

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-000381**Date Inspected:** 24-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:** Benica, 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 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 Company Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representatives Mr. Tommy Gibson, Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector observed the welding on the PQR test plate known as ABF-PQR-003-1A was started this day. This is the second attempt to weld this PQR test plate. Welder Dan Gordon completed a total of (5) weld passes in the 4G position. Mr. Johnson monitored welding amperage, voltage and travel speed parameters. The welders are using .072 inch diameter (1.8mm) Lincoln Innershield 232 E71T-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 Witness Report, TL-6032 generated upon completion of this PQR test plate.

The QA Inspector observed that the welders are experiencing problems with the Bug-O device. It was observed that the welders have taken apart this device to make repairs. See the left photo below for additional information.

WELDING INSPECTION REPORT

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Summary of Conversations:

The QC Inspector informed the QA Inspector that he performed informational Ultrasonic Testing (UT) on the PQR plate known as ABF-PQR-002-2B and found several indications in the root area. See the right photo above for additional information. The QA Inspector was informed these indications would be considered acceptable and the QC Inspector informed ABF Representative Mr. Tommy Gibson of the indications found. The QA Inspector was informed by Mr. Gibson that this PQR plate will undergo Radiographic testing and was shipped this date.

The QC Inspector informed the QA Inspector that the root pass will be considered Zone #1 and the successive weld passes will be considered Zone #2.

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