

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 #: 78.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-030087**Date Inspected:** 01-Oct-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Steward Machine Co.**Location:** Birmingham, AL**CWI Name:** Fred Hudson**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 #231 milling assembly S4C. (Machining east end)

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

Bay 4 – Plates:

Plates r3, m3, k3, j3 and p3.

S3B assembly:

This QAI noted the above mentioned assembly on the trailer being strapped down for shipping to the job site.

S4C assembly:

This QAI noted the above mentioned assembly having the east end of the assembly final machined on machine #231.

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S3C assembly:

This QAI noted the above mentioned assembly had been moved to the paint area where it and the e3 plate were blasted. After being blasted and having the blast profile checked the assembly and the e3 plate were taken back to the shop for fit up. The e3 plate was fit to the assembly and the root pass was welded on side B. After the root pass was welded on side B the assembly was flipped and the root pass was welded on side A. The welding was done by qualified welder Jeffery Hennington (476). The welding was done to the approved welding procedure (WPS) P2-W128-B. All welding done was monitored by Certified Welding Inspector (CWI) Fred Hudson.

This QAI spoke to the welding supervisor about the shops plan for welding the e3 plate to the S3C assembly tonight. The welding supervisor informed this QAI that they would just weld the root pass on both sides and nothing else tonight. This QAI asked about doing the MPT on the root passed and the supervisor said the MPT on the root passes would be done tomorrow morning before welding continued. This QAI informed the lead QAI Fritz of this so he could make any adjustments needed for his start time tomorrow to cover the required MPT.



Summary of Conversations:

As noted in the body of the report above. Other basic communication was performed between the QAI and the QC Inspector during the 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 Gary Thomas 916-764-6027, who represents the Office of Structural Materials for

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your project.

Inspected By: Webster, Andrew

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer