

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-000544**Date Inspected:** 27-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:** Benica, 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.

At the beginning of the shift the QA Inspector observed the welding operators deposit (10) weld passes onto the PQR test plate known as ABF-PQR-014-1C-CR in the 3G position. The welders are using 1/16 inch diameter (1.6mm) ESAB Dual Shield 70 Ultra Plus E71T-1M/9-M (FCAW-G) welding wire and 90% Argon / 10% Carbon Dioxide gas. Welder Dan Gordon deposited (10) sequential weld passes utilizing a Bug-O Systems mechanical device that travels on a magnetic track. Mr. Johnson and the QA Inspector monitored welding amperage, voltage and travel speed parameters. The QA Inspector was informed by the welders that (2) areas (each approximately 50 millimeters in length) in the root pass at approximately 550 millimeters and 640 millimeters from the start of the weld exhibited arc blow and were removed by grinding prior to repair. See photo below for additional information. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated this date.

WELDING INSPECTION REPORT

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Summary of Conversations:

The QA Inspector was informed by ABF that PQR test plate ABF-PQR-014-1C-CR will undergo informational Ultrasonic Testing (UT) and informational Radiographic Testing (RT) prior to the Charpy V Notch samples being removed from the test plate.

The QA Inspector was informed by the QC Inspector that UT was performed on ABF-PQR-016-1B-CR with no rejectable indications.

Important Note: The QA Inspector noticed that the report dated the 26th of September is actually for the 25th of September.

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
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Reviewed By:	Mertz,Robert	QA Reviewer
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