

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-002938**Date Inspected:** 05-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		
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

Component: Tower, Jacking and Deviation Saddles

Bridge No: 34-0006**Summary of Items Observed:**

On this date OSM Quality Assurance (QA) Representative Daniel L. Reyes observed the repair welding on the saddle casting scheduled on this date. The following was observed:

Foundry Shop

At the start of the shift the QA inspector traveled to the Foundry Shop to observe the scheduled repair welding build-up of the casting ribs performed on the West Deviation Saddle identified as W2E1. Upon the QA inspector's arrival at the work station located in Lane 1 and the designated area identified as, "The Gouging and Grinding Area," this QA inspector commence review of the Daily Production Log Book located at the work station. At the conclusion of the QA inspector's review of the recorded contents of the Daily Production Log Book it appeared that recorded documentation complies with the contract documents. The recorded documentation contained in the Daily Production Log Book was observed as follows, the amperage, voltage and travel speed for each individual weld pass and this information was recorded by the welder performing the repair welding. The QA inspector also observed that the actual preheat and interpass temperatures were also recorded in the Daily Production Log Book.

Shortly thereafter, the QA inspector observed the welding operation performed by the Japan Steel Works, Ltd. (JSW) welding personnel, Kazuya-Komai ID 06-2008. The welder performed the welding utilizing the Welding Procedure Specification (WPS) SJ-3026-2. The WPS was also used by the QA inspector as a reference during the verification of the welding parameters.

The consumable used during the repair welding appeared to be a Hobart Brothers Product, LB-106 and appeared to comply with the AWS Specification A5.5 and the AWS Classification E10016-G.

At the conclusion of verifying the preheat temperatures and the interpass temperatures, which measured

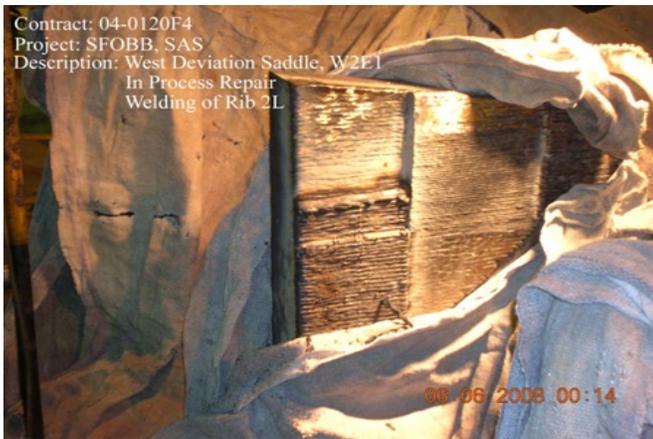
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accordingly, 201 degrees Celsius and 230 degrees Celsius. The QA inspector verified the Alternate Current (AC) welding parameters and were observed as follows; 201 amps and 23.5 volts with a travel speed measured at 146.7 Millimeters Per Minute (MM/M).

Later in the shift, the QA inspector observed the JSW Shop Welding Supervisor, Motoi-Hidaka verify the welding parameters for the welder Kazuya-Komai at periodical intervals. At the conclusion of the welding parameter verification the welder resumed the repair build-up welding of the Rib identified as 2L. The calibration dates of the measuring instruments utilized by the Shop Welding Supervisor, the clamp amp/volt meter and the digital surface thermometer, were previously verified by this QA inspector.

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



Summary of Conversations:

There were no general 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
