

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-002221**Date Inspected:** 18-Apr-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:** Muroran, Japan**CWI Name:** Rory O'Kane**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:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date OSM Quality Assurance Representative Daniel L. Reyes observed the welding of the Procedure Qualification Record (PQR) Test and the inspection relative to this project. The following was observed:

Procedure Qualification Test Plate-SW-7-1

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-7-1. The welding was performed by Japan Steel Works, Ltd. welding personnel Kouzou Kobayashi ID 08-5023 with the 50 millimeter thick test plate placed in the flat (1G) position. Mr. Kobayashi utilized the Shielded Metal Arc Welding (SMAW) as per the Welding Procedure Specification (WPS) SJ-2942 WP-10 which was also used by the Quality Control (QC) Inspector Rory O'Kane as a reference. The consumable utilized during the welding of the test plate was identified as a Hobart Electrode (Hoballoy) LB-52A with a diameter size of 5.0 millimeters which appears to comply with the AWS A5.1 specification and the E7016 classification.

The QC inspector Mr. O'Kane verified the minimum preheat temperature of 110 degrees Celsius and at the conclusion of verifying the surface temperature the welder Mr. Kouzou continued the welding of the fill passes. At this time this QA inspector observed the QC inspector verifying the amperage, voltage and travel speed. The average welding parameters were observed by this QA inspector as follows; 255 amps, 25.0 volts with a travel speed measured at 158 mm/m.

Later in the shift this QA inspector observed, at random intervals, the QC inspector Rory O'Kane performing the in process weld inspection and verifying the minimum preheat and maximum interpass temperatures during the welding of the weld layers numbers 15 through 33. The welding of the Test Plate identified as SW-7-1 was not completed during this shift on this date and appeared to comply with the WPS.

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Foundry Shop-QC Magnetic Particle Testing

At approximately 13:00 hours this QA inspector was notified by Yoshihiro Itoh, via telephone message, that the non-destructive testing that was scheduled on this date had been suspended to do the fact that the grinding of the linear indications was not completed and the testing has been rescheduled for Monday, April 21, 2008.

The following digital photographs illustrate observations of the activities performed on this date.



Summary of Conversations:

There were general conversations with Japan Steel Works, Ltd. (JSW) Department Manager Planning and Administration Group (Casting Engineer) Casting Department Yoshihiro Itoh and Bridge Group Steel Products Department personnel Kunio Nagaya regarding the location of welding and inspection 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:	Lanz, Joe	QA Reviewer
