

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-007218**Date Inspected:** 12-Jun-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 MT
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 MT
12. Solid Shaft (B4-02/F07302-120): Completed MT

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

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

Casting

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

The QA inspector observed the welding process utilized Flux Core Arc Welding (FCAW) with filler metal E81T1-K2, 1.6mm diameter wire manufacture by SEAH-ESAB with 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. The QA inspector observed a shielding gas flow of 10-25 l/min and a preheat temperature over 100°C which appeared to be maintained 24 hours a day.

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

Welder Mr. YT, Kim welding on S4-01.

Mr. JH, Kim and Mr. DJ, Kang welding on S3-03.

Mr. KS, Kim welding on S4-03.

1. Bearing Top Housing(B1-06, C07039-010): Continued repair welding.
2. Bearing Top Housing(B2-06, C07039-020): Started repair welding.
3. Bearing Top Housing(B3-06, C07039-030): Completed PWHT
4. Bearing Top Housing(B4-06, C07039-040): Completed PWHT
5. Bearing Hold Down Assembly (B1-01-1, C07039-050): Started Final NDT
6. Bearing Hold Down Assembly (B1-01-2, C07039-060): Started Final NDT
7. Bearing Hold Down Assembly (B2-01-1, C07039-070): Started Final NDT
8. Bearing Hold Down Assembly (B2-01-2, C07039-080): Completed PWHT
9. Bearing Hold Down Assembly (B3-01-1, C07039-170): Started Final NDT
10. Bearing Hold Down Assembly (B3-01-2, C07039-180): Started Final NDT
11. Bearing Hold Down Assembly (B4-01-1, C07039-190): Started Final NDT
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) : Continued repair welding.
17. Shear key Housing(S1-03, C07039-130): Continued repair welding.
18. Shear key Housing(S2-03, C07039-140): Completed PWHT
19. Shear key Housing(S3-03, C07039-150): Started repair welding
20. Shear key Housing(S4-03, C07039-160): Started repair welding

WELDING INSPECTION REPORT

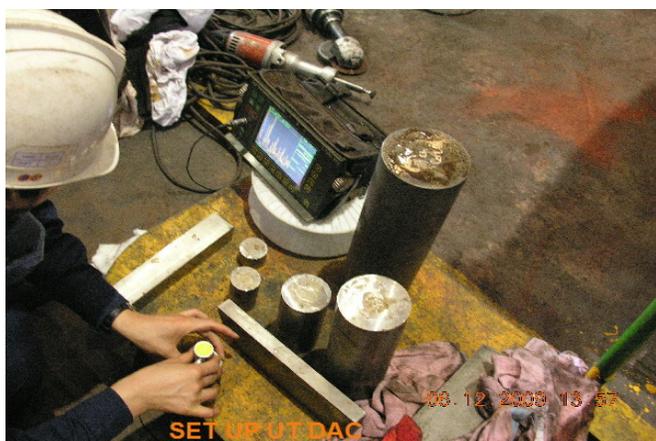
(Continued Page 3 of 4)

* S and B number is drawing number.

* C number is DSHI ID number

This QA Inspector observed a DHIC NDE technician performing Ultrasonic Testing (UT) and Magnetic Particle Testing (MT) on 6 bearing hold downs. This QA inspector verified equipment calibrations for the UT and MT equipment. The UT equipment verifications included a current calibration sticker, an acceptable Distance Amplitude Correction (DAC) setting and confirmed the correct transducer size and frequency were being used. The MT equipment verifications included a current calibration sticker and in process system performance using a pie gauge.

This QA inspector observed the Liquid Penetrant Testing (PT) results of the stainless steel Procedure Qualification Record (PQR). Please see photos below; repair welding, UT calibration and PT results.



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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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