

**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-002384**Date Inspected:** 04-Apr-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:** 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:** welder qualification welding test**Summary of Items Observed:**

Witnessing AWS D1.5 standard SMAW welder qualification welding test: Caltrans QAI representative Mr. Wai Pau witnessed a welder qualification test. The qualification welding tests utilizing the Shielded Metal Arc Welding (SMAW) process were conducted by welders performed in the vertical position (3G). The names of welder for SMAW test are Mr. Makoto Kato (08-5018), Mr. Naoki Murai (97-2118) and Masashi Inoue (69-3227). The material used for the welder qualification test specimens was reported by JSW Welding Engineer Mr. Jomio Imai as ASTM a 709M-HPS-485WT plate having a wall thickness measurement of 25mm. The weld joint design used butt joint, single-V-groove weld with 25mm backing bar. The proper filler metal used in the test for SMAW is Hoballoy 9018-M with 5mm diameter electrode made by Hobart Brothers, USA. The SMAW welding process and parameters have been monitored and recorded by CWI inspectors Mr. MaKhmud Ashadi. Based on Caltrans QA observation, the welder qualification tests appeared to be in general compliance with requirements of AWS D1.5 2002 Section 5 and Caltrans contract documents. A Caltrans Lot# B88-090-08, B88-091-08 and B88-092-08 were assigned on this welder test for tracking propose.

Witnessing AWS D1.5 standard FCAW welder qualification welding test: Caltrans QAI representative Mr. Wai Pau witnessed a welder qualification test. The qualification welding tests utilizing the Flux Cored Arc Welding (FCAW) welding processes were conducted by welders performed in the flat position (1G). The names of welder for FCAW test are Mr. Makoto Kato (08-5018), Masashi Inoue (69-3227) and Mr. Masao Yamashita (73-4195). The material used for the welder qualification test specimens was reported by JSW Welding Engineer Mr. Jomio Imai as ASTM a 709M-HPS-485WT plate having a wall thickness measurement of 25mm. The weld joint design used butt joint, single-V-groove weld with 25mm backing bar. The filler metal and shield gas used in the test for FCAW is Hoballoy wire TM-95K2, 1.6 diameter with 100% CO2 made by Hobart Brothers, USA. The FCAW welding process and parameters have been monitored and recorded by CWI inspectors Mr. MaKhmud Ashadi.

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# WELDING INSPECTION REPORT

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Based on Caltrans QA observation, the welder qualification tests appeared to be in general compliance with requirements of AWS D1.5 2002 Section 5 and Caltrans contract documents. A Caltrans Lot# B88-093-08, B88-094-08 and B89-092-08 were assigned on this welder test for tracking propose.

**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.

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

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