

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 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-000897**Date Inspected:** 14-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, Ca.

CWI Name:	William Norris		
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:** PQR test**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector arrived at the Ironworkers Apprenticeship Training Facility and witnessed the continued welding of the Procedure Qualification (PQR) test plate designated ABF-PQR-023-1. The welding was performed using gas shielded flux cored arc welding (FCAW-G) using gas shielded flux cored arc welding (FCAW-G) using Hobart Trimark TM-910 electrode, 0.062 in. diameter with with 90% Argon, 10% CO2 shielding gas. The welding was performed by the American Bridge welding personnel Mr. Daniel Gordon and Mr. Eric Rayburn. The welding was conducted with the support of a track guided "Bug O" system in the 4G (overhead) position. The welding was performed per the AWS D1.5, 2002 Section 5.12 heat input requirements. The Smith Emery QC inspector, Mr. William Norris recorded the preheat and interpass temperatures, the average amperage, voltage and the travel speed for all weld passes. The QA inspector observed the welding personnel Mr. Rayburn excavated the third weld pass due to issues with the track guided "Bug O" system and or the filler metal. Mr. Rayburn performed the excavation using a manual air-carbon arc system. After the air-carbon arc cutting was complete, the excavation was ground to resemble the initial joint geometry prior to the welding of pass three. The welding of this plate was not completed on this date. The QA inspector noted that the welding appeared to meet the minimum requirements of AWS D1.5-2002 and the contract documents.

Summary of Conversations:

At the start of welding the Procedure Qualification test ABF-PQR-023-1, the QC inspector, Mr. Norris reported that the test was to be performed in accordance with AWS D1.5-2002 section 5.12, maximum heat input WPS.

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

WELDING INSPECTION REPORT

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
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Reviewed By:	Mertz,Robert	QA Reviewer
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