

**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-000257**Date Inspected:** 06-Jul-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 (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 beginning of the first attempt of a PQR Test identified as ABF-PQR-026-1. This PQR test is being attempted using the flux-cored arc welding (FCAW) process and a mechanical device that travels on a magnetic track. ABF Representative Mr. Rick Clayborn performed excessive grinding on the root pass due to reoccurring mechanical problems. 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 Consolidated Engineering Laboratories (CEL) for mechanical testing. These plates have passed radiographic testing on a previous date and are identified as ABF-PQR-016-2, ABF-PQR-020-2, ABF-PQR-014-1C, ABF-PQR-017-1, ABF-PQR-020-1 and ABF-PQR-016-1B. Prior to shipment, Quality Control Representative Mr. Michael Johnson attached white envelopes to each test plate containing copies of the welding procedure specification, a QC visual sign off sheet and a Caltrans Sample Identification Card, TL-101.

The QA Inspector observed Quality Control Representative Mr. Michael Johnson as he performed ultrasonic

