

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 #: 73.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007147**Date Inspected:** 27-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** HoChang, Korea**Location:** Unyang/Changwon, Korea

CWI Name:	Sang Ho Kwak		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Pier E2 Bearing and Shear Key**Summary of Items Observed:**

The following report is based on METS observations at HoChang Machinery Industries (HCMI). Current work: Casting, forging and machining.

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at HoChang Machinery Industries (HCMI) located at Unyang, Korea and DooSan Heavy Industries (DHIC) located at Changwon, Korea. The Purpose of this trip was to observe quality control during fabrication and process of following items.

Forging

1. Bearing Bottom Housing (B1-07/F07302-010): Completed final UT
2. Bearing Bottom Housing (B2-07/F07302-020): Completed final UT
3. Bearing Bottom Housing (B3-07/F07302-030): Completed final UT
4. Bearing Bottom Housing (B4-07/F07302-040): Completed QT
5. Spherical Ring (S1-07/F07302-050): Completed final UT
6. Spherical Ring (S2-07/F07302-060): Completed final UT
7. Spherical Ring (S3-07/F07302-070): Completed final UT
8. Spherical Ring (S4-07/F07302-080): Completed final UT
9. Solid Shaft (B1-02/F07302-090): Completed final UT
10. Solid Shaft (B2-02/F07302-100): Completed final UT
11. Solid Shaft (B3-02/F07302-110): Completed QT
12. Solid Shaft (B4-02/F07302-120): Completed QT

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- F number is DooSan Production Number.
- B number is drawing Number .

Casting

On this date DHIC performed repair welding on the castings listed below as repair. This QA inspector, HMIC QC Inspector and DHIC QC inspector checked the welding parameters of the welding personnel listed below prior to the start of repair welding.

The welding process utilized was Flux Core Arc Welding (FCAW) with filler metal E81T1-K2, 1.6mm diameter, manufactured by SEAH-ESAB and Brand name Dual shield 1181-K2.

This QA inspector verified the following welding parameters: 23-26 volts and 210-250 amps with a travel speed of 13-16 cm/min. This QA Inspector observed a gas flow of 10-25l/min and a preheat temperature over 100°C during observations.

The welding parameters observed appear to comply with approved welding procedure specification; A-F-Z1Z1-219.

Welders: Mr. JH, Nam and Mr. TR, Ma welding on B1-06(Bearing Top Housing)
Mr. BJ, Na welding on S1-03(Shear Key Housing)

1. Bearing Top Housing(B1-06, C07039-010): Start repair welding.
2. Bearing Top Housing(B2-06, C07039-020): Completed removal of defect and NDT
3. Bearing Top Housing(B3-06, C07039-030): Completed PWHT
4. Bearing Top Housing(B4-06, C07039-040): Completed repair welding.
5. Bearing Hold Down Assembly (B1-01-1, C07039-050): Completed PWHT
6. Bearing Hold Down Assembly (B1-01-2, C07039-060): Completed PWHT
7. Bearing Hold Down Assembly (B2-01-1, C07039-070): Completed PWHT
8. Bearing Hold Down Assembly (B2-01-2, C07039-080): Completed PWHT
9. Bearing Hold Down Assembly (B3-01-1, C07039-170): Completed PWHT
10. Bearing Hold Down Assembly (B3-01-2, C07039-180): Completed PWHT
11. Bearing Hold Down Assembly (B4-01-1, C07039-190): Completed PWHT
12. Bearing Hold Down Assembly (B4-01-2, C07039-200): Completed PWHT
13. Shear Key Stub(S1-01, C07039-090) : Completed PWHT
14. Shear Key Stub(S2-01, C07039-100) : Completed PWHT
15. Shear Key Stub(S3-01, C07039-110) : Completed PWHT
16. Shear Key Stub(S4-01, C07039-120) : Completed removal of defect and NDT
17. Shear key Housing(S1-03, C07039-130): Continue to repair welding.
18. Shear key Housing(S2-03, C07039-140): Completed repair welding.
19. Shear key Housing(S3-03, C07039-150): Completed removal of defect and NDT
20. Shear key Housing(S4-03, C07039-160): Completed removal of defect and NDT

* S and B number is drawing number.

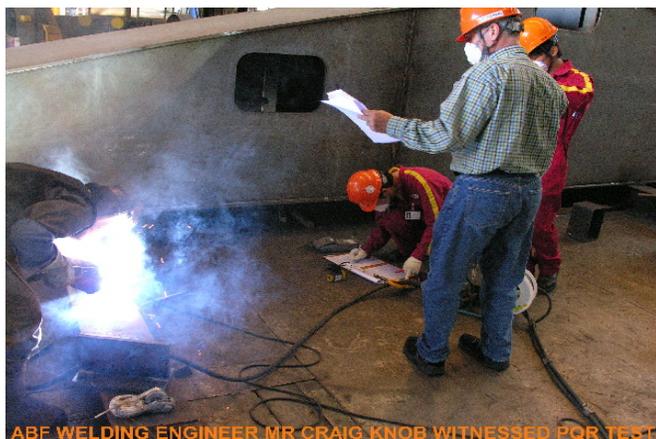
* C number is DSHI ID number

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This QA Inspector observed HMIC QC Inspector Mr. Kwak and ABF welding engineer Mr. Craig Knob were present during the welding of various Procedure Qualification Record (PQR) for draft WPS's. Please see TL-6032 this date for more details. The following is a list of PQR's welding witnessed.

WPS No	Position	Supporting PQR No
FC-061	1F	QFC-061-1F
FC-061	2F	QFC-061-2F
FC-061	3F	QFC-061-3F
SFC-013	Flat	QSFC-013



Summary of Conversations:

*Discuss with Mr. S. H. Kwak regarding general project schedule.

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, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Hager,Craig	QA Reviewer
