

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-027042
Date Inspected: 13-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	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:	Channel Assemblies SEI112667CA2	

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.

Jason Gray, WBA Welder, was observed welding on Channel Assembly SEI112667CA2-23. Mr. Gray is in the process of welding the bottom plate (BB) to the back plate seam AB. Approved WPS FCAW-13, (CJP for joint TC-U4b-GF) being used for welding. All parameters monitored and verified by QC and observed by this QAI. Run off tabs are in use. Back weld was put in and back gouged from face. This QAI witnessed the back gouging and assembly was released for welding. Jason Gray is using Hobart (Tri-Mark) E81T1-Ni1 electrodes. Welding continues on joint under observation of this QAI.

The last top plate for channel assembly SEI112667CA2-24 was received at Watson Bowman Acme from drilling at Private Systems in Blasdell NY. Plate had not been inspected prior to its arrival at WBA. This QAI is waiting for a copy of the MTR for the plate before releasing. John Miller of WBA QC has been contacted and is in the process of making copies of the MTR. The heat number written on plate is A1G896, and the plate measures 425mm x 1790mm. (12) 39.5 mm holes are drilled in plate at locations called out on approved drawing B-24952 sheet 5 of 12 Rev 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
