

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-027043**Date Inspected:** 16-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:** Channel Assemblies SEI12667CA2**Summary of Items Observed:**

This (QAI) arrived at Watson Bowman Acme, Amherst NY, as requested to monitor progress on fabrication of the Channel Assemblies SEI12667CA2. This QAI met with John Miller, QC Watson Bowman Acme (WBA), and Mr. Reno Davis QC, to discuss progress and any changes in schedule.

This QAI found the Channel Assembly SEI12667CA2-24 in process of set up by second shift. Setup had taken place on Friday night 1/13/12 and Saturday 1/14/12. The back and bottom plates had been set and tacked. The assembly was then laid out for locating divider plates which were then tacked in place. Dimensional verification was observed by this QAI by QC to approved drawing B-24952 sheet 5 of 12 Rev 12. No discrepancies were found at this time.

Jason Gray, WBA Welder, was observed welding on Channel Assembly SEI12667CA2-23. Mr. Gray is in the process of welding the top plate (TB) to the back plate seam AB. Approved WPS FCAW-BBS03-ca, (CJP for joint TC-U5-F) 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 observed the back gouging along with Mr. Davis, QC, and the seam was released for welding. Jason Gray is using Hobart (Tri-Mark) E81T1-Ni1 electrodes. Welding continues on joint under observation of 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
