

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-027038
Date Inspected: 12-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: Amherst NY

CWI Name:	John Crabtree, KTA	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 Channel Assemblies**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. This QAI met with John Miller, QC Watson Bowman Acme (WBA), to discuss progress and any changes in schedule.

Upon arriving at WBA this QAI found that the support legs and lugs welded to channel assembly SEI112667CA2-21 and 22. The lugs had sufficient 6mm fillet welds all the way around the base. Weld size was verified by this QAI using a Master fillet weld gage. The legs on the channel assemblies were welded with a 5mm fillet. The top leg is short and will need to be repaired. Welds were immediately brought up to acceptable requirements. SMAW-11 WPS was used in the welding process. Hobart E-7018-H4R stick rod run at parameters set by WPS and monitored by Mr. Crabtree.

Jason Gray, WBA Welder, was observed setting up the Channel Assembly for SEI112667CA2-23. Back plate and bottom plate had been set and tacked in position. The area for the side and partition plates on the back and bottom plate were ground removing all mill scale. Locations were then laid out per approved drawings and partition plates set and tacked in place. No welding was performed at this time due to the absence of QC representative Reno Davis. John Crabtree, QC rep KTA, arrived at 1200 hrs to perform QC duties after covering second shift 1/11/12.

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

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 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
