

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-003994**Date Inspected:** 25-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Japan Steel Works**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, Deviation and Jacking Saddles**Summary of Items Observed:**

On this date OSM Quality Assurance (QA) Representative Daniel L. Reyes was present during the welding of the procedure qualification record test plate relative to this project. The following was observed:

Fabrication Shop # 4

The QA inspector traveled the fabrication shop to observe the continued welding of the Procedure Qualification Record (PQR) Test Plate identified as SW-11-1. The welding of the PQR test plate was performed by Japan Steel Works, Ltd. (JSW) personnel Kubota Mamoru ID 74-3666 utilizing the gas shielded Flux Cored Arc Welding (FCAW-G) process as per the Welding Procedure Specification (WPS) SJ-2942 WP-16.

The consumable utilized appeared to be a Hobart Brothers Product and the trade name was identified as Tri-Mark 95K2 which appeared to comply with the AWS Specification A5.29 and the AWS Classification E90T5-K2C H4. The size of the electrode was 1.6 mm in diameter.

The Quality Control (QC) Inspector, Makhmud Ashadi verified the Direct Current Electrode Positive (DCEP) welding parameters and was observed as follows, 295 amps and 31 volts with a travel speed measured at 257mm/m. The surface temperatures was also verified by the QC inspector and were noted as follows, 195 Celsius. The verification task was performed utilizing a Hioki 3109 Clamp Meter, Model RMS and the surfaces temperatures were verified utilizing an Anritsu HA 100E digital surface thermometer.

The digital photograph on page 2 of this report illustrates the observations of the activities performed on this date.

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Summary of Conversations:

There were no pertinent conversations relative to the 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
