

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/ALA 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-000116**Date Inspected:** 04-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, California

CWI Name:	Michael Johnson		
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:**

Caltrans Quality Assurance (QA) Inspector Robert Cuellar is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/ Fluor for the continuing purpose of witnessing Procedure Qualification Record tests. The following items have been observed,

- 1) Today's observation is a continuance of procedure qualification record PQR test that is identified as ABF-PQR-001-1. This PQR test is being attempted in the 1G position and represents an AWS D1.5 single vee groove with one inch thick steel plate and a 10mm thick steel backing bar.
- 2) Caltrans QA Inspector observed the following personnel present, Smith Emery Certified Welding Inspector Mr. Michael Johnson, ABF Welding Superintendent Mr. Tommy Gibson and also welders Mr. Juan Andrade Ortega and Dan Gordon. Caltrans QA Inspector Mr. Robert Mertz was also present periodically. Mr. Robert Mertz will be observing PQR testing scheduled for dates 04-05-2007 through 04-09-2007.
- 3) Caltrans QA Inspector visually observed that only three flux cored arc welding (FCAW) filler passes were added to the PQR test plate assembly on this date. Visual observation of today's activities recall that the examined FCAW filler passes exposed to the surface of the weld joint contain linear porosity. The FCAW, welder Mr. Dan Gordon spent a majority of this date attempting to remove the surface linear porosity utilizing an electrical powered grinder.

For specific welding parameter values recorded during this procedure qualification record test see the Caltrans TL-6032 generated for this date. Digital pictures that support today's observations are included within the TL-6032.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Summary of Conversations:

1) Mr. Tommy Gibson voiced that PQR testing would resume on Thursday 04-05-2007.

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:	Cuellar,Robert	Quality Assurance Inspector
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Reviewed By:	Smith,Ryan	QA Reviewer
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