

**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 #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001218**Date Inspected:** 10-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:****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:** West Deviation Saddle Segment W2E2**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI) representative, Mr. Wai Pau traveled to Nikko Inspection Service (NIS) office, to review radiographic testing (RT) film result of ASME IX Flux Cored Arc Welding (FCAW) horizontal position (2G) welder qualification test and ASME IX standard Shielded Metal Arc Welding (SMAW) process PQR qualification test. First, a total of ten welder qualification films submitted to Caltrans QAI for reviewing. The source of radiation for films used is portable X-ray model Radioflex-300EGM made by Rigaku Denki Service and performed by NIS radiographer Level II Mr. Osamu Nitami on Dec-26-07. The radiograph film used is type Fuji #80, size 114mm x 432mm with wire type Image Quality Indicators (IQI) ASTM 1B. The ten films also evaluated and accepted by NIS interpreter Level II Mr. Masanobu Nakajima prior Caltrans QAI reviewing. Based on Caltrans QA reviewing, the ten radiograph films quality and weldments quality results in the films were appeared to be in general compliance with requirements of the Caltrans Special Provisions and ASME IX 2006. Ten Caltrans Lot# B88-001-08 to B88-010-08 were assigned on those films for tracking propose. Next, a total of three films for PQR qualification test were submitted to Caltrans for review. The PQR is numbered SJ-2941-WP2. The source of radiation for film used is 4 Mev Linac type and performed by NIS radiographer Level II Mr. Osamu Nitami on Dec-13-07. The radiograph film used is type Fuji #50, size 178mm x 432mm with wire type IQI ASTM 1B. The three films also evaluated and accepted by NIS interpreter Level II Mr. Masanobu Nakajima prior Caltrans QAI reviewing. Based on Caltrans QA reviewing, the three radiograph films were observed for quality and weldments quality results. These films appeared to be in general compliance with requirements of the Caltrans Special Provisions and ASME IX 2006 Section.

**Summary of Conversations:**

As note within the report above.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## 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 Venkatesh Iyer (858)697-6363, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
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<b>Reviewed By:</b>	Brasel,Ron	QA Reviewer
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