

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-002695**Date Inspected:** 28-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Mr. Makhmud 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:**

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan. Current work: Casting, machining and nondestructive testing of Saddles.

Fabrication Building number 4

The QA inspector periodically observed The Nikko Inspection Services QC/NDT technician Mr. Rikuo Kumagai perform magnetic particle (MT) testing of West Deviation Saddle base W2E1, at locations where cracked tack welds have been removed. The MT was performed in accordance with ASTM standard E709, using the yoke method. The yoke utilized appeared to be model UM 3BF, serial numbers 93-01. The yoke dead lift was verified with a 4.65kg test plate. The magnetic field was verified with a field indicating gauge (pie gauge). Dry visible magnetic particle was utilized. All calibrations appear to meet the minimum requirements of ASTM E709. The testing was evaluated in accordance with the contract special provisions. No relevant indications were marked by Mr. Kumagai. The testing was completed on this date and the work appears to meet the minimum requirements of the contract specifications.

The QA inspector performed magnetic particle testing (MT) verification of West Deviation Saddle base W2E1, at tack weld locations and locations where cracked tack welds have been removed. The welds and weld locations were examined using magnetic particle testing of approximately 10% of the locations examined by Nikko Inspection Services QC/NDT technicians. The QA inspector performed the magnetic particle testing in accordance with ASTM E709 and JSW procedure SF-MT-01 using a magnetic particle AC yoke. No relevant indications were noted. The QA inspector did concur with the QC/NDT inspector's assessment. Please see the Magnetic Particle Testing Report (TL-6028) that was generated on this date for welds that were tested in

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accordance with the contract requirements.



Summary of Conversations:

JSW Deputy Manager Mr. Kazunori Sato requested a meeting with METS personnel Mr. Ron Brasel to discuss issues with the Performance Qualification Tests that were performed outside the requirements of the Contract Special Provisions Section 8-3.01-Welding.

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) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Brasel,Ron	QA Reviewer
