

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-000256**Date Inspected:** 05-Jul-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.

On this date, the QA Inspector observed ABF Representative Mr. Rick Clayborn as he used a grinder to remove temporary fitting aids from the backside of a PQR test plate identified as ABF-PQR-025-1. Following grinding, the QA Inspector observed Quality Control Representative Mr. Michael Johnson as he performed visual inspection of the back side of the identified test plate to ensure there are no surface irregularities that may interfere with radiographic testing. After visual inspection of the back side of the test plate was completed and accepted by Mr. Johnson, Mr. Clayborn then began grinding the weld reinforcement on the other side of the plate. Grinding of weld reinforcement was not completed on this date.

The QA Inspector witnessed the completion of the first attempt of a PQR Test identified as ABF-PQR-025-2. 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 eight 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.

On this date, ABF Representative Mr. Jim Bowers picked up six completed PQR test plates for delivery to

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Consolidated Engineering Laboratories (CEL) for radiographic testing. The six plates sent to CEL for radiography are identified as ABF-PQR-010-2, ABF-PQR-010-1B, ABF-PQR-011-1A, ABF-PQR-011-2A, ABF-PQR-022-2A and ABF-PQR-021-1C. At approximately 1400 hours, Mr. Bowers returned with two PQR test plate identified as ABF-PQR-021-1 and ABF-PQR-022-2. These two test plates failed radiographic testing on an earlier date and are now going to be cut longitudinally down the center of the weld and reused for future PQR testing.

The QA Inspector observed ABF personnel using practice test plates to establish root and filler pass settings in the vertical position for the next PQR test plate which will be identified as ABF-PQR-026-1.



Summary of Conversations:

Prior to welding, Quality Control Representative Mr. Michael Johnson informed the QA Inspector that the identified PQR would contain a separate zone for the root pass only.

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.

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Inspected By: Madere, Mary

Quality Assurance Inspector

Reviewed By: Mertz, Robert

QA Reviewer