

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000122**Date Inspected:** 11-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification (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 the continuation of procedure qualification record (PQR) test that is identified as ABF-PQR-003-1. This PQR test is being attempted in the overhead (4G) position and represents an AWS D1.5 single vee groove using 25 mm thick steel plate and a 10mm thick steel backing bar.
- 2) The 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.
- 3) The Caltrans QA Inspector visually observed that the welder Mr. Dan Gordon applied two final flux cored arc welding (FCAW) cap weld passes. Flux cored arc welding of this PQR test plate assembly was completed on this date. The welder started to grind the completed cap weld pass for purposes of radiographic testing, however did not complete such task for final observation of the ground surface.

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.

Summary of Conversations:

- 1) Mr. Tommy Gibson voiced that PQR testing would resume on Thursday 04-12-2007.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
----------------------	----------------	-----------------------------

Reviewed By:	Smith,Ryan	QA Reviewer
---------------------	------------	-------------