

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-027045**Date Inspected:** 18-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 Channel Assemblies**Summary of Items Observed:**

This (QAI) arrived at Watson Bowman Acme (WBA), Amherst NY, as requested to monitor progress on fabrication of the Channel Assemblies SEI112667CA2 for the Seismic Expansion Joints on the SFOBB project. This QAI met with John Miller, QC Watson Bowman Acme, and Mr. Reno Davis QC, to discuss progress and any changes in schedule.

Mr. Davis informed this QAI that (2) of the channel assemblies, SEI112667CA2-21 and 22, had the lifting lugs set and welded in the wrong locations. Per approved drawing B-24952 sheet 5 of 12 Rev 12 the lugs should be 38mm from the face of the bottom plate to the center of the lifting hole. The lugs were mistakenly set and welded 76mm from the face of the bottom plate. Discrepancy was discussed with Greg Ross, QC Supervisor WBA, and Mr. Ross is in the process of writing a Non Conformance Report and repair plan to issue to Caltrans. This QAI notified Bajhat Dagher of the problem.

Jason Gray, WBA Welder, was observed welding on Channel Assembly SEI112667CA2-24. Mr. Gray is in the process of welding the top plate (TB) external seam to the back plate. Approved WPS FCAW-BBS03-ca (CJP for joint TC-U5-F) is being used for the welding. All parameters monitored and verified by QC Mr. Davis 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 unit was released for welding. Jason Gray is using Hobart (Tri-Mark) E81T1-Ni1 electrodes. Welding continues on this joint under observation of this QAI.

The items observed appear in general conformance with the contract documents other than listed above.

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

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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
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Reviewed By:	Foerder, Mike	QA Reviewer
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