

**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-002389**Date Inspected:** 14-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:****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:** chemical analysis**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau observe JSW NDT technician performed a non-destructive chemical analysis on the unidentified ASTM 709M-HPS-485WT material plate with x-ray fluorescence (XRF) instrument. The XRF instrument used on test by JSW is Innov-X system model 2000AS, SN# 5687 made by Innovative XRF Techniques Japan. However, this XRF instrument only detects five chemical elements Cr, Ni, Fe, Ni and Cu. A total thirty plates have been analyzed and those plates will be use for west deviation saddle W2-E1 and W2-E2. Caltrans QAI also witness JSW cutting five samples form residual plates heat number 010003-2, 010302-2, 338343-2, 338494-1 and 338494-2 for wet chemical test.

The below list is for the XRF test:

HT# 010264-2\_\_100mm Thick\_\_Plate #1-2

HT# 010266-1\_\_120mm Thick\_\_Plate #1-3

HT# 010003-1\_\_110mm Thick\_\_Plate #1-4

HT# 010264-1\_\_100mm Thick\_\_Plate #1-5 &amp; 1-6

HT# 338494-1\_\_080mm Thick\_\_Plate #1-7, 1-8, 1-13, 1-14, 2-7, 2-8, 2-13 &amp; 2-14

HT# 338494-2\_\_080mm Thick\_\_Plate #1-9, 1-10, 1-11, 1-12, 2-9, 2-10, 2-11 &amp; 2-12

HT# 010302-1\_\_080mm Thick\_\_Plate #1-15, 2-5, 2-6, 2-15 &amp; 2-16.

HT# 010302-2\_\_080mm Thick\_\_Plate #1-16

HT# 016265-1\_\_080mm Thick\_\_Plate #2-2

HT# 010002-1\_\_120mm Thick\_\_Plate #2-3

HT# 010000-1\_\_120mm Thick\_\_Plate #2-4

**Summary of Conversations:**

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# WELDING INSPECTION REPORT

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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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