

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-005438**Date Inspected:** 07-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan

CWI Name:	Chung Kuan and MaKhmun 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:

Witness AWS D1.5 standard welder qualification welding test:

Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau witnessed six welder qualification tests. The qualification welding tests utilizing the Shielded Metal Arc Welding (SMAW) process were conducted by welders performed in the vertical position (3G). The welder test names are Mr. Yuuki Hayasako (94-2251), Mr. Mamoru Kubota (74-3666), and Mr. Mutsuo Kashiwara (08-2008), Mr. Yoshito Nakano (08-2011), Mr. Takao Kawakami (08-5079) and Mr. Takuma Ohakawa (03-3091). The material used for the welder qualification test specimens was reported by JSW Welding Engineer Mr. Jomio Imai as ASTM a 709M-HPS-485WT plate having a wall thickness measurement of 25mm. The weld joint design used butt joint, single-V-groove weld with 25mm backing bar. The proper filler metal used in the test for SMAW is Hoballoy 9018-M with 5mm diameter electrode made by Hobart Brothers, USA. The SMAW welding process and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan, Mr. MaKhmun Ashadi. However, the six welder qualification welding tests have been rejected by CWI Mr. Chung Kuan, Mr. MaKhmun Ashadi and verified by Caltrans QAI result in weld profiles excess of code allowances and some of welder unable to complete the welding on the specimen. Immediate retest was refused politely by JWS welding foreman. The reason is those welders need more training and practice.

Caltrans QAI informed welding foreman that JSW has to provide either the new training certificate or welding practice log book (include: date, time and type of welding practice) for those six welders prior welder qualification retest.

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
