DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 73.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-004796
Date Inspected: 27-Nov-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: HoChang, Korea

OSM Arrival Time: 600
OSM Departure Time: 1500
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	
				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. Current work: Casting, forging and machinning.

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at HoChang Machinery Industries (HCMI) located at Unyang, Korea. The Purpose of this trip was to observe quality control during fabricate and process of following items.

Forging

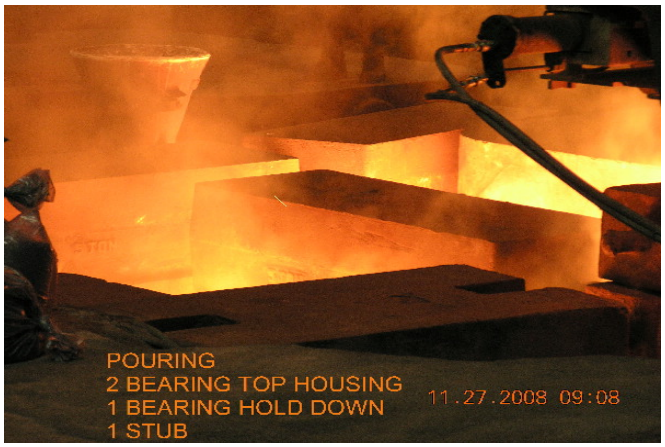
1. Bearing Bottom Housing (B1-07/F07302-010): Move to HCMI for rough machining.
2. Bearing Bottom Housing (B2-07/F07302-020): Continue to rough machining
3. Bearing Bottom Housing (B3-07/F07302-030): Move to HCMI for rough machining.
4. Bearing Bottom Housing (B4-07/F07302-040): Move to HCMI for rough machining.
5. Spherical Ring (S1-07/F07302-050): Dimension check after rough machining.
6. Spherical Ring (S2-07/F07302-060): Dimension check after rough machining.
7. Spherical Ring (S3-07/F07302-070): Dimension check after rough machining.
8. Spherical Ring (S4-07/F07302-080): Dimension check after rough machining.
9. Solid Shaft (B1-02/F07302-090): Dimension check after rough machining.
10. Solid Shaft (B2-02/F07302-100): Dimension check after rough machining.
11. Solid Shaft (B3-02/F07302-110): Dimension check after rough machining.
12. Solid Shaft (B4-02/F07302-120): Dimension check after rough machining.

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

Casting

1. Bearing Top Housing(B1-06, C07039-010): Raiser cut in progress
2. Bearing Top Housing(B2-06, C07039-020): Finished Pouring
3. Bearing Top Housing(B3-06, C07039-030): Finished Pouring
4. Bearing Top Housing(B4-06, C07039-040): Pattern making
5. Bearing Hold Down Assembly (B1-01-1, C07039-050): Cool down in mold.
6. Bearing Hold Down Assembly (B1-01-2, C07039-060): Cool down in mold.
7. Bearing Hold Down Assembly (B2-01-1, C07039-070): Finished Pouring
8. Bearing Hold Down Assembly (B2-01-2, C07039-080): Pattern making
9. Bearing Hold Down Assembly (B3-01-1, C07039-170): Pattern making
10. Bearing Hold Down Assembly (B3-01-2, C07039-180): Pattern making
11. Bearing Hold Down Assembly (B4-01-1, C07039-190): Pattern making
12. Bearing Hold Down Assembly (B4-01-2, C07039-200): Pattern making
13. Shear Key Stub(S1-01, C07039-090) : Raiser cut in progress
14. Shear Key Stub(S2-01, C07039-100) : Finished Pouring
15. Shear Key Stub(S3-01, C07039-110) : Pattern making
16. Shear Key Stub(S4-01, C07039-120) : Pattern making
17. Shear key Housing(S1-03, C07039-130): Raiser cut in progress
18. Shear key Housing(S1-03, C07039-130): Raiser cut in progress
19. Shear key Housing(S1-03, C07039-130): Pattern making
20. Shear key Housing(S1-03, C07039-130): Pattern making

* S and B number is drawing number.
* C number is DSHI ID number
  * Blank is not started.



WELDING INSPECTION REPORT

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Summary of Conversations:

Discuss Mr. S. H. Kwak regarding current status of NDE procedure and fabrication procedure comments.

Check machining schedule of bearing bottom housing with Mr. Kwak.

Ask production schedule of casting.

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