

**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-005164**Date Inspected:** 11-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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 welding: Caltrans Quality Assurance Inspector (QAI) representative observed two Japan Steel Works (JSW) welders performed Flux Cored Arc Welding (FCAW) processes on rib plate welds #7S-5U-2 and 7S-5U-3 of T1-1 tower. These welds are connecting casting and steel structure. The two welds start welding from 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. These two welds have been completed 70% weld metal. The tower saddle will wait for rotation to the opposite side to continue welding. The rotation operation approximate takes three hours to complete. The CWI Mr. Kuan informed to QA Inspector that welding for the tower will start at 2100 B shifts after dinner. 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.

## Casting Shop:

Casting shop has no scheduled for NDT test or welding today.

**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

---

---

## WELDING INSPECTION REPORT

*( Continued Page 2 of 2 )*

---

---

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

---

<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
----------------------	---------	-----------------------------

---

<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer
---------------------	----------	-------------