

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000959**Date Inspected:** 29-Nov-2007**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Arrival Time:****OSM Departure Time:****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 Record (PQR) test plates.

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-026-1-A, ABF-PQR-011-1-E and ABF-PQR-011-2-D. 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 welds prior to sent test plates to the laboratory for required Non Destructive Testing. William Norris notified the QA Inspector he did not observe major welding discontinuities on the weld of test plate number ABF-PQR-011-1-E and ABF-PQR-011-2-D. William Norris informed the QA Inspector he observed rejectable indications located at the root area of ABF-PQR-026-1-A test plate weld. William Norris notified the QA Inspector he used Tensile Stress Criteria in Table 6.3 of AWS D1.5, 2002 to evaluate indications during UT. American Bridge Flour (ABF) welding foreman Rick Clayborn informed the QA Inspector that due to the welding difficulties they had during welding of the test plate and the rejectable indications showing during the preliminary UT it was decided not to send the test plate to the laboratory, the test plate will not be use and it will be scrapped.

a) QA Inspector periodically observed ABF welding personnel Daniel Gordon perform air carbon arc cutting (gouging) and grinding on ABF-PQR-011-1-E and ABF-PQR-011-2-D test plates. The cutting was being performed to remove run off weld tabs and the grinding to remove the weld reinforcement to a smooth and flush

WELDING INSPECTION REPORT

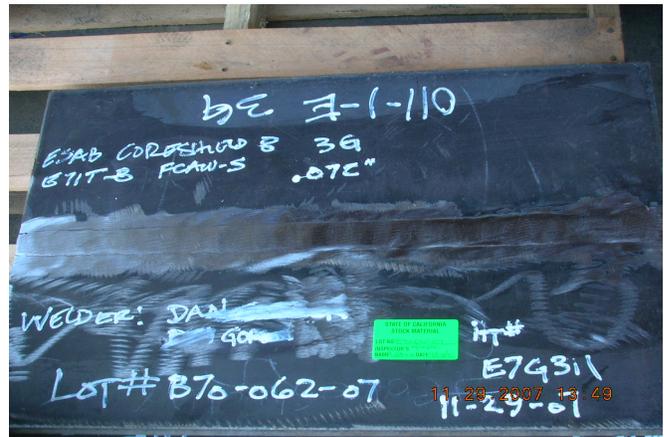
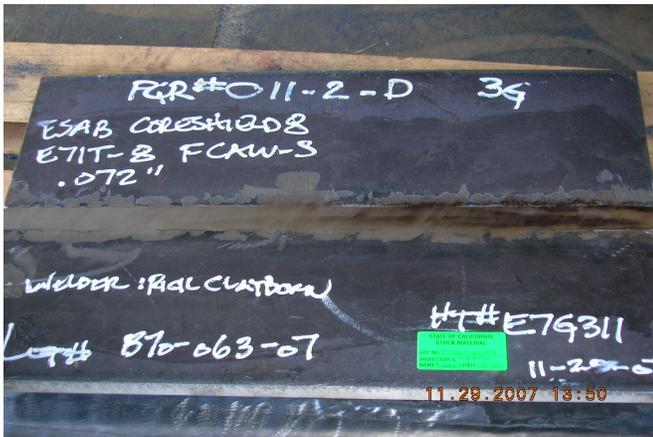
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finish to prepare test plate for final inspection and future Non Destructive Testing.

b) After cutting and grinding were completed the PQR test plates were visually inspected by QC Inspector William Norris. William Norris notified the QA Inspector the test plates were visually acceptable in accordance with AWS D1.5-2002. The QA Inspector performed visual verification and observed test plates appeared to be in general compliance with the project plans and specifications. Please see digital images below.

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

2. The QA Inspector periodically observed ABF welding personnel Rick Clayborn setting up welding equipment and preparing testing material prior to start welding to make Complete Joint Penetration (CJP) groove weld of Procedure Qualification Record (PQR) test plate. QA Inspector was notified by Rick Clayborn that there will be no welding on the testing plate on this date due to welding equipment was not working properly and that repair needed to be done on equipment prior to start welding. No welding was performed at this location on this date.



Summary of Conversations:

As noted in the body of the report above. QC Inspector William Norris informed the QA Inspector he intended to monitor and record the electrical welding parameters (amperage, voltage and travel speed) and document the placement of each welding pass in the groove joint.

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.

Inspected By: Medina,Ricardo

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer