

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 37.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014505**Date Inspected:** 27-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1130**Contractor:** American Metal Fab. Modesto**Location:** Pier-7, Jobsite

CWI Name:	Mike Johnson		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Stud Welding PQR**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel during the welding of a Stud Welding Procedure Qualification Record (PQR) in the vertical position.

This QA Inspector observed QC Inspector Mike Johnson was present to verify the stud welding parameters and document the applicable variables regarding the welding of the PQR. This QA Inspector observed ABF personnel Matthew Chamberlain was present to perform the stud welding. This QA Inspector observed the following material was present and used during the stud welding: Nelson 3/4-inch diameter by 6-3/16-inch long studs, 3/4-inch thick ASTM grade 36 plate (approximately 48-inches by 30-inches). This QA Inspector was provided a copy of the Certificate of Compliance for the Nelson studs and a Material Test Report (MTR) for the base material.

The documents provided appeared to match the materials being used and comply with the contract requirements.

This QA Inspector randomly observed ABF personnel Matthew Chamberlain weld ("shoot") 10 studs, consecutively, on to the 3/4-inch thick plate, which was positioned approximately 12 degrees from the vertical axis. This QA Inspector randomly observed QC Inspector Mike Johnson record the welding amperage, time duration of the stud welding, measure the plunge setting on the stud gun and verify the welding was performed with direct current and a negative ground. This QA Inspector randomly observed as the 10 studs were bent approximately 90 degrees. This QA Inspector observed as QC Inspector Mike Johnson performed a visual inspection of the bent stud welds and was informed he had accepted the welds and the PQR test. This QA Inspector performed a random visual verification of the stud welds and concurred the work appeared to comply with the contract requirements. Please see Welding Witness Report (TL-6032) this date for further details.

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Summary of Conversations:

As noted above.

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 Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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