

**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-027032**Date Inspected:** 28-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 Pinehurst, Amherst NY

<b>CWI Name:</b>	Kevin P Sullivan		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** Deck and Support Plates**Summary of Items Observed:**

This (QAI) arrived at Watson Bowman Acme, Amherst NY, as requested to monitor progress on fabrication of the Deck Plates SEI122667AC, Channel Assemblies SEI12667CA1, 2 and 3, and the Support Plates SEI12667SP1, 2 and 3 for WBA Seismic Plate Expansion Joints.

Upon arrival at WBA this QAI found that no fabrication was being performed on this date due to vacation time and absences of WBA employees assigned to this project. This QAI spent the morning reviewing Channel assemblies in progress and (9) 32mm Support Plates SEI12667SP3- 13, 14, 15, 16, 17, 18, 19, 20 and 22 for completion and tagging. There was no QC from KTA Tator in shop at time of inspection, however the items were identified as accepted by QC per Greg Ross, QC Supervisor Watson Bowman Acme, to approved drawings B-24952 sheet 7 of 12 Rev 6. Dimensions of support legs and anchor studs verified as well as flatness and overall cleanliness. One plate was discovered mis stamped and this item was corrected by WBA personnel. All plates were radiused on the edges. Flatness was verified with the use of a Calibrated 6' Starrett scale.

Upon completion of inspection this QAI then Green tagged the accepted support plates. This batch being shipped is tagged S26-003-11 and these support plates will be shipped with the (6) 85mm Deck Plates, SEI12667AC- 15, 16, 17, 18, 19 and 21 that were inspected and tagged on 12-23-11 for this shipment.

Bill of Lading as well as a copy of the Certificate of Conformance supplied by Greg Ross to this QAI. Paperwork was reviewed and a green tag with S26-003-11 info was attached to first page of C of C. Released plates were loaded on Carrier for shipment to Regal Industrial Corp., Donora PA. Two trucks were needed to ship all the components. The first truck had (3) Deck Plates SEI12667AC - 15, 18 & 21 as well as (6) Support Plates SEI12667SP3 13, 15, 16, 17, 18, & 19 with a total weight of 28,000 lbs.. The second truck carried (3) Deck Plates SEI12667AC 16, 17 & 19 and (3) Support Plates SEI12667SP3 14, 20 & 22 with a total weight of 21,500 lbs.

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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, ABF QC 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 , who represents the Office of Structural Materials for your project.

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

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