

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-002056**Date Inspected:** 25-Apr-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 930**OSM Departure Time:** 1630**Location:** Muroran, Japan

CWI Name:	Mr. Makhmud Ashadi and Mr. Chung Kuan			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
Bridge No:	34-0006			Delayed / Cancelled:	Yes	No	N/A
				Component:	Tower, Jacking and Deviation Saddles		

Summary of Items Observed:

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan. Current work: Casting, machining and nondestructive testing of Saddles.

At 1300 hours, the Caltrans Quality Assurance (QA) inspector arrived at JSW fabrication shop number 4 and observed a procedure qualification test designated GJ6-3402 SW-7-2 performed by JWS welding personnel Mr. Kouzou Kabayashi. The QA inspector, Mr. Daniel Reyes had monitored the welding prior to 1300 hours on this date. The welding was performed utilizing the shielded metal arc welding process in the vertical (3G) position with upward progression. The filler metal electrode appeared to be LB-52A, ER7016 AWS designation A5.1, 4 mm diameter. The welding was performed per the AWS D1.5, 2002 Section 5.13 requirements. The Intertek QC inspectors, Mr. Makhmud Ashadi and Mr. Chung Kuan recorded the preheat and interpass temperatures, the average amperage, voltage and the travel speed for all weld passes. The QA inspector observed that the welder Mr. Kouzou Kabayashi ground each weld pass to smooth bright finish prior to starting the next weld pass. The welding of this plate was not completed on this date. The QA inspector noted that the welding appeared to meet the minimum requirements of AWS D1.5-2002 and the contract documents.

On this date the QA representative Joe Lanz arrived at Japan Steel Works (JSW) of Muroran Japan and traveled to Machine shop number 2 at 1400 hours escorted by JSW representative Mr. Koji Kanazawa. The QA inspector observed the Tower saddle casting designated T1-2 was in process of rough milling end the faces on a horizontal mill. Both end faces had been milled to a rough dimension approximately 10 mm greater than the final dimension. At the time of the QA inspector's observation, two JSW personnel were performing a dimensional check of the milled end surfaces. See the digital images below for further detail. No work was performed at the time of

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inspection.



Summary of Conversations:

No relevant conversations on this date.

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:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Brasel,Ron	QA Reviewer
