

**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 #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004900**Date Inspected:** 02-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Japan Steel Works**Location:** Muroan, Japan**CWI Name:** 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:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance Inspector (QA) James Weaver was present at the Japan Steel Works (JSW) jobsite in Muroan, Japan for the purpose of observing in-process fabrication of components for the Tower, Jacking and Deviation Saddles. Current work: Casting, machining, welding and nondestructive testing of Saddles and Bases.

**T1-2 Base**

The QA inspector observed the Magnetic Particle (MT) inspection of the weld terminations prior to filling the termination radius with weld material. The MT inspections were performed by The Nikko Inspection Services QC/NDT technicians Mr. K. Kumagia and Mr. H. Aiuchi. MT was performed in accordance with ASTM standard E709 and Nikko Inspection Services procedure SF-MT-01 using the yoke method with dry visible powder. The testing was evaluated in accordance with the contract special provisions. No relevant indications were marked by Mr. Kumagia or Mr. Aiuchi. The testing was not completed on this date and the work appears to meet the minimum requirements of the contract specifications.

**T1-3 Base**

QA Observed the JSW welding personnel tack welding joint 9Y-6V (2-2). The JSW welding personnel Yoshihiro Ohta, ID 08-2017 performed the in process tack welding of joint 9Y-6V (2-2) in the vertical position. The welding was performed utilizing the Shielded Metal Arc Welding (SMAW) process per the welding procedure specification (WPS) SJ-3012-2. The welding parameters and heat control were monitored by Intertek Testing Services Quality Control (QC) inspector Mr. Chung-Fu Kuan at periodic intervals. The minimum preheat temperature of 110°Celsius was verified to meet the WPS requirements by Mr. Kuan was observed by the QA

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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inspector utilizing Tempilstik temperature indicators. This data was entered into the QC inspector's daily log, identifying the location on a weld map. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.



## Summary of Conversations:

There were general conversations with Intertek Testing Services Certified Welding Inspector Mr. Makhmud Ashadi relative to the location of the welding and inspection personnel in the fabrication shop number 4.

## 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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Weaver,James	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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