

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-027037**Date Inspected:** 11-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:** 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 K**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. Two (2) of the assemblies were completed on second shift 1-10-12. Channel Assemblies SEI112667CA2- 21 and 22 were ready for cleaning and verification of flatness on back plate. Reno Davis, QC was present and performed flatness verification with this QAI observing.

Jason Gray, WBA Welder, began cleaning the (2) assemblies in preparation of attaching anchor bolts, support legs and lifting lugs. Welds were inspected and repair areas marked as requires by QC. Minor repairs were made by Mr. Gray and accepted by Mr. Davis then this QAI. Mr. Gray then set the lugs to the top plate on the two assemblies and tacked in place. Welding was performed in accordance with approved WPS SMAW-11 applying a 6mm fillet weld to each side of the lugs. Filler metal used is Hobart E-7018-H4R. All parameters of approved WPS were monitored and followed by this QAI.

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

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your project.

Inspected By: Sullivan, Kevin

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer