

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002846**Date Inspected:** 03-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 830**Contractor:** Japan Steel Works, Ltd.**Location:** Muroran, Japan

CWI Name:	N/A	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 was present during the repair welding of the Saddle Casting. The following was observed:

At the start of the shift the QA inspector observed the Japan Steel Works, Ltd. (JSW) Shop Welding Supervisor, Motoi-Hidaka verify the welding parameters for the welder Kazuya-Komai, ID 06-2008. At the conclusion of the verification, the welder commence the repair welding on the Rib 2L for the casting identified as the West Deviation Saddle, W2E1 repair area 3-8.

The QA inspector verified the preheat temperature of 200 degrees Celsius and the maximum interpass temperature of 240 degrees Celsius. At the conclusion of verifying the surface temperatures, the QA inspector verified the Alternate Current (AC) welding parameters and was observed as follows; 210 AC amps and 23.5 AC volts with a travel speed measured at 143.2 millimeters per minute (mm/m).

The welder utilized the self Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specification (WPS) SJ-3026-2 which was also used by the QA inspector and Motoi-Hidaka as a reference during verification of the welding parameters. The consumable was a 5.0 millimeter diameter electrode and appeared to be a Hobart Brothers product identified as LB-106. The electrode appeared to comply with the AWS Specification A5.5 and the AWS Classification E10016-G

The repair welding was performed in the horizontal (2G) position with the work in the vertical plane and the axis of the weld horizontal. The West Deviation Saddle was located in the Foundry Shop at Lane Number 1 at the designated area identified as, "The Gouging and Grinding Area."

Later in the shift, at periodic intervals the QA inspector verified the minimum preheat temperatures and the

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maximum interpass temperatures, the AC welding parameters and observed the in process repair welding. The QA inspector also observed, periodically the Shop Welding Supervisor Motoi-Hidaka verify the welding parameters.

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



Summary of Conversations:

There were no 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.

Inspected By: Reyes, Danny

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer