

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000408**Date Inspected:** 05-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:	Michael 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.

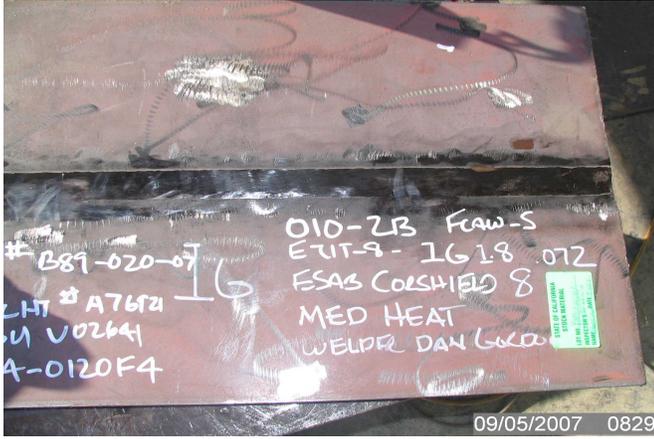
The QA Inspector observed welding on the PQR test plate known as ABF-PQR-011-1D was started this day. This is the fifth attempt to weld this PQR test plate and it is being welded in the 3G position. Welder Dan Gordon deposited The root weld pass was deposited by hand and the (2) the sequential weld passes were made utilizing a Bug-O Systems mechanical device that travels on a magnetic track. Mr. Johnson monitored welding amperage, voltage and travel speed parameters. The welders are using .072 inch diameter (1.8mm) ESAB Core Shield-8 E71T-8 (FCAW-S) process to make these welds. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated upon the completion of this PQR test plate.

Summary of Conversations:

The QC Inspector informed the QA Inspector the PQR plate known as ABF-PQR-010-2B was ready for Visual Testing (VT) and informational Ultrasonic Testing (UT). The QA Inspector observed the QC Inspector perform these inspections and upon the QC inspectors acceptance, the QA Inspector performed VT inspection and affixed a green tag to the face of this PQR plate with the Lot #B89-020-07. See photo below for more information.

WELDING INSPECTION REPORT

(Continued Page 2 of 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
