

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-005437**Date Inspected:** 06-Mar-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1930**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:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

Witness various mechanical tests for PQR #SJ-2942-WP5 (test plate SW-4-1)

Caltrans Quality Assurance Inspector (QAI) representative, Mr. Danny Reyes and Mr. Wai Pau, traveled to Nikko Inspection Service (NIS) test lab, to witness various mechanical tests for AWS D1.5 standard Shielded Metal Arc Welding (SMAW) process PQR qualification test. The PQR is numbered SJ-2942-WP5 (test plate SW-4-1). 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 was monitored and recorded by the NIS foramen Mr. Hideo Domon. The reduced section tension test and all weld metal tension test did not meet the requirements of Caltrans' Special Provision and AWS D1.5 2002.

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 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