

**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-000199**Date Inspected:** 08-Jun-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 Company's Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representatives Mr. Tommy Gibson and Mr. Rick Clayborn and welder Mr. Dan Gordon.

**Procedure Qualification Record (PQR) Summary:**

Since the beginning of PQR testing on March 26, 2007, ABF has attempted twenty-seven (27) PQR test plates. As of this date, six of the twenty seven test plates have passed radiographic testing (RT). Three test plates are currently pending RT.

On this date, the QA Inspector observed ABF personnel in the process of assembling Procedure Qualification Record (PQR) test plates and multiple practice test plates for use with the flux-cored arc welding (FCAW-G) process with gas shielding and a mechanical device that travels on a magnetic track. The QA Inspector observed ABF Representative Mr. Rick Clayborn as he welded several practice weld passes, then consulted with Quality Control (QC) Representative Mr. Michael Johnson to determine the correct settings for the machine being used. By the end of the shift, Mr. Clayborn and Mr. Johnson had determined the correct settings and prepared a PQR plate for welding on Monday, June 11, 2007. See the following digital photographs for additional information.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



## Summary of Conversations:

Quality Control Representative Mr. Michael Johnson stated that Mr. Gordon would begin a PQR test on Monday, June 11, 2007 using the flux-cored arc welding process with gas shielding in the flat position.

## 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