

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-003990**Date Inspected:** 25-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Japan Steel Works**Location:** Muroran, 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 Muroran Japan. Current work: Casting, machining and repair of Saddles.

PQR WITNESS

At 1300 hours, the Caltrans Quality Assurance (QA) inspector arrived at JSW fabrication shop number 4 and observed a procedure qualification test designated SJ-2942 WP-16 performed by JWS welding personnel Mr. K. Kobayashi. The welding was performed utilizing the Shield Metal Arc Welding and Flux Core Arc welding Process in the Flat (1G) position. The SMAW filler metal appeared to be Hoballoy, E9018-M H4R, AWS designation A5.5, 4.0 mm diameter and FCAW filler metal appeared to be TM 95K2 E90T5-K2C H4, AWS designation A5.29. The test plate thickness was 110mm (30% for SMAW and 70% for FCAW). The welding was performed per the AWS D1.5, 2002 Section 5.7. 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 cleaning each weld pass to smooth bright finish prior to starting the next weld pass. The welding of this plate was not 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.

WQT WITNESS

QA Inspector observed a welder qualification test with SJ-2983 WP-1 performed by JWS welding personnel Mr. K. Shimosawa, ID 02-2889. The welding was performed utilizing the Flux Core Arc Welding Process in the Horizontal (2G) position. The filler metal Flux Core Wire appears to be TM-55, E70T-SMJH4, AWS A5.29. The

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welding was performed as per the AWS D1.5, 2002 Section 5.23 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 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.

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.

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