

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-004553**Date Inspected:** 30-Oct-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** HoChang, Korea**OSM Arrival Time:** 900**OSM Departure Time:** 1700**Location:** UnYang, Korea

CWI Name:	N/A	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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		Component:	PIER E2 Bearing and Shear Key	

Summary of Items Observed:

The following report is based on METS observations at HoChang Machinery Industries. 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 Ulsan, Korea and DooSan Heavy Industry. The Purpose of this trip was observed quality control during fabricate and process of following items.

Forging

1. Bearing Bottom Housing (F07302-010): Completed normalizing and heat treating
2. Bearing Bottom Housing (F07302-020): Completed normalizing and heat treating
3. Bearing Bottom Housing (F07302-030): Completed normalizing and heat treating
4. Bearing Bottom Housing (F07302-040): Completed normalizing and heat treating
5. Spherical Ring (F07302-050): Completed normalizing and heat treating
6. Spherical Ring (F07302-060): Completed normalizing and heat treating

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7. Spherical Ring (F07302-070): Completed normalizing and heat treating
8. Spherical Ring (F07302-080): Completed normalizing and heat treating
9. Solid Shaft (F07302-090): Completed normalizing and heat treating
10. Solid Shaft (F07302-100): Completed normalizing and heat treating
11. Solid Shaft (F07302-110): Completed normalizing and heat treating
12. Solid Shaft (F07302-120): Completed normalizing and heat treating

Note: The F number is DooSan Production Number.

Castings

1. Bearing Top Housing
 - Unit # 1: Pattern making
 - Unit # 2: Not started
 - Unit # 3: Not started
 - Unit # 4: Not started
2. Bearing Hold Down Assembly
 - Unit # 1: Pattern making
 - Unit # 2: Pattern making
 - Unit # 3: Not started
 - Unit # 4: Not started
3. Shear key Housing
 - Unit # 1: Pattern making
 - Unit # 2: Pattern making
 - Unit # 3: Not started
 - Unit # 4: Not started
4. Shear Key Stub
 - Unit # 1: Pattern making
 - Unit # 2: Not started
 - Unit # 3: Not started
 - Unit # 4: Not started

Summary of Conversations:

Discussed with Mr. C. I. Park and Mr. S. H. Kwak regarding NDE procedure submittal schedule and fabrication procedure comments.

Also trip schedule to DSHI for witness of in house UT before rough machining and green tag schedule.

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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 Jinesh K, Mehta 951-840-0541, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
