

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-000407**Date Inspected:** 04-Sep-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:** Benicia, CA**CWI Name:** Micheal 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 third attempt to weld PQR test plate known as ABF-PQR-010-2B. Welder Dan Gordon completed (10) total weld passes in the 1G position. Mr. Johnson monitored welding amperage, voltage and travel speed parameters. The welders are using .072 inch diameter (1.8mm) ESAB Coreshield-8 E71T-8 self shielding Flux Core Arc Welding (FCAW-S) process. It is noted that the root weld pass was deposited by hand and the (9) sequential weld passes were deposited utilizing a Bug-O Systems mechanical device that travels on a magnetic track. The QA Inspector observed that the cover weld passes number 9 and 10 appeared to contain very small round indications with trails. See photo below for additional information.

The QA Inspector observed that after grinding, the round indications appeared to have been removed. The QA Inspector observed that upon completion the QC Inspector performed Visual Testing (VT) and informational Ultrasonic Testing (UT). Following the QC Inspectors acceptance, The QA Inspector performed a VT inspection and affixed a green tag to the face of this PQR test plate. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated upon the completion of this PQR test plate.

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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
