

**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-000410**Date Inspected:** 07-Sep-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

<b>CWI Name:</b>	Michael Johnson		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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 the welding and completion of 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 started Thursday 9/6/07 and was completed this day. Welder Dan Gordon deposited (4) sequential weld passes made utilizing a Bug-O Systems mechanical device that travels on a magnetic track and these (4) weld passes were deposited over (5) previously made weld passes for a total of (9) weld passes made on this PQR test plate. Mr. Johnson monitored welding amperage, voltage and travel speed parameters. The welders are using .072 inch diameter (1.8mm) ESAB Coreshield-8 E71T-8 (FCAW-S) welding wire. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated this date.

**Summary of Conversations:**

The QC Inspector informed the QA Inspector that Ultrasonic Testing (UT) will not be performed on this PQR test plate prior to 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

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## WELDING INSPECTION REPORT

*( Continued Page 2 of 2 )*

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	White,Danny	Quality Assurance Inspector
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<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer
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