DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-003393
Date Inspected: 07-Aug-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 1000
OSM Departure Time: 1800
Location: Muroran, Japan

CWI Name: Makhmud Ashadi

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ 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 Muroran Japan. Current work: Casting, machining and repair of Saddles.

At 1000 hours, the Caltrans Quality Assurance (QA) inspector arrived at JSW fabrication shop number 4 and observed a welding procedure qualification test designated GJ6-3402 SW-3-2 performed by JWS welding personnel Mr. K. Kobayashi and Mr. N. Murai. The welding was performed utilizing the Flux Core Arc Welding Process in the Flat (1F), position. The filler metal appeared to be TM-55, E-70T-5MJ H4 AWS designation A5.29, 1.6mm diameter with dual shield. The welding was performed per the AWS D1.5, 2002 Section 5.10.3 and Figure 5.8 requirements. The Intertek QC inspector, Mr. Makhmud Ashadi checked welding parameter and recorded the preheat Temperature was over 160C and interpass Temperatures Max 260C, the average amperage of 270, voltage of 27, gas flow rate was 25liters/min and the average travel speed was 314mm/min. The QA inspector observed that the both welders ground each weld pass to smooth bright finish prior to starting the next weld pass. The welding of these plates 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.

Summary of Conversations:

No specific conversations.

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

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