

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000382**Date Inspected:** 27-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:** 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 completion of welding on the PQR test plate known as ABF-PQR-003-1A. This is the second attempt to weld this PQR test plate. Welder Dan Gordon deposited the (3) final weld cover passes making a total of (8) weld passes deposited onto this PQR plate. These (8) weld passes were made 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 on this date.

The QA Inspector observed that the welders remove 2 inches of the back-up bar from each end of ABF-PQR-003-1A plate to observe any indications that may exist. The ends of the PQR test plate in which the backing bar was removed are considered discard areas. It was observed that Round Indications were discovered at both locations. See photo below for additional information.

Later in the shift the QA Inspector observed the welders weld (2) non-PQR test plates to set the welding parameters. After the root pass was deposited in these non-PQR test plates, ABF removed the backing bar by carbon arc cutting (COC) to assess the backing bar and root area.

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Summary of Conversations:

The QC Inspector informed the QA Inspector that he will perform informational Ultrasonic Testing (UT) on the PQR plate known as ABF-PQR-003-1A at a later date.

The QA Inspector informed the QC Inspector that lot number B89-016-07 is issued to this PQR test plate.

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
