

**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-002655**Date Inspected:** 20-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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:** Tower, Jacking and Deviation Saddle**Summary of Items Observed:**

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan.

Current work: Casting, machining and nondestructive testing of Saddles.

Number 4 Fabrication shop:

At 1300 hours, the QA inspector, Mr. Dong J, Shin, went to JSW fabrication shop number 4 and observed a procedure qualification test designated GJ6-3402 SW-6 performed by JWS welding personnel Mr. Kouzou Kabayashi utilizing gas shielded flux cored arc welding in the flat position. The QC inspector, Mr. Makhmud Ashadi monitored the in process welding and verified the welding parameters, preheat and interpass temperatures with QA representative Mr. Dong J, Shin monitoring activities at this location. The test was completed on this date and test results were not in compliance with special provision 8-3.01 for welding.

**Summary of Conversations:**

Discussed with Mr. Makhmud Ashadi regarding special provision requirement for welding travel speed variations of 10 percent.

**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) 967-6363, 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>	Shin,DJ	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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