

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-005439**Date Inspected:** 28-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 MaKhud 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 Procedure Qualification Record (PQR) qualification test (SW-5-2): Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau, travel to Japan Steel Works (JSW) Muroran plant to witness an AWS D1.5 standard PQR qualification welding test. The number of PQR qualification welding test is SJ-2942-WP-8 (test plate SW-5-2). The material used for the PQR qualification test specimens was reported by JSW Welding Engineer Mr. Takaaki Maruya as ASTM A and ASTM A709-HPS-485WT (plate) both having a wall thickness measurement of 50mm. The weld joint design used butt joint, single-V-groove weld with 20mm x 75mm backing bar. The filler metal used in the test is Hoballoy 9018-M with 4mm diameter electrode, made by Hobart Brothers, USA. The electrode certification is 30H438. The SMAW welding and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan, Mr. MaKhud Ashadi and JSW Welding Engineer Mr. Takaaki Maruya, and were also observed by Caltrans QAI. Filler weld passes (#45 to #46) were completed on this date and the PQR welding for this plate has been completed. Based on Caltrans QA observation, The PQR welding test was appeared to be in general compliance with the requirements of AWS D1.5 2002 and Caltrans contract document. The PQR will schedule to radiographic testing (RT) test.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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