

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-000191**Date Inspected:** 18-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

CWI Name:	Michael 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 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 Representatives Mr. Tommy Gibson and Mr. Rick Clayborn, Bay Arc Representative Mr. Rich Deveau and welder Mr. Dan Gordon.

PQR Test Summary

Based on the Caltrans QA Inspectors observations starting from the first date of these PQR Test attempts on March 26, 2007, eighteen PQRs have been attempted. The first seven PQR test plates were found to be visually non-compliant by Quality Control. Nine of the PQR test plates complied with the welding parameter and visual requirements but did not comply with the requirements of radiographic testing (RT). On Thursday, May 17, 2007, two PQR plates were found to meet the requirements of RT and are now pending mechanical testing. On Tuesday, May 15, 2007, ABF discontinued welding of the third attempt at the PQR identified as ABF-PQR-014-1 due to equipment problems. As of this date, there have been no PQR tests found to be compliant with all of the requirements of the contract documents.

The QA Inspector witnessed the beginning of the first attempt of a maximum heat input Procedure Qualification Record (PQR) Test identified as ABF-PQR-017-1. This PQR test is being attempted using the flux-cored arc welding (FCAW-G) process with gas shielding and a mechanical device that travels on a magnetic track. Welder Mr. Dan Gordon deposited seven weld passes on this date. For specific welding parameters recorded during this

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PQR and digital photographs that support these observations, see Caltrans Welding Witness Report, TL-6032 generated on this date.

Summary of Conversations:

Quality Control Representative Mr. Michael Johnson stated that Mr. Gordon would complete the identified PQR test plate on Monday, May 21, 2007.

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
