

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-027063**Date Inspected:** 19-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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.

Jason Gray, WBA Welder, was observed cleaning for shipment Channel Assemblies SEI112667CA2- 19 thru 24.

Mr. Davis has been performing final inspections of all welds on these assemblies and marking areas needing minor repairs.

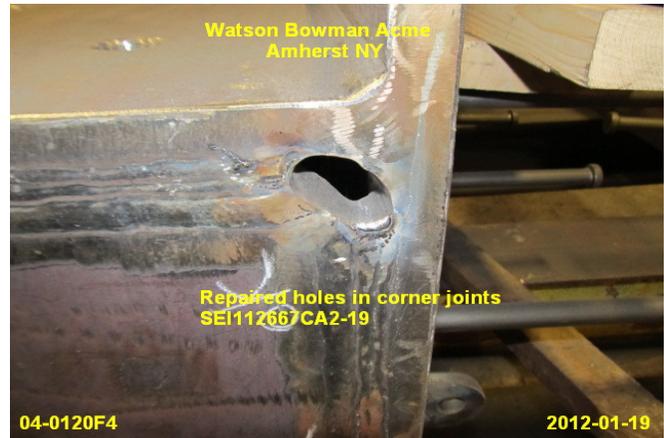
The dislocated lifting lugs on Channel Assemblies SEI112667CA2- 21 and 22 were removed per submitted Repair Procedure and area of incorrect weld was ground flush. Magnet Particle Test was then performed by a Certified ASNT Level II Technician from Niagara Testing of Buffalo NY and witnessed by this QAI and Mr. Davis. Once soundness of base material was established Mr. Gray welded new lifting lugs in correct using approved WPS SMAW-11. Stick Electrode Classification was verified to be E-7018-H4R. Parameters of WPS were observed by this QAI being monitored by Mr. Davis.

Above operations are being performed in preparation of final shipment to Paint shop on Friday 1/20/12.

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

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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 your project.

Inspected By:	Sullivan, Kevin	Quality Assurance Inspector
Reviewed By:	Foerder, Mike	QA Reviewer
