

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-000310**Date Inspected:** 25-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 Representative Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector observed Mr. Dan Gordon as he welded several practice test plates to determine root pass settings for the next PQR which will be identified as ABF-PQR-004-1. The QA Inspector recorded approximately 250 amps and 22 volts during practice welding. Mr. Gordon welded 125 millimeter sections of these practice test plates using various parameters and travel speed, then removed the backing bar to evaluate the weld. Mr. Gordon welded seven practice test plates PQR on this date. After the seventh practice test plate, ABF Representative Mr. Rick Clayborn elected to discontinue the attempts at the identified PQR at this time. See summary of conversations below for additional information.

The QA Inspector observed the beginning of the fourth attempt of a PQR test identified as ABF-PQR-010-1C. This PQR was previously identified as ABF-PQR-010-1. This PQR test is being attempted using the flux-cored arc welding (FCAW) process and a mechanical device that travels on a magnetic track. Welder Dan Gordon deposited the root pass only 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

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Summary of Conversations:

At approximately 1230 hours, Quality Control (QC) Representative Mr. Michael Johnson informed the QA Inspector that ABF has decided to temporarily discontinue PQR testing using the Lincoln NR-232 electrode. ABF made this decision based on welding ten practice test plates on the previous day and seven practice test plates on this date without being able to establish welding parameters to deposit a suitable root pass.

ABF Representative Mr. Tommy Gibson informed the QA Inspector that he delivered eight completed PQR test plates to the warehouse for temporary storage until a decision is made about which company would perform the required radiographic testing.

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
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Reviewed By:	Mertz, Robert	QA Reviewer
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