

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000987**Date Inspected:** 05-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 615**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** American Bridge/Fluor Enterprises, a JV**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 Company Quality Control (QC) Inspector William Norris to observe QC functions during the welding of the Procedure Qualification Record (PQR) test plate listed below.

ABF-PQR-026-1-A.2

1. The QA Inspector observed QC Inspector William Norris perform Ultrasonic Testing (UT) on complete joint penetration butt weld of the PQR test plate identified as ABF-PQR-026-1-A.2. The QA Inspector observed the UT test 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 send test plate to laboratory for Non Destructive Testing. William Norris informed the QA Inspector he observed rejectable indications located at the root area of 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.

a) QA Inspector periodically observed American Bridge Floor (ABF) welding personnel Rick Clayborn perform air carbon arc cutting (gouging) and grinding on test plate. The cutting was being performed to remove run off weld tabs and the grinding to remove the weld reinforcement to a smooth and flush finish to prepare test plate for final inspection and future Non Destructive Testing.

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

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D1.5-2002. The QA Inspector performed visual verification and observed test plate appeared to be in general compliance with the project plans and specifications. Please see digital image below.

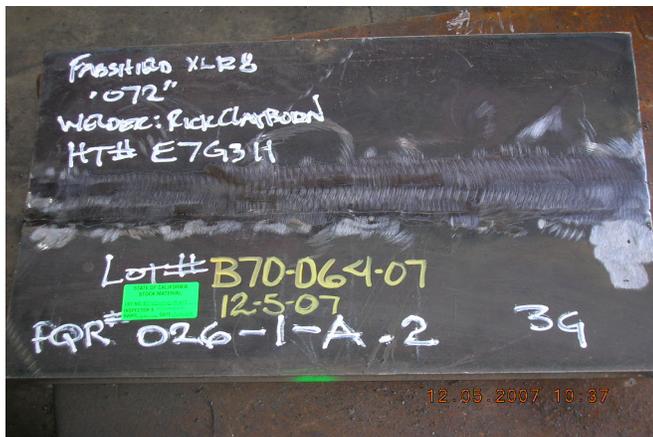
c) QA Inspector assigned a Caltrans Index Lot Number to test plate for tracking purposes and a Welding Witness Report (TL-6032) was generated on this date.

ABF-PQR-023-2

2. Prior to starting welding PQR test plate QC Inspector William Norris informed the QA Inspector he had accepted the fit up of the weld joint. The QA Inspector verified the weld joint to be a standard butt joint B-U2a-GF intended to be a CJP groove weld. The QA Inspector performed a random visual verification of the fit up of the plate and observed the joint to be in accordance with figure 2.4 of the AWS D1.5, 2002.

a) The QA Inspector periodically observed ABF welding personnel Rick Clayborn and Daniel Gordon 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 identified as ABF-PQR-023-2.

b) QA Inspector periodically observed the QC Inspector William Norris verify electrical welding parameters and the travel speed for welding personnel to produce the welds. ABF welding foreman Rick Clayborn notified the QA Inspector that no welding will be performed on this test plate at this location on this date.



Summary of Conversations:

As noted in the body of the report above. Other basic communication was performed between QA Inspector and the QC Inspector William Norris during 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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Inspected By: Medina,Ricardo

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer