

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-000135**Date Inspected:** 25-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		
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) 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 QC Mr. Michael Johnson performing Ultrasonic Testing (UT) on two Procedure Qualification Record (PQR) Tests identified as ABF-PQR-014-1 and ABF-PQR-010-1. Mr. Johnson elected to perform UT on the two test plates in an effort to determine the location and possibly the type of discontinuities found during Radiographic Testing (RT) on the previous date. During testing, Mr. Johnson mapped out various indications on each weld. After UT was completed, Mr. Johnson stated that the indications detected during UT are located in root area of each weld.

A short time later, ABF Representative Mr. Tommy Gibson elected to cut the test plate identified as ABF-PQR-014-1 in the areas marked by Mr. Johnson in an attempt to determine the cause of the RT failure. Digital photographs of the samples cut from this PQR are included within this report.

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Summary of Conversations:

ABF Representative Mr. Tommy Gibson informed the QA Inspector that the two Procedure Qualification Record (PQR) Tests x-rayed on the previous date were rejected by the Davis Laboratories, Incorporated Representative Mr. Matt Schonhoff. These two PQRs are identified as ABF-PQR-014-1 and ABF-PQR-010-1.

At approximately 1200 hours, QC Mr. Michael Johnson informed the QA Inspector that ABF would weld several passes on a practice test plate in preparation for a second attempt at the PQR identified as ABF-PQR-014-1. In addition, Mr. Johnson stated that Mr. Gordon would weld the practice plate on this date and begin the identified

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procedure on the following date. Later in the shift, the QA Inspector observed Mr. Gibson and Mr. Johnson cutting and removing sections from the PQR identified as ABF-PQR-010-1. Mr. Johnson stated that ABF would wait until the following date to set up for the second attempt at the PQR 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
Reviewed By:	Cuellar,Robert	QA Reviewer
