

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 #: 72.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028728**Date Inspected:** 09-Nov-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Lubrite**Location:** Meadville PA**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:** Spherical Bushing Ring Bearing (Hinge K)**Summary of Items Observed:**

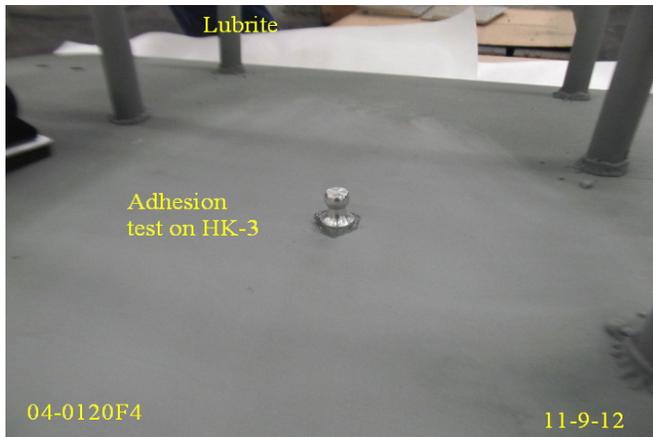
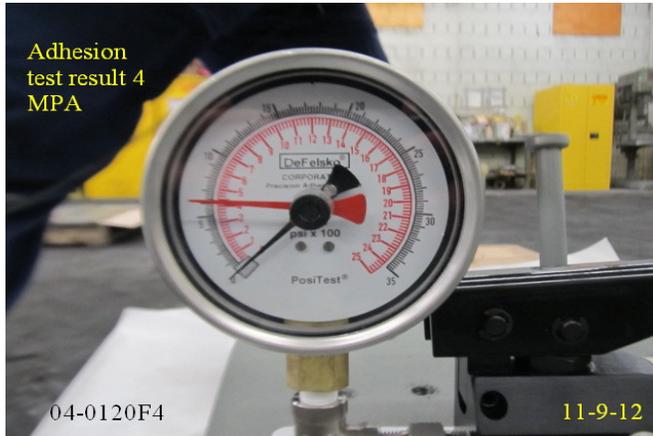
This Quality Assurance Inspector (QAI) arrived at Lubrite Technologies in Meadville, PA as requested per TL-38 for observation of coatings application on 8 Spherical ring segments for Hinge K fourth assembly. Materials for the last ring segment were presented to this QAI for witnessing the coatings application by Quality Manager Brad McWright of Lubrite Technologies. Only 4 segments were able to receive the coatings at this time due to the limited amount of space at Lubrite for the coatings application. There were 4 of 8 segments in the application area prepped, with this QAI witnessing the environmental tests being taken by QC Manager. Along with the environmental tests being taken and recorded, the blast profile of the segments was checked with test strips and recorded. The mixing of the inorganic Carboline coating was witnessed by this QAI. QM presented this QAI with the batch numbers of the coatings and they were verified by this QAI to be correct with the coatings being mixed. Following the mixing of the coating, this QAI witnessed the application of the inorganic primer coating by the worker, two applications were observed (left to right and top to bottom) as necessary per approved painting coating application. Following the conclusion of the application of the coatings material, this QAI observed the QM taking "wet" film measurements to assure the proper amount of coatings had been applied to the 4 segments. These 4 segments will cure for the 72 hours as required by contract documents for final coatings inspection to be performed at a later date.

Following the application of the coatings, this QAI witnessed the adhesion testing of the completed Hinge segments of HK-3, with QM performing dry film thickness checks, and a wet/dry MEK wipe test following the required 72 hours of cure time on the coatings on these 8 segments for HK-3. At the time of this reporting all coatings checks appeared to be in conformance of the contract documents.

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This QA Inspector met with Lubrite QC Barry Vickers for 2 of the 4 segment plates were stud welding had been performed. It was relayed to this QAI that Reno Davis from ABF was onsite for the welding inspection of the studs. This QAI observed 2 stud locations that had been applied and then removed due to non-fusion of the stud to the base material. The non-conformance of the studs to the base material would require base material repair due to the removal of the studs. These studs were rejected by the QC Reno Davis as relayed to this QAI. Due to Lubrite not having the ability to repair the base material the 2 segments, (HK-4 A1 and HK-4 A5) are to be sent to American Bridge in Coraopolis PA for repair. This QAI verified the base material in need of repair (as shown below in photos) and attached a green tag for tracking purpose to the material to be sent to American Bridge for repair. Lot number applied to the material was B350-016-12.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and Lubrite Quality Management and Quality Control 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 Gary Thomas (916)764-6027, who represents the Office of Structural Materials for your project.

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Inspected By: Smith,James

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer