

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 Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000800**Date Inspected:** 29-Oct-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:	William Norris		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	PQR		

Bridge No: 34-0006**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector arrived at the Ironworkers Apprenticeship Training Facility and witnessed welding of a Procedure Qualification (PQR) test plate designated ABF-PQR-012-1 using self shielded flux cored arc welding (FCAW) using Coreshield 8 electrode, .072 in. diameter. The welding was conducted with the support of a track guided "Bug O" system in the 4G (overhead) position. The welding was performed per the AWS D1.5, 2002 Section 5.13 requirements. The Smith Emery QC inspector, Mr. William Norris recorded the preheat and interpass temperatures, the average amperage, voltage and the travel speed for all weld passes. The root pass was identified as zone 1 and the remainder of the weld was identified as zone 2. The welder Mr. Daniel Gordon partially removed the third pass using a manual air-carbon arc system. After the air-carbon arc cutting was complete, the weld groove was ground. The welding of this plate was completed on this date. The QA inspector noted that the welding appeared to comply with the contract documents. Pictures are on file.

Summary of Conversations:

At the start of welding the QC inspector reported that the Procedure Qualification test was to be performed in accordance with AWS D1.5-2002 section 5.12 maximum heat input. The QA inspector informed Mr. Norris that the filler metal utilized was not included in Table 4.1 and the procedure would fall under the requirements of Section 5.13 production procedure specification. At the completion of the welding the QC inspector Mr. Morris reported that the test plate visual inspection would be performed at a later date.

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.

WELDING INSPECTION REPORT

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Inspected By:	Lanz,Joe	Quality Assurance Inspector
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Reviewed By:	Mertz,Robert	QA Reviewer
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