

**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 #: 78.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-030046**Date Inspected:** 20-Sep-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Steward Machine Co.**Location:** Birmingham, AL**CWI Name:** Jimmy Brewer**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:** E2 Shear Key Anchorages**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Andrew Webster was present on the date and times noted above in order to observe the fabrication and Quality Control (QC) functions performed by Steward Machine Company for the E2 Shear Key Anchorages for the SFOBB project. The following items were observed:

**Steward Machine - Plant 1:**

This QAI performed a walkthrough at the shop to verify plates on site and to observe Steward Machine personnel at work machining and welding. Work performed at the Steward Machine shop as noted below:

CNC Machine #230 milling assembly S3B. (Milling east end to size)

The following plates were noted staged throughout the shop in various stages of processing.

**Bay 4 – Plates:**

S3B-e3. Formed, stressed relieved, partially machined and stud welded.

S3C-a3. Formed, stressed relieved and partially machined.

S3C-b3. Formed, stressed relieved and partially machined.

S3C-c3. Formed, stressed relieved and partially machined.

S3C-d3. Formed, stressed relieved and partially machined.

S3C-e3. Formed, stressed relieved, partially machined and stud welded.

S3C-f3. Formed, stressed relieved and partially machined.

S3C-g3. Formed, stressed relieved and partially machined.

S3C-h3. Formed, stressed relieved and partially machined.

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S4B-e4. Formed, stressed relieved, partially machined and stud welded.

S4C-e4. Formed, stressed relieved, partially machined and stud welded.

Pallet of r3, m3, k3 and j3 plates.

p3 (x8). Cut, beveled and stud welded.

S4C assembly:

This QAI noted the welding of the above mentioned assembly in the welding jig for night shift. The welding was done by qualified welders Daniel Rowe (73) and Jeffery Hennington (476). The welding was done to the approved welding procedure (WPS) P2-W126-B. All welding done was monitored by Certified Welding Inspector (CWI) Jimmy Brewer. Welding was continued on side A.

S4B assembly:

Trial fit of the e4 plate to the S4B assembly.

j3, k3 and m3 plates:

This QAI noted the above mentioned plates having the s3 bent rods welded to them. The welding was done by qualified welders Daniel Rowe (73) and Jeffery Hennington (476). The welding was done to the approved welding procedure (WPS) P2-W101-B. All welding done was monitored by Certified Welding Inspector (CWI) Jimmy Brewer.

S10C Assembly:

The above mentioned assembly was moved to the paint area where it was blasted to the required profile and then painted. The blast profile was checked using extra coarse profile tape and was found to be between the required 1.57 to 3.38 mills. After the blast profile was checked and found to be acceptable the S10C assembly was painted with the primer coat.



## Summary of Conversations:

This QAI spoke with QC Inspector Dale about duck pizza. The QC Inspector told this QAI that there was a restaurant called Slice that was serving duck pizza for a limited time. Other basic communication was performed between the QAI and the QC Inspector during the observations.

## Comments

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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>	Webster,Andrew	Quality Assurance Inspector
<b>Reviewed By:</b>	Foerder,Mike	QA Reviewer

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