

**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 #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000157**Date Inspected:** 04-May-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1030**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) 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 Davis Laboratories, Incorporated Radiographic Technician Mr. Matt Schonhoff, as he prepared to perform Radiographic Testing (RT) on two Procedure Qualification Record (PQR) Test Plates identified as ABF-PQR-014-1 and ABF-PQR-013-1. The QA Inspector observed Mr. Schonhoff's equipment set up after the first exposure and verified compliance with AWS D1.5 2002, Figure 6.1A. After Mr. Schonhoff removed his film from the first exposure, the QA Inspector observed that Mr. Schonhoff was not using a lead symbol "B" on the back side of his film cassette as required by AWS D1.5 2002, Section 6.10.8.2. The QA Inspector addressed this issue with Mr. Schonhoff. Mr. Schonhoff agreed with the QA Inspector and then elected to discard the first exposure, attach a lead symbol "B" to his film cassette, and expose another piece of film. See the following digital photographs for additional information.

**PQR Test Summary**

Based on the Caltrans QA Inspectors observations starting from the first date of these PQR test attempts on 03-26-2007 through present date, fifteen PQRs have been attempted.

- Six (6) of the fifteen (15) PQR tests were found to be visually non-compliant by Quality Control.
- Eight (8) of the fifteen (15) PQR tests complied with the welding parameter and visual requirements, however

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did not comply with radiographic testing requirements.

There have been no PQR tests found to be compliant with all of the requirements of the contract documents.



## Summary of Conversations:

At approximately 1400 hours, Quality Control Representative Mr. Michael Johnson informed the QA Inspector that the Procedure Qualification Record (PQR) Test plates identified as ABF-PQR-014-1 and ABF-PQR-013-1 were rejected by Davis Laboratories RT Technician, Mr. Matt Schonhoff.

## 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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