

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-005162**Date Inspected:** 09-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Kuan**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 Saddles**Summary of Items Observed:**

Steel Structure Welding Shop:

T1-1 Tower Saddle Casting and Steel Structure joint section: Caltrans Quality Assurance Inspector (QAI) representative observed three Japan Steel Works (JSW) welders perform Flux Cored Arc Welding (FCAW) process on rib plate welds 7S-5U-1, 7S-5U-2 and 7S-5U-3 of T1-1 tower. These three welds are connecting the casting and steel structure. The three welders started welding from after root pass to 70% weld metal complete. The filler metal used for FCAW is Hoballoy wire TM-55, 1.6 diameter made by Hobart Brothers, USA. The parameters used for FCAW welding of assemblies were conducted in accordance with Caltrans approved WPS #SJ-3011-6. The FCAW welding process and parameters have been monitored and recorded by CWI inspector Mr. Chung Kuan. Based on Caltrans QA observation, the FCAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

W2E2 West Deviation Saddle Casting and Steel Structure joint section: Caltrans QA Inspector representative observed two JSW welders perform fit up of the W2E2 west deviation saddle casting and steel structure joint section. The gap and alignment of rib plates and stem plates appear to meet the requirement of approved drawing. The JSW Welding Engineer Mr. Nagaya informed Caltrans QA Inspector that joint section will move to welding station for permanent fit up and production welding next week. Based on Caltrans observation, no discrepancies were noted.

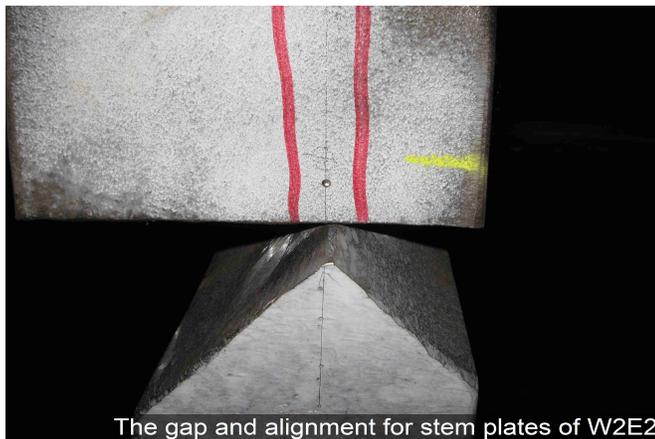
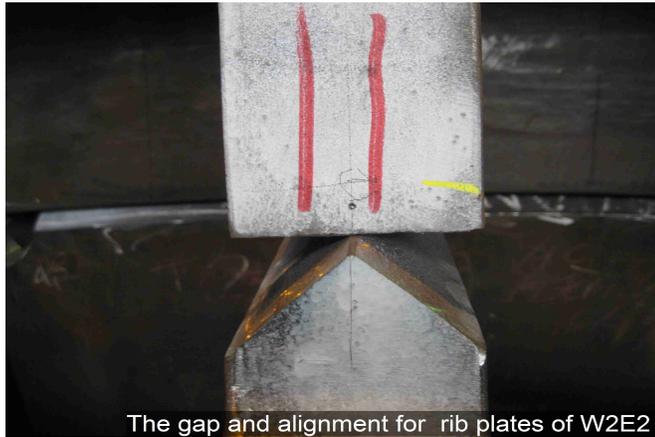
Casting Shop:

W2E3 and W2W3 West Deviation Saddle castings: Caltrans QAI observed two JSW workers performed grinding process on exterior rough surface of rib sides for W2E3 and W2W3 west deviation saddles after arc-gouging.

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Grinding process is to remove all the excess metal, oxide film and slag caused by gouging. The purpose for grinding is prepared for NDT testing. Base on Caltrans observation, no discrepancies were noted.



Summary of Conversations:

As noted within the report.

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 Nina Choy (510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Pau,Wai

Quality Assurance Inspector

Reviewed By: Lanz,Joe

QA Reviewer
