

APPENDIX J
HDPE GEOMEMBRANE CQA DOCUMENTATION



TRIAL SEAM LOG - FUSION

PROJECT: ASARCO El Paso Category 1 Landfill - Cell 3 CQA

LOCATION: 2301 West Paisano Drive, El Paso, TX 79922 PROJECT NO.: 06835001.2014 TASK NO.: 47CQ1

DESCRIPTION: Cell 3 CQA - Baseline Repairs (60 mil HDPE) YEAR: 2014

SPECIFICATIONS: FUSION WELD: PEEL: 91 SHEAR: 120 ppi psi
 EXTRUSION WELD: PEEL: 78 SHEAR: 120 ppi psi

TENSIOMETER DESCRIPTION: Pro-Tester T-0100 SERIAL NO.: 667867

DATE (mo/day/yr)	TRIAL SEAM NO.	TIME	OPER. ID	MACHINE NO.	MAT. DESCR. (1)	FUSHION WELD		EXTRUSION WELD		PEEL VALUES (lbs/in)				SHEER (lbs/in)				PASS	FAIL	QA ID	
						WEDGE TEMP. (°F)	MACHINE SPEED SETTING (ft/min)	BARREL TEMP. (°F)	PREHEAT TEMP. (°F)												
4/7/2014	1	14:05	WB	1266	T/T			350	230					151	148	150			X	RJ	
4/7/2014	2	14:10	RM	84	T/T			450	310	131	128	133		160	155	152			X	RJ	
4/8/2014	3	9:34	RM	84	T/T			450	400	135	137	132		175	174	176			X	RJ	
										113	85	78									

NOTE: (1) MATERIAL DESCRIPTION REFERS TO EITHER SMOOTH/SMOOTH (S/S); SMOOTH/TEXTURED (S/T); OR TEXTURED/TEXTURED (T/T).



REPAIR SUMMARY LOG

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 INSTALLER: American Environmental Group (AEG) PRIMARY SECONDARY OTHER

REPAIR NO.	REP. CODE	DATE (mo/day/yr)	LOCATION ²			SIZE ²			WELDER ID		QA ID	NON-DESTRUCTIVE TESTING						
			SEAM	PANEL	LOCATION	LENGTH	WIDTH	DIA.	MACH. NO.	OP. ID		DATE	OP. ID	PASS	FAIL	ACTION	QA ID	
1	P	4/7/2014	Baseliner Repair		8' W of SE Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ	
2	P	4/7/2014				25' W of SE Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
3	P	4/7/2014				180' W of SE Corner	1	2	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
4	P	4/7/2014				228' W of SE Corner	1	2	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
5	P	4/7/2014				231' W of SE Corner	1	2	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
6	P	4/7/2014				232' W of SE Corner	1	2	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
7	P	4/7/2014				261' W of SE Corner	2	2	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
8	P	4/7/2014				264' W of SE Corner	1	1	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
9	P	4/7/2014				313' W of SE Corner	2	4	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
10	P	4/7/2014				385' W of SE Corner	2	5	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
11	P	4/7/2014				350' W of SE Corner	2	6	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
12	P	4/7/2014				355' W of SE Corner	1	1	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
13	P	4/7/2014				87' N of SW Corner	1	1	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
14	P	4/7/2014				96' N of SW Corner	1	1	---	84	RM	RJ	4/7/2014	RM	X		VT OK	RJ
15	P	4/7/2014				10' E of NW Corner	18	4	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
16	P	4/7/2014				214' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
17	P	4/7/2014				260' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
18	P	4/7/2014				261' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
19	P	4/7/2014				266' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ

NOTES: (1) REPAIR NUMBERS SHALL BE NUMBERED SEQUENTIALLY, REPAIR CODES: P = PATCH C = CAP S = ANCHOR TRENCH EXTENSION (SKIRT)
 DS = DESTRUCTIVE SAMPLE G = GRIND & WELD T = TOPPING ALONG FUSION SEAM R = RECONSTRUCTION B = BEAD (EXTRUSION)
 (2) LOCATION & SIZE SHALL BE INDICATED IN FEET

20	P	4/7/2014			269' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
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REVIEWED BY: _____



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			SEAM	PANEL	LOCATION	LENGTH	WIDTH	DIA.	MACH. NO.	OP. ID		DATE	OP. ID	PASS	FAIL	ACTION	QA ID
21	P	4/7/2014	Baseliner Repair		280' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
22	P	4/7/2014			290' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
23	P	4/7/2014			298' E of NW Corner	3	5	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
24	P	4/7/2014			333' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
25	P	4/7/2014			366' E of NW Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
26	P	4/7/2014			52' S of NE Corner	1	1	---	1266	WB	RJ	4/7/2014	RM	X		VT OK	RJ
27	P	4/8/2014			10' S of NE Corner	2	3	---	84	RM	RJ	4/8/2014	RM	X		VT OK	RJ
28	P	4/8/2014			14' S of NE Corner	1	1	---	84	RM	RJ	4/8/2014	RM	X		VT OK	RJ
29	P	4/8/2014			20' S of NE Corner	1	1	---	84	RM	RJ	4/8/2014	RM	X		VT OK	RJ

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