

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000297**Date Inspected:** 29-May-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:****Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Gregory Bertlesman 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, Bay Arc Representative Mr. Rich Deveau and welder Mr. Dan Gordon.

The QA Inspector witnessed the completion of a Procedure Qualification Record (PQR) Test identified as ABF-PQR-020-1. This PQR test is being attempted using the flux-cored arc welding (FCAW-S) process with Tri Mark TM-910 and a mechanical device that travels on a magnetic track. Welder Mr. Dan Gordon deposited two weld passes on this date to complete the welding of the PQR started on 5-25-07. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated on this date.

The QA Inspector witnessed the start of a Procedure Qualification Record (PQR) Test identified as ABF-PQR-020-1. This PQR test is being attempted using the flux-cored arc welding (FCAW-G) process with ESAB dualshield 70 Ultra plus and a mechanical device that travels on a magnetic track. Welder Mr. Dan Gordon deposited thirteen weld passes on this date to complete the welding of the PQR. Prior to welding, Quality Control Representative Mr. Michael Johnson informed the QA Inspector that this PQR would have a separate zone for the root pass only. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated on this date.

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Summary of Conversations:

As stated in the contents of the above report.

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:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
