

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-027034
Date Inspected: 04-Jan-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Watson Bowman Acme

OSM Arrival Time: 700
OSM Departure Time: 1530

Location: 95 Pineview Drive, 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	

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 Greg Ross and QC Technician John Miller. Also present was certified Welding Inspector (CWI) Mr. Reno Davis, the Quality Control personnel for this location.

This QAI observed Joe Kearns, WBA welder, performing Flux Core Arc Welding (FCAW) on Channel Assembly SEI112667-CA2-19, using Hobart (Tri-Mark) TM-811N1 electrode. Mr. Kearns was welding the joints for the partition plates to the back plate using FCAW-11 for a 10mm fillet weld, and the top plate to back plate using FCAW-16 (CJP for joint TC-U5-F) as well as bottom plate to back plate using FCAW-13 (CJP for joint TC-U4b-GF). The welder was observed using a rose bud torch to pre-heat prior to welding to about 170 deg F.

Also noted was WBA welder Jayson Gray welding on Channel assembly SEI112667-CA2-20. The approved WPS FCAW-13 (CJP for joint TC-U4b-GF) is being used on the End plate welds 1A and 1C. Preheating was performed using a rose bud to a temp of 150 deg F.

During visit to WBA this QAI also performed final inspection on QC released parts that are ready for possible shipment on 1/5/12 to paint shop. Final inspection and tagging will be performed at time of shipment.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Mr. Michael Bennett, Alta Vista Solutions, was at WBA to review progress of project and to answer any questions this QAI may have on the transition to project.

The items observed appear to be progressing as scheduled and are in general conformance with the contract documents.

Summary of Conversations:

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

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 858-531-0335, who represents the Office of Structural Materials for your project.

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