

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-002397**Date Inspected:** 29-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Japan Steel Works**Location:** Muroran, Japan

CWI Name:	Mr. Chung Kuan		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** PQR qualification welding test**Summary of Items Observed:**

Witness Procedure Qualification Record (PQR) qualification test (test plate SW-7-2): Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau, travel to Japan Steel Works (JSW) Muroran plant to witness an AWS D1.5 standard PQR qualification welding test. The number of PQR qualification welding test is SJ-2942-WP-11 (test plate SW-7-2). The PQR qualification test utilizing Shielded Metal Arc Welding (SMAW) was conducted by welder Mr. Kouzou Kobayashi (08-5023) performed in the vertical position (3G). The material used for the PQR qualification test specimens was reported by JSW Welding Engineer Mr. Takaaki Maruya as A148M-Gr.550-345 and ASTM A709-Gr.345T (casting to plate) 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 filler metal used in the test is TB52A with 4mm diameter electrode, made by Kobelco Japan. The SMAW welding and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan, Mr. MaKhud Ashadi and JSW Welding Engineer Mr. Takaaki Maruya, and were also observed by Caltrans QAI. A total of eight interior filler weld passes (#42 to #49) were completed on this date and the PQR welding for this plate has been completed. Based on Caltrans QA observation, The PQR welding test was appeared to be in general compliance with the requirements of AWS D1.5 2002 and Caltrans contract document. The PQR will schedule to radiographic testing (RT) test.

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

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