

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-002328**Date Inspected:** 25-Feb-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:	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		

Summary of Items Observed:

PQR welding test SJ-2942-WP-1 (test plate SW-1)

Caltrans Quality Assurance Inspector (QAI) representative, Mr. Wai Pau witnesses an AWS D1.5 standard PQR qualification welding test. The number of PQR qualification welding test is SJ-2942-WP-1 (test plate SW-1). The PQR qualification test utilizing Flux Cored Arc Welding (FCAW) welding processes were conducted by welder Mr. Tatuyu Naitoh (71-2736) performed in the flat position (1G). The material used for the PQR qualification test specimens was reported by JSW Welding Engineer Mr. Takaaki Maruya as ASTM A 709M-HPS-485WT and A148M-Gr.620-415 plate to casting having a wall thickness measurement of 50mm. The weld joint design used butt joint, single-V-groove weld with 20mm x 75mm backing bar. The proper filler metal and shield gas used in the test for FCAW is Hoballoy 9018-M with 5mm diameter electrode and TM-95K2, 1.6 diameter with 100% C02 made by Hobart Brothers, USA. The welder performed the FCAW welding process and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan, Mr. MaKhmud Ashadi and JSW Welding Engineer Mr. Takaaki Maruya, also observed by Caltrans QAI. A total of twenty interior filler weld passes were completed on this date. The preheat temperature of the test plate is to be held at 120 C overnight for the continuation of the welding at tomorrow. Based on Caltrans QA observation, no discrepancies were noted.

Summary of Conversations:

As Note within the report above.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Pau, Wai	Quality Assurance Inspector
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Reviewed By:	Brasel, Ron	QA Reviewer
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