

**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-005350**Date Inspected:** 07-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, 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 saddles**Summary of Items Observed:**

Steel Structure Welding Shop:

W2E2 West Deviation Saddle Casting and Steel Structure Joint Section: Caltrans Quality Assurance Inspector (QAI) representative observed Japan Steel Works two (JSW) welders perform FCAW welding process on stem plate weld E2S-2U of W2E2 west deviation saddle and steel portions. The weld is connecting to casting and steel structure. The proper filler metal used for FCAW is Hoballoy TM-95K2, 1.6mm diameter with 100% C02. The entire structure has been preheated to a minimum 160C prior welding. The FCAW welding process and parameters have been monitored and recorded by CWI inspector Mr. Chung Kuan. Based on Caltrans observation, the FCAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

W2E3 West Deviation Saddle Steel Structure: Caltrans Quality Assurance Inspector (QAI) representative observed a welder perform FCAW process one stem plate weld E3S-2L of W2E3 west deviation saddle. The filler metal and shield gas used for FCAW is Hoballoy wire TM-95K2, 1.6mm diameter with 100% C02. The entire welding zone has been preheated to a minimum 110C prior welding. 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.

**Summary of Conversations:**

As noted within the report above.

**Comments**

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## WELDING INSPECTION REPORT

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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, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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