

**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-002391**Date Inspected:** 16-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**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:** Reviewing radiographic films**Summary of Items Observed:**

Reviewing radiographic testing (RT) film result: Caltrans Quality Assurance Inspector (QAI) representative, Mr. Wai Pau traveled to Nikko Inspection Service (NIS) office, to review radiographic testing (RT) films result of AWS standard PQR welding test #SJ-2942-WP-7 (test plate SW5-1) and #SJ-2942-WP-8 (test plate SW5-2). Three radiographic films used for each PQR qualification test, the qualification testing include before Post Weld Heat Treatment (PWHT) and after PWHT. The source of radiation for film used is ML-5RII (4 Mev Linac type) made by Mitsubishi electric Corporation and performed by NIS radiographer Level II Mr. Osamu Nitami. The radiograph film used is type Fuji #50, size 178mm x 432mm with wire type Image Quality Indicators (IQI) ASTM 1B. All the films also evaluated and accepted by NIS interpreter Level II Mr. Masanobu Nakajima prior Caltrans QAI reviewing. Based on Caltrans QA reviewing, all the films quality standard and weldments quality standard of two PQR radiograph results in appeared to be in general compliance with requirements of the Caltrans Special Provisions and AWS D1.5 2002 Section 6.

**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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# WELDING INSPECTION REPORT

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