

**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 #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000156**Date Inspected:** 07-May-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, CA

<b>CWI Name:</b>	Michael Johnson		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**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 Company's Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representative Mr. Tommy Gibson, and welder Mr. Dan Gordon.

The QA Inspector observed welder Dan Gordon welding multiple practice test plates in preparation for a minimum heat input Procedure Qualification Record (PQR) Test identified as ABF-PQR-013-2. Under the direction of ABF Representative Mr. Tommy Gibson, Mr. Gordon welded the root pass and two subsequent weld passes in the flat position on each of the practice test plates. After welding of the practice test plates was completed, Mr. Gibson cut multiple cross sections from the plate in an effort to determine the quality of the weld and to ensure that the machine settings were correct before proceeding with the PQR Test. During welding of the practice test plates, the QA Inspector recorded an average of approximately 256 amps and 23.3 volts at Mr. Gordon's station. The following digital photograph illustrates Mr. Gordon in the process of welding one of the practice test plates in the flat position.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

ABF Representative Mr. Tommy Gibson informed the QA Inspector that Mr. Gordon would begin a Procedure Qualification Record (PQR) Test on the following date.

## 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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<b>Inspected By:</b>	Madere,Mary	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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