

**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-000161**Date Inspected:** 30-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, 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 Companys 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 preparing a test plate for the Procedure Qualification Record (PQR) Test identified as ABF-PQR-013-1. Under the direction of ABF Representative Mr. Tommy Gibson, welder Dan Gordon welded the backing bar to the test plate for the full length of the plate. In addition, Mr. Gordon welded two additional strong backs to the backside of the test plate and used wedges to secure a heat shield behind the backing bar.

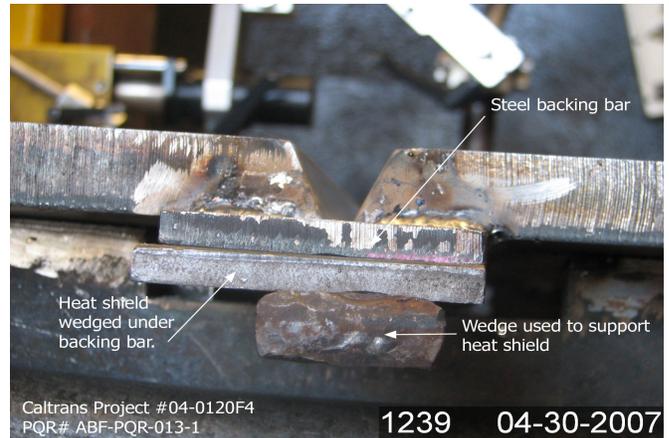
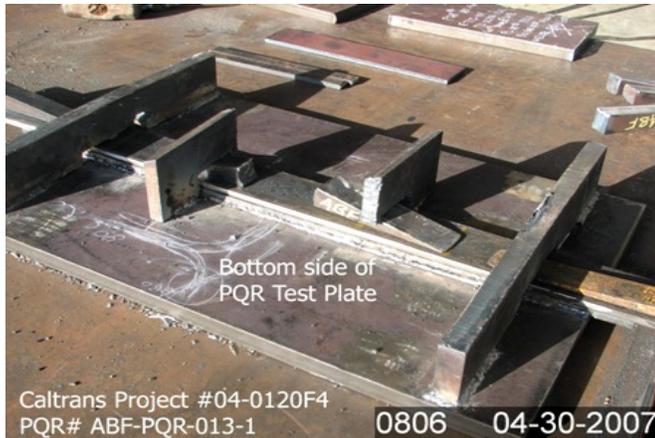
Mr. Gordon then set up a practice test plate using the flux-cored arc welding (FCAW-G) process with gas shielding and a mechanical device that travels on a magnetic track. Mr. Gordon welded three passes on the practice test plate. Welding parameters recorded by the QA Inspector during the practice test are approximately 252 amps and 24.8 volts. The following digital photographs illustrate the additional strong backs used and the heat shield secured by wedges to the bottom of the test plate.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

ABF Representative Mr. Tommy Gibson stated that he would use a 1/2 thick backing for the next PQR.

## 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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**Inspected By:** Madere, Mary

Quality Assurance Inspector

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**Reviewed By:** Cuellar, Robert

QA Reviewer