

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 #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004479**Date Inspected:** 14-Oct-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.

FOUNDRY SHOP

On this date the QA representative Dong J. Shin arrived at Japan Steel Works (JSW) of Muroran Japan and traveled to JSW foundry and observed build up welding on the West Deviation Saddle casting W2-E2. The welding was performed to build up the thickness of the ribs in areas that were found to not meet the minimum thickness of the contract special provisions. The repair locations and repair details for this casting were submitted as number 000643, revision 02. The JSW welding personnel, Mr. Y. Kabutomori continued the in process build up welding of Rib8U, repair B-B, location B-3 utilizing the Shielded Metal Arc Welding (SMAW) process per the welding procedure specification (WPS) SJ 3026-2. The welding was performed in the 2G (Horizontal) position. The filler metal utilized was identified as 5mm diameter, Class E10016-G, Brand name LB-106. The minimum preheat temperature of 160 degrees Celsius and maximum interpass temperature of 260 degrees Celsius was verified to meet the WPS requirements by Mr. Kabutomori. The SMAW welding average amperage and voltage by clamp type meter and travel speed were verified to be within the welding procedure specification parameter range of 180 amps to 240 amps, 22 volts to 26 volts and travel speed of 115 to 280 mm per minute by the QA inspector. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

NDT Inspection (Foundry Shop)

The QA inspector periodically observed The Nikko Inspection Services (NIS) QC/NDT technicians Mr. Yatsunori

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Narita and Mr. Atsusi Seino perform magnetic particle (MT) testing of tower jacking saddle after PWHT. The MT was performed in accordance with ASTM standard E709, using the yoke method. The yokes utilized appeared to be model VM3. The yoke dead lift was verified with a 4.65kg test plate. The magnetic field was verified with a field indicating gauge (pie gauge) utilizing red dry powder. All calibrations appear to meet the minimum requirements of ASTM E709. The testing was evaluated in accordance with the contract special provisions. The testing was not completed on this date.

FABRICATION SHOP # 4

Mr. K. Kobayashi and Mr. K. Nakasato performed welding on multiple root pass welds on E1Y-4V1 and E1Y-4V rib plate to rib plate and rib plate to stem plate of W2E1 casting to steel structure. The root pass welding (SMAW) process per the welding procedure specification (WPS) SJ-3011-5 and SJ 3011-6. The welding was performed in the 2G (Horizontal) and 3G (vertical up) positions. A NISC technician performed Magnetic Particle testing on first single root pass. The filler metal utilized was identified as 4.0mm diameter, Class E9018-M-H4R, Brand name Hoballoy 9018-M. The welding parameters and heat control were monitored by Intertek Testing Services Quality Control (QC) inspector Mr. Chung-Fu Kuan at periodic intervals. The minimum preheat temperature of 160 degrees Celsius and maximum interpass temperature of 260 degrees Celsius was verified to meet the WPS requirements by Mr. Kuan and the QA inspector utilizing Tempilstik temperature indicators. This data was entered into the QC inspector's daily log, identifying the location on a weld map. The SMAW welding average amperage and voltage by clamp type meter and travel speed were verified to be within the welding procedure specification parameter range of 195amps to 200 amps, 23 volts to 24 volts and travel speed of 132 to 168 mm per minute for the 4.8mm electrode and 145 amps to 165 amps, 21 volts to 24 volts and travel speed of 72 to 97 mm per minute for the 4.0mm electrode by the QA inspector. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and 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
