

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001705**Date Inspected:** 13-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Japan Steel Works, Ltd.**Location:** Muraran, Japan

CWI Name:	Chung Kuan and Makhmud Ashadi			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:	PQR Test Plate SW-4-1		

Summary of Items Observed:

On this date OSM Quality Assurance Representative Daniel L. Reyes observed the casting of the cable saddles, welding of the structural steel components and inspection relative to this project. The following was observed:

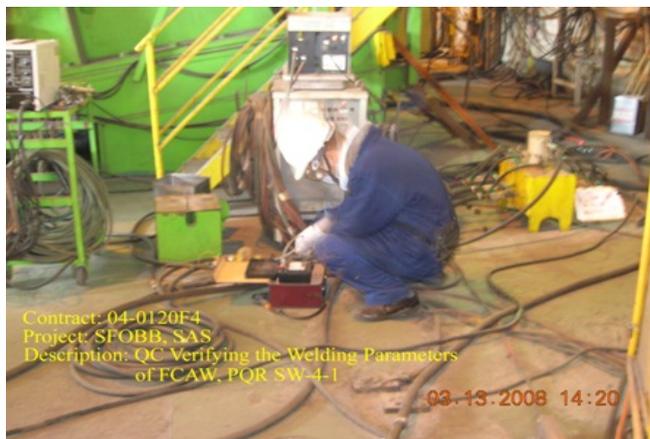
At the start of the shift this QA inspector observed the continued welding and inspection of the Procedure Qualification Record (PQR) test plate identified as SW-4-1. The welding was performed by Japan Steel Works, Ltd. welding personnel Ko Payashi ID 08-5023 utilizing the gas shielded Flux Cored Arc Welding (FCAW-G) as per the Welding Procedure Specification (WPS) SJ-2942 WP-5 which was also used by the Quality Control (QC) Inspectors Makhmud Ashadi and Chung Kuan as a reference. The consumable utilized during the welding of the test plate was identified as a Tri-Mark TM-95K2 with a diameter of 1.6 millimeters manufactured by Hobart Brothers.

The QC inspector Mr. Ashadi verified the minimum preheat temperature of 160 degrees Celsius and at the conclusion of verifying the surface temperature the welder Mr. Payashi continued the welding of the fill passes. At this time the QA inspector also observed Mr. Ashadi verifying the travel speed and Mr. Kuan verifying the amperage and voltage. The average welding parameters were observed by this QA inspector as follows; 340 amps, 35.0 volts with a travel speed measured at 287mm/m.

Later in the shift this QA inspector observed, at random intervals, the QC inspectors Makhmud Ashadi and Chung Kuan performing the in process weld inspection and verifying the minimum preheat, maximum interpass temperatures and the DCEP welding parameters. The welding of the Test Plate identified as SW-4-1 was not completed during this shift on this date and appeared to comply with the WPS. (See Digital Photographs)

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Summary of Conversations:

There were general conversations with the Quality Control (QC) Inspectors Makhmud Ashadi and Chung Kuan relative to the Procedure Qualification Record Test and the location of the welding personnel.

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) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By: Reyes, Danny

Quality Assurance Inspector

Reviewed By: Brasel, Ron

QA Reviewer