

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-005405**Date Inspected:** 10-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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:

W2E3 West Deviation Saddle Steel Structure: Caltrans Quality Assurance Inspector (QAI) representative observed Japan Steel Works (JSW) welders perform FCAW fillet weld process on weld access holes on rib plates 3-8, 3-10 and 3-12 of W2E3 west deviation saddle. The filler metal and shield gas used for FCAW is Hoballoy wire TM-95K2, 1.6 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 fillet weld 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 QAI representative observed JSW welders perform grinding processes on one side of stem plate weld E2S-2U of W2E2 west deviation saddle and steel portion. The purpose of the grinding is for dry MT test. Based on Caltrans observation, no discrepancies were noted.

T1-2 Tower Saddle Casting: Caltrans QAI representative observed two welders perform SMAW buildup weld metal welding on few casting area surfaces. The buildup weld metal is for the temporary reinforcement supply structure. The buildup metal welding utilizing the SMAW process was conducted by welders in the vertical up position (3G). A 6mm height weld metal has been welded on surfaces. The proper filler metal used for SMAW is LB52A (E7016) with 5mm diameter electrode made by Kobe, Japan. The SMAW welding process and parameters have been Caltrans approved per WPS SJ-3012-5. Based on Caltrans QA observation, the SMAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans

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approved RFI documents.



Summary of Conversations:

As noted within the report above.

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

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