

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-000134**Date Inspected:** 26-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**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 Record (PQR) Tests**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Mary Madere is present at the Ironworkers Apprenticeship Training Facility as requested by ABF for the continuing purpose of witnessing Procedure Qualification Record tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Companys Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representative Mr. Tommy Gibson and ABF Quality Control Manager (QCM) Mr. Jim Bowers, Bay Arc Representative Mr. Rich Deveau and welder Mr. Dan Gordon.

The QA Inspector observed welder Dan Gordon setting up a practice test plate prior to beginning the Procedure Qualification Record (PQR) Test identified as ABF-PQR-014-1. Mr. Gordon began welding the practice test plate at approximately 0830 hours. Welding parameter averages during the practice testing are as follows: 260 amps and 23.5 volts. Mr. Gordon practiced welding the root pass only on two test plates prior to beginning the identified PQR.

The QA Inspector witnessed the second attempt of the PQR identified as ABF-PQR-014-1. This PQR test is being attempted using the flux-cored arc welding (FCAW-G) process with gas shielding and a mechanical device that travels on a magnetic track. Welder Mr. Dan Gordon completed five weld passes on this date. For specific welding parameters recorded during this PQR and digital photographs that support these observations, see Caltrans Welding Witness Report, TL-6032 generated on this date.

Summary of Conversations:

QC Representative Mr. Michael Johnson informed the QA Inspector that welder Mr. Dan Gordon was going to weld the root pass and several practice weld passes prior to beginning the Procedure Qualification Record (PQR)

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Test identified as ABF-PQR-014-1.

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:	Madere,Mary	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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