

**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-027036**Date Inspected:** 09-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 Dr Amherst**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:**

This (QAI) arrived at Watson Bowman Acme, Amherst NY, as requested to monitor progress on fabrication of the Channel Assemblies SEI112667CA2 and deck plates SEI112667AC.

This QAI, while at WBA observed Joe Kearns performing Flux Core Arc Welding (FCAW) on component SEI112667-CA2-21; 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 102 degrees Celsius (215 deg F) as required by approved WPS FCAW-13. The weld joints being welded by Joe Kearns are the end plates where the external end plate joins the bottom, top and back plate (1A, 1B, and 1C) using Joint Detail TC-U4b-GF. Back weld was applied to inside of joint, back gouged/ground to sound metal on face side, observed by this QAI and released for welding by Mr. Davis (QC).

Also observed by this QAI was Jason Gray, WBA Welder, performing Flux Core Arc Welding (FCAW) on component SEI112667-CA2-22; 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 102 degrees Celsius (215 deg F) as required by approved WPS FCAW-13. The weld joints being welded by Mr. Gray are the end plates where the external end plate joins the bottom, top and back plate (1A, 1B, and 1C) using Joint Detail TC-U4b-GF. Back weld was applied to inside of joint, back gouged/ground to sound metal on face side, witnessed by this QAI and released for welding after inspection by QC.

During the observation it is noted that the Mr. Davis was checking the welding parameters for compliance to the Welding Procedure Specification (WPS) on both of the channel assemblies mentioned above. Run off tabs are being used as required for the face welds.

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WBA welder John Ash set and welded the lifting lugs to the final (4) deck plates SEI112667AC-20, 22, 23 and 24. Lugs were set per approved drawing B-23952 sheet 10 of 12 Rev 8 and welded per WPS SMAW-11 using a 6mm fillet weld each side.

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.

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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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