

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-011073**Date Inspected:** 31-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Oakland, CA

CWI Name: Mike Johnson
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

Bridge No: 34-0006**Component:** ABF-PQR-033**Summary of Items Observed:**

This Quality Assurance (QA) Inspector arrived at American Bridge/Fluor (ABF) warehouse to monitor the welding of Procedure Qualification Record (PQR) test plates and Quality Control (QC) functions.

The QA Inspector was on site on 12/31/09 to observe the removal of the steel backing and back welding of the above identified PQR plate. Upon the arrival of the QA Inspector, the ABF welding operator Rory Hogan was observed removing the steel backing bar utilizing a plasma cutting thermal gouge. After the bar was removed, the weld was back gouged with the plasma cutter and ground to a weldable profile. The QA Inspector randomly observed the QC Inspector Mike Johnson perform magnetic particle testing of the back gouged weld. Mr. Johnson informed the QA Inspector, no relevant indications were located. After the semi automated bug-o track was set up in the 4G position the welding operator performed the single pass back weld. The QA Inspector recorded the FCAW-G parameters and they were 265 Amps, 23.1 Volts, 239mm/min travel and a heat input of 1.53 kJ.

The QA Inspector was informed by the QC Inspector Mike Johnson, the plate will not be ready for final inspection until Monday 1/4/10. Mr Johnson informed the QA Inspector the final grinding will be performed on Monday. The QA Inspector noted the welding of the above identified PQR appeared to meet the general requirements of the contract.

Summary of Conversations:

As noted 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

WELDING INSPECTION REPORT

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remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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