

**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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029422**Date Inspected:** 17-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**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:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**Welder Carlos Garcia:**

The welder was observed performing stud welding of 1/4" threaded studs for a qualification test. The welder welded 10 studs each for the Overhead, Downhand and Sidehand positions using the Nelson Series 4500 Model 101 welding machine with the Nelson Nelweld stud gun. The current was set at 350 Amps with weld time at .17 seconds to produce a 0.215" weld base diameter. Each of the 30 welded studs were then torque tested to 5ft-lbs as per Figure 7.3 of AWS D1.5 2002 and all passed. This test also satisfied the pre production requirements of Section 7.7.1.1 and the welder then commenced welding the studs on Traveler E2/E3 EB as required supported by PQR S003 with QC Inspector Fred Michaels overseeing and inspecting stud welding operations. Welding parameters appeared to be in compliance with the PQR noted above.

**Welder Rick Clayborn #2773:**

The welder was observed performing in process welding of Pier E2, N2 Temporary Bearing Retrofit as per ABF-SUB-003242R00 as a means of restricting the movement of the temporary bearing to the east. The welder was observed utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-1, F2200-3, 2160-1 and 2160-3 for Flux Core Arc Welding (FCAW). The welding parameters were verified by QC Inspector William Sherwood throughout the day and appeared to be in compliance with the WPS noted above.

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The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

Conversations this day as required for scope of work.

## 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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<b>Inspected By:</b>	Belford,Fritz	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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