

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-004828**Date Inspected:** 27-Nov-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1700**Location:** Muroan, Japan

CWI Name:	Chung-Fu Kuan		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	Tower, Jacking and Deviation Saddles		

Bridge No: 34-0006**Summary of Items Observed:**

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

Fabrication Shop 4

T1-1 Base

No work performed on this date.

T1-1 Casting

No work performed on this date.

T1-2 Base

JSW personnel were observed rotating T1-2 base to allow welding to continue on the opposite side of weld joints previously welded.

T1-3 Base

The QA inspector observed the in process fit-up and welding of the structural steel plate temporary stiffeners for the Tower Saddle Base T1-3. The stiffeners were located on the exterior of the rib plates as shown in JSW approved fabrication procedure. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

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W2-E1

The QA inspector observed JSW personnel continue removing temporary bracing from W2-E1 base ribs in preparation for final machining. The bracing was removed using the oxygen-fuel gas method. The QA inspector noted that the final cut to bring the edges of the plates to required dimension was performed using an automated oxygen-fuel gas system. The work was not completed on this date and appears to meet the minimum requirements of the contract documents.

W2-E2 Base

No work performed on this date.

W2-W1 Casting

No work performed on this date.

Foundry

W2-E2 Casting

One JSW personnel was observed shaping welded repair areas of casting W2E3 utilizing the manual air carbon arc cutting method. The shaping task was performed on built up thickness of the ribs in areas that were found to not meet the minimum thickness as shown in submittal 000712, revision 00. After shaping was complete, one JSW employee was observed grinding to smooth the surface of the casting where the Air-Carbon Arc method was utilized. Work was not completed on this date and appears to meet the minimum requirements of the contract documents.

W2-E3 Casting

Nikko Inspection Services QC/NDT technicians performed a Dye Penetrant examination on casting W2-E2. The areas examined appear to be the exterior surfaces on the side opposite the stamp mark on the casting. The examination was performed in accordance with ASTM 165 and JSW procedure SJ-2878. No relevant indications were observed on the surfaces.

T1-2 Casting

The QA inspector observed the in process casting repair welding on Tower Saddle casting T1-2. The welding was performed where defects found during non-destructive testing were removed. The repair locations and repair details for this casting were submitted as Transmittal number 1652, revision 00. The JSW welding personnel Yoshio Kabutomori, ID 06-8000 continued the repair welding of repair numbers 7, 11 and 12. The repairs were performed utilizing Shielded Metal Arc Welding (SMAW) per the welding procedure specification (WPS) SJ 3026-4. JSW welding engineer Mr. Imai monitored the welding parameters and heat control at periodic intervals. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

The QA inspector observed the in process casting repair welding on Tower Saddle casting T1-2. The welding was performed to build up the thickness of the ribs in areas that were found to not meet the minimum thickness as shown on the approved drawings. The repair locations and repair details for this casting were submitted as number 000943, revision 03. The JSW welding personnel Hitoshi Sato, ID 69-2697 continued the repair welding of repairs 1 and 2 as shown on section B-B. The repairs were performed utilizing Shielded Metal Arc Welding

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(SMAW) per the welding procedure specification (WPS) SJ 3026-4. JSW welding engineer Mr. Imai monitored the welding parameters and heat control at periodic intervals. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

T1-3 Casting

No work performed on this date.

Summary of Conversations:

No relevant conversations.

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
