

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-000337**Date Inspected:** 09-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benica, CA

CWI Name:	Jesse Cayabyab		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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 Danny C. White (B89) is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/Flour (ABF) for the purpose of witnessing Procedure Qualification Record (PQR) tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Companys Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Jesse Cayabyab, ABF Representatives Mr. Tommy Gibson, Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector observed PQR plate known as ABF-PQR-027-1 was removed from the fixture and transported to a covered outside location for (informational only) ultrasonic testing (UT). The QA Inspector monitored QC Representative Jesse Cayabyab perform UT. See photo for additional information.

The QA Inspector observed welding being performed on a non-PQR test plate that was tacked in the 4G position onto a fixture near the next PQR test plate that is to be welded. Welder Mr. Dan Gordon is using .072 inch diameter (1.8 millimeter) flux-cored arc Hobart Fabshield XLR-8 (FCAW-S) process. The QA Inspector monitored QC Representative Mr. Cayabyab while he checked welding amperage, voltage and travel speed parameters.

Welding began on PQR plate known as ABF-PQR-027-2 which represents the minimum amperage, voltage and travel speed settings. This PQR test is being attempted using .072 inch diameter (1.8 millimeter) Hobart Fabshield XLR-8 flux-cored arc welding (FCAW-S) wire and a Bug-O Systems mechanical device that travels on a magnetic track. Welder Dan Gordon deposited (8) passes. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated on this date.

WELDING INSPECTION REPORT

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Summary of Conversations:

See above

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: White,Danny

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer