

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-005343**Date Inspected:** 22-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:****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:****Summary of Items Observed:**

Witness various mechanical tests for PQR #SJ-2942-WP3 (test plate SW-2-2)

Caltrans Quality Assurance Inspector (QAI) representative, Mr. Wai Pau, traveled to Nikko Inspection Service (NIS) test lab, to witness various mechanical tests for AWS standard Shielded Metal Arc Welding (SMAW) process PQR qualification test. The PQR is numbered SJ-2942-WP3 (test plate SW-2-2). The mechanical test includes all weld metal tension test, side bend test, reduced section tension test, macro etch and V-notch impact test

The entire various mechanical tests operation were monitored and accepted by the NIS foramen Mr. Hideo Domon.

Based on Caltrans QA observation, the various mechanical tests appeared to be in general compliance with requirement of Caltrans Special Provision and AWS D1.5 2002. A Caltrans Lot# B88-088-08 was assigned on the results of these various mechanical tests for tracking propose.

Bend test for welder qualification test:

QAI representative, Mr. Wai Pau witness side bent tests for two welder SMAW 3G position qualification test.

Two bend test specimens are requiring for each welder qualification test. The names of welders are Tatsuya Naitoh (71-2736) and Kei Nakasato (91-2247). The bend tests were recorded and accepted by NIS foramen Mr. Hideo Domon. Based on Caltrans observation, the testing operation and results appeared to be general compliance with requirements of AWS D1.5 section 5.

Summary of Conversations:

As noted within the report above.

WELDING INSPECTION REPORT

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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)697-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
