

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002386**Date Inspected:** 09-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 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 was conducted by welder performed in the flat position (1G). The names of welder for FCAW test is Mr. Minoru Matudate (08-5151), Toshiyuki Watanabe (08-5153) and Masatugu Kovayashi (08-5154). 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. 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# B88-106-08, B88-107-08 and B88-108-08 were assigned on this welder test for tracking propose.

Bend test for welder qualification test:

QAI representative, Mr. Wai Pau witness side bent tests for four welders SMAW 3G position and FCAW 1G position qualification test. Two bend test specimens are requiring for each welder of each welding process qualification test. The names of welders are Mr. Masao Yamashita (73-4195), Mr. Makoto Kato (08-5018), Mr. Naoki Murai (97-2118) and Mr. Masashi Inoue (69-3227). The bend tests were recorded and accepted by NIS foramen Mr. Hideo Domon. Base on Caltrans observation, the bend testing operation and results appeared to be general compliance with requirements of AWS D1.5 section 5. A Caltrans Lot# B88-098-08 thru B88-104-08 were assigned on the results of those side bend tests for tracking propose.

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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.

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