

**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-002297**Date Inspected:** 14-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Japan Steel Works**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:** PQR test**Summary of Items Observed:**

The JSW Engineer Itoh Yoshihiro accompanied Caltrans quality assurance Inspector (QAI) representative to machine shop #4, to observe the two JSW operators performing rough machining on two segments of the West Deviation Saddle Segments numbered W2E1 and W2E2. The material used for the castings is ASTM A148M Gr. 620-415. Two segments have been measured and secured the position by jet camps. The W2E1 segment has performed rough machining on exterior surface. The machine being used is Shoko, model 60 with a cutter head of 450mm diameter operating at a speed of 120 rpm. The rough machining will be finish on Dec-28-07 according to JSW's schedule. The W2E2 segment has performed rough machining on interior surface. The machine has been used is Shoko, model 50 with a cutter head of 300mm at a speed of 110rpm. The rough machining will be finish on Jan-31-07 with JSW schedule. Base on Caltrans observation, no discrepancies were noted. The rough machining will be finish on Jan-31-08 according to JSW's schedule.

Note: We have to go with JSW representative every time entry the casting shop, machine shop, and welding shop that is by JSW rule.

**Summary of Conversations:**

As Note 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.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Pau, Wai	Quality Assurance Inspector
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<b>Reviewed By:</b>	Brasel, Ron	QA Reviewer
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