

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-002387**Date Inspected:** 10-Apr-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:****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:** ASTM 709M-HPS-485WT material**Summary of Items Observed:**

Identify ASTM 709M-HPS-485WT material prior cutting: Caltrans Quality Assurance Inspector (QAI) representative Mr. Danny Reyes and Mr. Wai Pau travel to JSW No. 2 welding shop verified a material of ASTM a 709M-HPS-485WT plate prior cutting. First, Caltrans QAI verify the MTR and cutting drawing of ASTM a 709M-HPS-485WT material, which submitted by JSW Company. Then, identify the plate number, heat number and rolling direction marked on the each steel plate. However, total of twenty-three plates of ASTM a 709M-HPS-485WT material with various thickness have been cutting with various sharp plates and most the edge of plates have been beveled for welding. The plate number and heat number of twenty-three plate material of ASTM a 709M-HPS-485WT can't be physical identified on any cut plates. The only way can tracking the material is by cutting mark from the cutting drawings. Caltrans QAI asked the JSW Mr. Sato Kazunori when the cutting and beveling process have be start and how come Caltrans inspector has not be notice for this process. Mr. Sato Kazunori reponded that ASTM a 709M-HPS-485WT material has been cut and bevel since Feb-2008 and JSW has not notice any Caltrans inspector in JSW Japan. Caltrans QAI reported to Caltrans SMR Mr. Ron Brasel and NCR will be issue today.

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.

WELDING INSPECTION REPORT

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Inspected By:	Pau, Wai	Quality Assurance Inspector
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Reviewed By:	Brasel, Ron	QA Reviewer
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