

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000241**Date Inspected:** 26-Jun-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 (PQR) 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.

The QA Inspector witnessed the completion of the second attempt of a PQR Test, which was previously identified as ABF-PQR-022-2. This PQR is now identified as ABF-PQR-022-2A. This PQR test is being attempted using the flux-cored arc welding (FCAW) process and a mechanical device that travels on a magnetic track. Welder Dan Gordon deposited three weld passes on this date. For specific welding parameters recorded during this PQR and digital photographs that support these observations, see Caltrans Welding Witness Report, TL-6032 generated on this date.

The QA Inspector witnessed the beginning of the second attempt of a PQR test, which was previously identified as ABF-PQR-021-1. This PQR is now identified as ABF-PQR-021-1A. Welder Dan Gordon deposited the root pass only on this date. After a visual inspection of the root pass, Quality Control Representative Mr. Michael Johnson observed excessive amounts of porosity in the root pass. At that time, ABF Representative Mr. Rick Clayborn elected to discontinue this PQR attempt and begin a third attempt at the same PQR. This PQR was identified as ABF-PQR-021-1B. Welder Dan Gordon deposited six passes on this PQR. After periodic visual inspections and excessive grinding to remove porosity, Mr. Clayborn elected to discontinue this PQR also.

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Summary of Conversations:

Quality Control Representative Mr. Michael Johnson informed the QA Inspector that PQR testing would continue on the following date.

ABF Representative Mr. Rick Clayborn informed the QA Inspector that he needed to consult with Mr. Tommy Gibson on how to proceed with the next attempt at this 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.

Inspected By: Madere, Mary

Quality Assurance Inspector

Reviewed By: Mertz, Robert

QA Reviewer