

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 #: 78.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-030088**Date Inspected:** 02-Oct-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**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 S3C. (Machining west end)

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

Bay 4:

S4C assembly:

This QAI noted the above mentioned assembly having the final grinding being done in preparation for blast and paint. This QAI was informed that the final MPT as well as the blast and paint of this assembly will take place tomorrow.

S3C assembly:

This QAI noted the above mentioned assembly having the straps welded. The welding was being done on side B of the assembly. The welding was done by qualified welder Jeffery Hennington (476). The welding was done to

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

the approved welding procedure (WPS) P2-W126-B. All welding done was monitored by Certified Welding Inspector (CWI) Fred Hudson.

This QAI noted the above mentioned assembly was cut from the stand and moved to machine #231 for final machining on the west end of the assembly. This QAI was informed that the strap welds on side A would be completed after machining the west end.



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 your project.

Inspected By: Webster, Andrew

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer
