

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-000162**Date Inspected:** 24-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) 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. The following items have been observed:

- 1) The Caltrans QA Inspector observed the following personnel present: Smith-Emery Company's Certified Welding Inspector Mr. Michael Johnson, ABF Welding Superintendent Mr. Tommy Gibson, Bay Arc Representative Mr. Rich Deveau and welder Mr. Dan Gordon.
- 2) The QA Inspector was present for the purpose of witnessing the first attempt of the PQR identified as ABF-PQR-010-1. This PQR test is being attempted with the flux cored arc welding process utilizing a mechanized machine device set up on a magnetic track. The electrode being used is a CORESHIELD 8 self shielding electrode. The identified PQR test was completed on this date. For specific welding parameters values recorded during this PQR, see Caltrans Welding Witness Report, TL-6032 generated on this date. Digital photographs that support today's observations are included within the TL-6032.
- 3) The QA Inspector observed Davis Laboratories, Incorporated personnel identified as Mr. Matt Schonhoff and Mr. Chris Davidson in the process of performing radiographic testing (RT) of ABF-PQR-014-01, which was welded on Friday, April 20, 2007. The radiographers were performing RT on the completed weld prior to grinding of the weld reinforcement. The QA Inspector addressed this issue with Mr. Michael Johnson. Mr. Johnson stated that the weld reinforcement measured less than 1/32 prior to RT. The QA Inspector informed Mr. Johnson of the requirements of the State of California Standard Specifications dated July 1999, Section 55-3.17, which states, All weld surfaces shall be ground smooth and flush when nondestructive testing is required. In addition, the QA Inspector informed Mr. Johnson that ABF is proceeding at risk. At approximately 1630 hours, Mr. Johnson informed the QA Inspector that the identified PQR did not pass RT.

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Summary of Conversations:

As stated in the contents of the above report.

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
