DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF Rte: 80 PM: 13.2/13.9
File #: 1x.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-000934
Date Inspected: 20-Nov-2007

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 630
OSM Departure Time: 1430
Location: Benica, 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: Procedure Qualification Record (PQR) test

Summary of Items Observed:

The Quality Assurance (QA) Inspector arrived at the Ironworkers Apprenticeship Training Facility and met with Smith Emery Quality Control (QC) Inspector William Norris to observe QC functions during the welding of the Procedure Qualification Records (PQR) listed below.

ABF-PQR-020-1-A.

1. The QA Inspector observed QC Inspector William Norris perform Ultrasonic Testing (UT) on the complete joint penetration butt weld of the PQR test plate identified as ABF-PQR-020-1-A. The QA Inspector observed the UT testing was performed on 100% of the weld length. QC Inspector William Norris informed the QA Inspector the testing was being performed for information only to see if there were major welding discontinuities on the weld prior to sent test plate to the laboratory for required Non Destructive Testing. William Norris notified the QA Inspector he did not observe any major welding discontinuities on the weld.

a) QA Inspector periodically observed American Bridge Flour welding personnel Daniel Gordon perform air carbon arc cutting (gouging) and grinding on the test plate of PQR identified as ABF-PQR-020-1-A. The cutting was being performed to remove run off tabs and the grinding to remove the weld reinforcement to a smooth and flush finish to prepare test plate for final inspection.

b) After cutting and grinding were completed the PQR test plate was visually inspected by QC Inspector William Norris. William Norris notified the QA Inspector the test plate was visually acceptable in accordance with AWS D1.5-2002 section 5.12. The QA Inspector performed visual verifcation and observed test plate appeared to be in

general compliance with the project plans and specfications. Please see digital image below.

c) QA Inspector assigned an Index Lot Number to test plate for tracking purposes and a Welding Witness Report (TL-6032) was generated on this date.

ABF-PQR-011-1-E.

2. The QA Inspector did not observe any American Bridge Flour welding personnel performing any welding on the test plate of PQR identified as ABF-PQR-011-1-E at this location on this date. QC Inspector William Norris notified the QA Inspector that the remaining welding of the PQR test plate will continued on next Monday November 26, 2007.

3. The QA Inspector periodically observed welding personnel Daniel Gordon and assistants performing plate preparation prior to starting fit up to make testing plates for future PQR. The test plates in process had not been identified with an assigned PQR number at this time. After plates were in placed QA Inspector periodically observed Daniel Gordon perform welding per the Flux Cored Arc Welding (FCAW) process to make tack welds. The plate preparation, fit up and tack welding were in process at the end of the QA Inspector's shift on this date.

Item	Description	WBS	Dwg No.	Status
1	ABF-PQR-020-1-A PQR test plate	N/A	N/A	N/A

Summary of Conversations:

As noted in the body of the report above. Also QA Inspector was notified by the QC Inspector William Norris that the test plate number ABF-PQR-020-1-A will be ship to Construction Materials Testing laboratory for Radiographic testing only.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer