

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-000384**Date Inspected:** 29-Aug-2007**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Arrival Time:** 700**OSM Departure Time:** 1530**Location:** Benicia, CA

CWI Name: Mike Johnson
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 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 PQR test plate known as ABF-PQR-025-1B was completed this day. This is the second attempt to weld this PQR test plate. Welder Dan Gordon completed (8) total weld passes in the 1G position. The root pass was deposited by hand and the QA Inspector was informed by the QC Inspector that this will be considered zone #1. See photo for additional information. It is noted by the QA Inspector that a start stop occurred in the root pass approximately 160mm from the beginning of the weld. This start stop area was blended to a smooth transition prior to completing the root pass. Sequential passes were deposited utilizing the Bug-O Systems mechanical device and will be considered zone #2. Mr. Johnson monitored welding amperage, voltage and travel speed parameters. The welders are using .072 inch diameter (1.8mm) Hobart Fabshield XLR-8 E71T-8 (FCAW-S) process. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated this date.

WELDING INSPECTION REPORT

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Summary of Conversations:

The QA Inspector informed the QC Inspector that lot number B89-017-07 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
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Reviewed By:	Mertz,Robert	QA Reviewer
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