

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-002987**Date Inspected:** 19-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:** 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 Saddles**Summary of Items Observed:**

On this date OSM Quality Assurance (QA) Representative Daniel L. Reyes observed the build-up repair welding and the welding of the structural steel plate components on the West Deviation Saddle and Saddle Casting scheduled on this date. The following was observed:

Fabrication Shop # 4

At the start of the C-shift the QA inspector traveled to the Fabrication Shop # 4 to observe the continued Partial Joint Penetration (PJP) groove welding of the structural steel plate components for the West Deviation Saddle identified as W2E1. The Welding Procedure Specification (WPS) SJ-3011-1 was utilized by the Japan Steel Works, Ltd. (JSW) personnel during the performance of the production welding of the base plate to stem plate connection and was also used as a reference during QC verification.

The gas shielded Flux Cored Arc Welding (FCAW) was performed by JSW welding personnel Yuichi-Arai ID 08-5157 and Satoru-Watanabe ID 08-5159 and Makoto Kato ID 08-5016. The consumable utilized by the welding personnel appeared to be a Hobart Brothers Product and identified with the trade name TM 95K2 which appeared to comply with the AWS Specification A5.29 and the AWS Classification E90TS-K2C H4. The size of the electrode was 1.6 mm in diameter.

The Quality Control (QC) inspection was performed by Intertek Testing Services personnel Makhmud Ashadi. The QC inspector verified the preheat temperatures, the Alternating Current (AC) welding parameters and performed the in process weld inspection during this shift. The welding parameters were verified utilizing a Hioki 3109 Clamp Meter, Model RMS and the surfaces temperatures were verified utilizing an Anritsu HA 100E digital surface thermometer during the QC verification. The calibration dates of the measuring instruments utilized by the QC inspector were previously verified by this QA inspector.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The welding, inspection and verification were performed on the weld joint identified as E1S-2L. The welding was performed in the Flat Position (1G) with the work in the horizontal plane and the weld metal deposited from above.

The QA inspector's observations were performed at random intervals during the shift. The QA inspector noted that it appeared the approved and latest revised WPS's were posted at the welding station and that each approved welder was entered in the latest revised Welding Personnel Log issued by Japan Steel Works, Ltd. The welding parameters, preheat and interpass temperatures were verified by the QA inspector utilizing a Fluke 337 clamp meter for the electrical welding parameters and Tempilstik temperature indicators for the surface temperatures. The filler metal utilized by the JSW welding personnel was also verified. The QC inspector ITS personnel, Mukhmud Ashadi appeared to perform the visual weld examinations, monitoring of the welding and the verification of the welding parameters in accordance with the contract documents.

Foundry Shop

At approximately 02:00 hours of the shift the QA inspector traveled to the Foundry Shop to observe the repair welding on the saddle casting scheduled on this date. The welding was performed utilizing the Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specification (WPS) SJ-3026-2 which was also used by the QA inspector as a reference during verification of the welding parameters. The welding was performed by JSW welding personnel, Kazuya-Komai ID 06-8002 and Yoshito-Kabutomori which was conducted on the West Deviation Saddle Casting identified as W2E1 and was performed in the horizontal (2G) position with the work in the vertical plane and the axis of the weld horizontal. The repair welding was conducted on the rib castings identified as 2U and 4U.

The consumable appeared to be identified as LB-106, a product of Hobart Brothers which appeared to comply with the AWS Specification A5.5 and the AWS Classification E10016-G. The size of the electrode appeared to be 5.0 millimeters in diameter.

The QA inspector verified the preheat temperatures, the interpass temperatures and the Alternating Current (AC) welding parameters at random intervals during this shift.

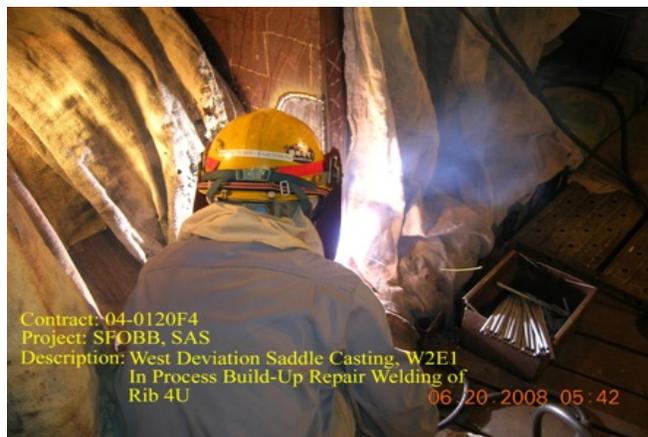
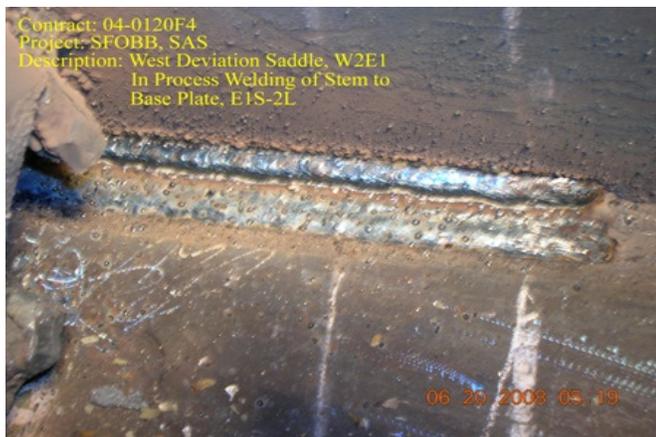
This QA inspector randomly observed the in process Shielded Metal Arc Welding (SMAW) for the repair welding of the ribs on the West Deviation Saddle Casting identified as W2E1. This QA inspector noted that it appeared the approved and latest revised WPS's were posted at the appropriate welding station and that each approved welder was entered in the latest revised Welding Personnel Log issued by Japan Steel Works, Ltd. The welding 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 welding was not completed during this shift and appeared to be in general compliance with the contract documents.

See Weld Joints in Progress Inspected on Page 3 of 3 of this report regarding to the QA observation of the welding parameters recorded during this shift on this date.

The following digital photographs on Page 3 of 3 of this report illustrate the observations of the activities performed on this date.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	W2E1, Rib 4U, Area (3-1)	SJ-3026-2	N/A	215 AC	24.0 AC	172 mm/m	150-260 Degrees C.	Y.-Kabutomori
2	W2E1, Rib 2U, Area (3-6)	SJ-3026-2	N/A	208 AC	23.0 AC	160 mm/m	150-260 Degrees C.	Kazuya-Komai
3	W2E1, EIS-2L	SJ-3011-1	M. Ashadi	333 DC	36.0 DC	295 mm/m	160-218 Degrees C.	Makoto Kato
4	W2E1, EIS-2L	SJ-3011-1	M. Ashadi	335 DC	35.0 DC	291 mm/m	160-218 Degrees C.	Satoru-Watanabe
5	W2E1, EIS-2L	SJ-3011-1	M. Ashadi	330 DC	34.0 DC	297 mm/m	160-218 Degrees C.	Yuichi-Arai

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