

**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-000272**Date Inspected:** 10-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.

The QA Inspector witnessed the beginning of the first attempt of a PQR Test identified as ABF-PQR-026-2. This PQR test is being attempted using the flux-cored arc welding (FCAW) process and a mechanical device that travels on a magnetic track. ABF Representative Mr. Rick Clayborn completely removed weld pass number two by grinding due to fusion issues caused by mechanical problems. Welder Dan Gordon deposited seven 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 observed Quality Control Representative Mr. Michael Johnson as he performed a visual inspection of the completed PQR test plate identified as ABF-PQR-026-1 after removal the weld reinforcement. Following acceptance by QC and a visual inspection by the QA Inspector, the QA Inspector applied a green tag containing lot number B67-038-07 to the test plate. This test plate will be sent out for radiographic testing sometime in the week to follow. Following visual inspection, Mr. Johnson elected to perform ultrasonic testing on the identified PQR for information purposes only. At the completion of ultrasonic testing, Mr. Johnson informed the QA Inspector that the test plate appears to be acceptable.

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# WELDING INSPECTION REPORT

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On this date, ABF received a pallet containing twenty-five millimeter PQR test plates and twelve millimeter backing bars. The QA Inspector performed a review of the contractor supplied mill test reports (MTR) which stated that the material received was melted and manufactured in the United States. The QA Inspector documented heat numbers for the material received on this date as follows: A7C921 for the test plates and V02641 for the backing bars.



## 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

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