

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027033**Date Inspected:** 03-Jan-2012**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 Plate Joint**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kevin Sullivan was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

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

This QAI arrived at WBA and observed Joe Kearns performing Flux Core Arc Welding (FCAW) on components SEI112667-CA2-19, using Hobart (Tri-Mark) TM-811N1 electrode under WPS's FCAW-NY-16 (CJP for Joint TC-U5a-GF), and FCAW-11 (CJP for joint TC-U5-F). The 10mm fillet weld for weld numbers 1~7 B welds joining the end plates and partition plates to the back plate. Joe Kearns was also welding the joints for the partition plates to the back plate using FCAW-11 (CJP for joint TC-U5-F). The welder was observed using a rose bud torch to pre-heat the areas to 107 degrees Celsius (225F). Amps were run at 270 with an approved WPS range of (265 to 300). Volts were set at 29 with an approved WPS range of (28 to 31).

Also noted was welder Jayson Gray fitting up the back plate, top plate and partition plates on Channel assembly SEI112667-CA2-20. FCAW was used for tacking parts together. Proper weld details were applied to parts at setup. Dimensions verified to the approved drawing B-24952 sheet 5 of 12 Rev 12.

Summary of Conversations:

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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.

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