

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-003176**Date Inspected:** 03-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Japan Steel Works**Location:** Muroan, Japan**CWI Name:** Kuan Chung**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 Muroan Japan. Current work: Casting, machining and repair of Saddles.

PQR Witness

The Caltrans Quality Assurance (QA) inspector Mr. Dong J, Shin arrived at JSW fabrication shop number 4 and observed a welding procedure qualification test designated SJ6-2942 WP-15, SW10-1 and SW10-2 performed by JWS welding personnel Mr. K. Kobayashi, (08-5023). The welding was performed utilizing the Shield Metal Arc Welding Process in the Flat(1F ,SW-10-1) and Horizontal(2F, SW-10-2) positions. The filler metal for the Shield Metal Arc Welding electrode appeared to be E9018M H4R, AWS designation A5.5(96), 4.0 mm diameter. The welding was performed per AWS D1.5, 2002 Section 5.10.3 and Figure 5.8 requirements. The Intertek QC inspector, Mr. Kuan Chung checked welding parameter and recorded the preheat and interpass temperatures, the average amperage, voltage and the travel speed for all weld passes. The QA inspector observed that the welder Mr. K. Kobayashi ground clean each weld pass to smooth bright finish prior to starting the next weld pass. The welding of this plate was completed on this date. The QA inspector noted that the welding appeared to meet the minimum requirements of AWS D1.5-2002 and the contract documents. See detail information in PMIV Report TL-6032 dated 07-03-2008.

Summary of Conversations:

No specific conversations.

Comments

WELDING INSPECTION REPORT

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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:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
