

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-000575**Date Inspected:** 03-Oct-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**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 QC Inspector perform a visual inspection on the following (4) PQR test plates. These PQR test plates were welded specifically to retest the Charpy V Notch values since the previous tests were performed at 0 degrees instead of -20 degrees as ABF had desired to conform to fracture critical requirements. Following the QC Inspector's acceptance of these PQR test plates the QA Inspector affixed a Green Tag sticker on to the weld face side and issued the QC Inspector the appropriate TL-101 Sample Identification Card and assigned the following Lot # to each of the following tests; Lot # B89-027-07 ABF-PQR-016-1B-CR, Lot # B89-028-07 to ABF-PQR-014-1C-CR, Lot # B89-029-07 to ABF-PQR-020-1-CR and Lot # B89-030-07 to ABF-PQR-020-2-CR. The QA Inspector was informed that these PQR test plates were shipped for informational Radiographic Testing (RT) at this time.

The QA Inspector was informed by ABF that the next PQR test plate is awaiting the arrival of Lincoln welding wire and the wire is expected this day. The QA Inspector observed that while the welders were waiting for the welding wire mentioned above, they proceeded fabricating (7) additional PQR test plates. Towards the end of the shift the QA Inspector observed that the welding wire had not arrived.

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Summary of Conversations:

See above.

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
