

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000364**Date Inspected:** 15-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, 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:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Danny C. White (B89) is present at the Ironworkers Apprenticeship Training Facility and Construction Materials Testing 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 Company Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Jesse Cayabyab ABF Representatives Mr. Tommy Gibson, Mr. Rick Clayborn and welder Mr. Dan Gordon.

In the beginning of the shift the QA Inspector arrived at the Ironworkers Apprenticeship Training Facility and observed that the welders were tacking PQR test plates together and was informed that welding on the PQR test plate known as ABF-PQR-011-1C would not begin until later in the shift. The QA Inspector departed the Ironworkers Apprenticeship Training Facility and arrived at CMT for the final Visual Inspection (VT) of (4) PQR plates and issued the following (4) Lot numbers affixed to the face of the plates: ABF-PQR-027-1 Lot #B89-008-07, ABF-PQR-027-2 Lot #B89-009-07, ABF-PQR-025-1A Lot #B89-010-07, ABF-PQR-010-1D Lot #B89-011-07.

Later in the shift the QA Inspector left Construction Materials Testing and arrived back at the Ironworkers Apprenticeship Training Facility and observed a total of (3) passes were deposited on the PQR test plate known as ABF-PQR-011-1C. This is the fourth attempt welding this PQR plate and this test plate is being welded in the 3G position. Mr. Cayabyab monitored welding amperage, voltage and travel speed parameters. The welders are using .072 inch diameter (1.8mm) ESAB Coreshield 8 (FCAW-S) process and utilizing a Bug-O Systems mechanical device that travels on a magnetic track. For specific welding parameters recorded during this PQR see Caltrans

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Welding Witness Report, TL-6032 generated on this date.

Summary of Conversations:

The QC Inspector Informed the QA Inspector that prior to being shipped he had performed informational UT on ABF-PQR-010-1D and ABF-PQR-025-1A with no rejectable indications found.

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
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Reviewed By:	Mertz,Robert	QA Reviewer
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