

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-000508**Date Inspected:** 10-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, California**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 Robert Cuellar is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/ Fluor for the continuing purpose of witnessing Procedure Qualification Record tests. The following items have been observed,

1) Today's observation is of an initial procedure qualification record PQR test that is identified as ABF-PQR-003-1.

This PQR test is being attempted in the overhead (4G) position and represents an AWS D1.5 single vee groove with one inch thick steel plate and a 10mm thick steel backing bar.

2) The Caltrans QA Inspector observed the following personnel present, Smith Emery Certified Welding Inspector Mr. Michael Johnson, ABF Welding Superintendent Mr. Tommy Gibson and also welders Mr. Juan Andrade Ortega and Dan Gordon. Caltrans QA Inspector Mr. Robert Mertz was present for a portion of the morning hours.

3) The Caltrans QA Inspector visually observed that the welder Mr. Dan Gordon applied nine flux cored arc welding (FCAW) filler

passes to the PQR test plate assembly on this date. Visual observation of today's activities recall that the welder utilized an electrical powered grinder for the removal of passes number seven and number eight. These weld passes were removed at the discretion of Quality Control and the welder due to non-uniform weld profiles, excessive weld reinforcement and also linear voids along the weld pass and the groove bevel face boundary. After these two weld passes were removed the subsequent weld passes were observed as visually compliant.

Flux cored arc welding of this PQR test plate assembly was not completed on this date. The cap weld remains to be welded and is scheduled to resume on Wednesday 04-11-2007.

For specific welding parameter values recorded during this procedure qualification record test see the Caltrans TL-6032 generated for this date. Digital pictures that support today's observations are included within the TL-6032.

WELDING INSPECTION REPORT

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Summary of Conversations:

Mr. Tommy Gibson voiced that PQR testing would resume on Thursday 04-11-2007.

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:	Cuellar,Robert	Quality Assurance Inspector
Reviewed By:	Smith,Ryan	QA Reviewer
