

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014669**Date Inspected:** 08-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

**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:** Orthotropic Box Girders**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI observed ABF activities at the Pier 7 location. The QAI noted that Quality Control (QC) Inspector Mike Johnson is present and will be monitoring the stud welding on OBG 6W. The QAI observed ABF worker Bob Russell, ID 0894, setting up and performing stud welding. The QAI noted that 150mm long, 19mm diameter Nelson studs are being welded onto plate B of the OBG, in 4 locations where the sea fasteners had prevented earlier placement. The QAI noted that 20 studs are being welded at each location. At the start of welding, the QAI was informed that welding procedure specification (WPS) ABF-WPS-D15-5000 Stud is being used. The QAI noted that the pre-production studs appeared to be visually conforming to the contract requirements. As the work was completed, the QC Inspector informed the QAI that all welded studs were acceptable. The QAI made random observations of the completed studs and noted that they appeared to be visually conforming to the contract requirements. See the attached photos. Upon completion of the stud welding, the ABF welder informed the QAI that the base metal and studs will be painted to prevent rusting of the exposed metal surfaces. The QAI inquired about what paint will be used. The QAI was informed that a spray can zinc primer will more than likely be used. The QAI suggested that the welder check with his foreman, as the contract requirements do not allow the permanent application of zinc primer from spray cans. The QAI was then informed that it has not yet been determined what paint will be used. The QAI noted that the studs did not appear to have been painted by the end of the shift.

The QAI noted that ABF personnel are welding on barges and other job related equipment. The QAI also noted

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that the contractor is assembling parts of the temporary trestle and Favco crane parts on the barges at Pier 7. The QAI noted that this work was in progress until the end of the shift.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP and newly issued ABFJV non-conformance reports. The QAI updated the records of the non-conforming incident reports and requested weld repair reports.



## Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI Mike Foerder was also informed of the status of work observed at the Pier 7 facilities. Except as described above, there were no other notable conversations or observations.

## 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.

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**Inspected By:** Croff, Scott

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer

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