

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000167**Date Inspected:** 06-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA.

CWI Name:	Mike 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) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Mertz was present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/ Fluor for the continuing purpose of witnessing Procedure Qualification Record (PQR) tests. The following items were observed:

1. The QA inspector observe the welder practicing and the Smith Emery Certified Welding Inspector (CWI) QC inspector setting up the welding parameters on a steel plate prior to starting the PQR test plate.
2. The observation is of a PQR test identified as ABF-PQR-002-1. This PQR test was welded in the vertical (3G) position, and is a single-vee groove with 25mm (1) thick A709, Grade 345W steel plate and a 10mm (3/8) thick steel backing bar per Figure 5.1 and is being welded per AWS D1.5, 2002, section 5.13.
3. The Caltrans QA inspector observed ABF Welding Superintendent Mr. Tommy Gibson was present.
4. The Caltrans QA inspector visually observed that one root pass and two self-shielded flux cored arc welding (FCAW-S) fill passes using Lincoln NR-232 wire were added to the PQR test plate assembly on this date by Dan Gordon.

For additional information and specific welding parameters recorded during this procedure qualification record test see the Caltrans TL-6032 generated for this date. Digital pictures of observations are available upon request.

Summary of Conversations:

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Mr. Tommy Gibson stated additional PQR testing would resume on Monday 04-09-2007.

The QC inspector informed the QA inspector that the tack welds to attach the backing bar and strong-backs (distortion aids) will end up being in the reduced tensile section and possibly cause a failure. The QA inspector informed Mr. Johnson and Mr. Gibson that since the plate is longer than required, one option could be to lay out the test plate specimens by moving over approximately one inch from center if done prior to RT testing and note it in the test records. The QA inspector explained that the test is normally evaluated from the center, out to a total of 23 inches, and METS does not want to test the entire plate and then select the 23 inches needed. The QA inspector also suggested that future test plates be tack welded out side the test zone when possible.

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:	Mertz,Robert	Quality Assurance Inspector
Reviewed By:	Smith,Ryan	QA Reviewer
