SP3.

Greg Ross, QC supervisor WBA, informed this QAI that WBA was planning for a shipment of finished Deck plates SEI112667AC- 15, 16, 17, 18, 19 and 21 on Wednesday 12/28/11 to paint. This QAI inspected the deck plates to approved drawing B-24952 sheet 10 of 11 Rev 8. Upon acceptance of the (6) plates they were then Green Tagged in preparation of shipment by this QAI. Final documentation and verification of Bill of Lading will be done at time of shipment.

Summary of Conversations:

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

WELDING INSPECTION REPORT

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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
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Reviewed By:	Foerder, Mike	QA Reviewer
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