

**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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007499**Date Inspected:** 02-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1200**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7, Oakland, CA

<b>CWI Name:</b>	Mike 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:****Summary of Items Observed:**

This Quality Assurance (QA) Inspector arrived at the American Bridge/Fluor (ABF) warehouse at berth 7 and met with Quality Control (QC) Inspector Mike Johnson and ABF welder Sal Sandoval. QC Mike Johnson and welder Sal Sandoval adjusted the welding machine to correspond with previously used parameters. After completing the necessary adjustments, QA observed ABF welder Sal Sandoval continued welding the Procedure Qualification Record ABF PQR-003-1. The welder was noted using the same Lincoln Electric Innershield NR-232 with 0.072" diameter at 4G position. The plate was also noted at 70 degree F prior welding. The sixth pass was welded with measured welding parameters of 20.3 volts, 226 amperes and 3.37 inch per minute travel speed. Calculated heat input was 81.68 Kjoules per inch. The seventh pass until the eleventh pass (last pass) was welded with average parameters of 19.96 volts, 225.2 amperes and 3.38 inch per minute travel speed. The eight and tenth passes were carbon arc gouged at the edge of the weld for better deposition of the succeeding passes while the seventh and ninth passes were ground. The test plate was completely filled and cover welded but was not able to clean after the last and final pass due to time constraint. QC Mike Johnson and the welder only worked until 1200 hrs. QC Mike Johnson informed QA that the welder will continue on Monday and that welder will clean the PQR weld prior QC/QA visual verification.

**Summary of Conversations:**

No significant conversation occurred today.

**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 Tony Mullen (707-649-5495), who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Lizardo, Joselito	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill	QA Reviewer
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