

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-004486**Date Inspected:** 23-Oct-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 900**OSM Departure Time:** 1900**Location:** Muroan, 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, 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.

FABRICATION SHOP # 4

On this date the Caltrans Quality Assurance (QA) inspector, Dong J, Shin arrived at JSW fabrication shop number 4 and observed the in process assembly fit-up operation of the structural steel plates for the Tower Jacking Saddle base T1-2. The JSW fitter personnel Kiyotaka Koanagi began assembly of the Tower Jacking Saddle base T1-2 by aligning the stem plate to the rib plate, joint designation 8Y-12V. The JSW welding personnel Y. Otha, performed the in process tack welding utilizing the Shielded Metal Arc Welding (SMAW) process per the welding procedure specification (WPS) SJ-3011-1. The welding parameters and heat control were monitored by Intertek Testing Services Quality Control (QC) inspector Mr. Ashadi 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. Ashadi 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.

Mr. M. Kato, Mr. T. Kawakami and Mr. K. Sadakawa performed welding on E1Y-16V, and E1Y-17V rib plate to rib plate and rib plate to stem plate of W2E1 casting to steel structure. The fill pass welding (FCAW) process per the welding procedure specification (WPS) SJ-3011-5 and SJ 3011-6. The welding was performed in the 2G (Horizontal) position. The filler metal utilized was identified as 1.6mm diameter, Class E90T5-K2C H4, Brand name TM 95K2. The welding parameters and heat control were monitored by Intertek Testing Services Quality Control (QC) inspector Mr. Ashadi at periodic intervals. The minimum preheat temperature of 160 degrees

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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 325amps to 350 amps, 35 volts to 38 volts and travel speed of 255 to 310 mm per minute for the 1.6mm Wire. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

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, QA Inspector observed the build up welding on 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 Rib7U, repair C-C, location C-6 build up weld 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. 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.

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
