

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-000409**Date Inspected:** 06-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**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.

In the beginning of the shift the QA Inspector observed welding on the PQR test plate known as ABF-PQR-011-1D. This is the fifth attempt to weld this PQR test plate and it is being welded in the 3G position. This PQR test plate was started Wednesday 8/5/07 and was completed this day. Welder Dan Gordon deposited (5) sequential weld passes over the existing (3) for a total of (8) weld passes. The final (5) weld passes made this day 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). For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated this date.

Later in the shift the QA Inspector observed welding on the PQR test plate known as ABF-PQR-011-2C. This is the fourth attempt to weld this PQR test plate and it is being welded in the 3G position. This PQR test plate was not completed this day. Welder Dan Gordon deposited the root weld pass by hand and (4) sequential weld passes 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). For specific welding parameters recorded during this PQR see Caltrans

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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-011-1D was ready for Visual Testing (VT) (see photo on the left below for additional information) and informational Ultrasonic Testing (UT) (see photo on the right for additional information). The QA Inspector observed the QC Inspector perform these inspections and upon the QC inspectors acceptance, the QA Inspector performed VT inspection. The QA Inspector observed that the weld reinforcement was not ground at this time and was informed that it would be ground prior to being shipped for Radiographic Testing.



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
