

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002677**Date Inspected:** 13-May-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, Ltd.**Location:** Muroran, Japan

CWI Name:	Tomio Imai and Motoi Hidaka	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 Saddles	

Summary of Items Observed:

On this date OSM Quality Assurance (QA) Representative Daniel L. Reyes observed the following activities relative to this project. The following was observed:

Foundry Shop

At the start of the shift, this QA inspector was escorted to the Foundry Shop by Japan Steel Works, Ltd. (JSW) personnel, Kunio Hagaya to observe the continued repair welding of the rib build-up areas identified as 2-2 grid B-9 and 3-10 grid B-9 on the West Deviation Saddle Casting identified as W2E1. The QA inspector observed the welding performed by JSW welding personnel Noritake-Tamura ID 93-2337 and Kazuya-Komai ID 06-8002 and the in process weld inspection performed by QC inspector Tomio Imai and Motoi-Hidaka. The welding was performed by JSW welding personnel utilizing the Welding Procedure Specification (WPS) identified as SJ-3026-2 which was also used by the QC inspectors as a reference.

Later during this shift this QA inspector, at random intervals, observed the QC inspectors perform QC verification of the welding parameters, minimum and maximum surface temperatures and performing the visual weld inspection.

QA Observation Summary

This QA inspector randomly observed the in process Shielded Metal Arc Welding (SMAW) for the repair welding of the ribs on the West Deviation Saddles identified as W2E1. This QA inspector noted that it appeared the approved and latest revised WPS's were posted at the appropriate welding station and that each approved welder was entered in the latest revised Welding Personnel Log issued by Japan Steel Works, Ltd. The welding

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

parameters, preheat and interpass temperatures were verified as noted by this QA inspector utilizing a Fluke 337 clamp meter for the electrical welding parameters and Tempilstik temperature indicators for preheat and interpass temperatures. The filler metal utilized at the welding stations was also verified. The QC inspectors, Tomio Imai and Motoi-Hidaka appeared to perform the visual examinations and monitoring of the welding per the contract documents. The welding and inspection was not completed during this shift and appeared to be in general compliance with the contract documents.

The calibration dates of the measuring instruments utilized by the QC inspectors, the clamp amp/volt meter and the digital surface thermometer, were previously verified by this QA inspector.

See Weld Joints in Progress Inspected, below, in regards to QA observation of the welding parameters recorded during this shift on this date.

The following digital photographs illustrate the observations of the activities performed on this date.



Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	W2E1-Rib 1L, 3-10	SJ-3026-2	T. Imai	208	24	171mm/m	160 Degrees C.	Kozuya
2	W2E1-Rib 8L, 2-2	SJ-3026-2	T. Imai	211	23	176mm/m	160 Degrees C.	Noritake

Summary of Conversations:

There were no pertinent conversations relative to this project on this date.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Reyes,Danny

Quality Assurance Inspector

Reviewed By: Lanz,Joe

QA Reviewer