

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-000298**Date Inspected:** 19-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 Representative Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector observed the continuation of the first attempt of a PQR test identified as ABF-PQR-002-2. 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 seven 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 ultrasonic testing (UT) on one completed PQR test plate for information purposes only. Mr. Johnson used a seventy degree angle for this informational inspection. At the completion of testing, Mr. Johnson informed the QA Inspector that UT of the PQR test plate identified as ABF-PQR-002-1D revealed multiple indications in the root pass with an indication rating of +14 dbs.

The QA Inspector performed a random visual inspection of the completed PQR test plate identified as ABF-PQR-002-1D after removal of the weld reinforcement in preparation for radiographic testing. The QA Inspector then applied a green tag containing lot number B67-043-07 to the test plate. This PQR test plate will be

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sent out for radiographic testing sometime this week.



Summary of Conversations:

Prior to welding, QC Mr. Johnson informed the QA Inspector that 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.

Inspected By: Madere, Mary

Quality Assurance Inspector

Reviewed By: Mertz, Robert

QA Reviewer