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

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 70.28

WELDING INSPECTION REPORT

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

Report No: WIR-004901
Date Inspected: 03-Dec-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 830
OSM Departure Time: 1830
Location: Muroran, Japan

CWI Name: Makhmud Ashadi

Inspected CWI report:	☑ Yes	☐ No	☐ N/A	**CWI Present:**	☑ Yes ☐ No
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ 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 Muroran, 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.

W2-E2 Base

Two JSW employees were observed grinding weld prep areas of the rib and stem plates of W2-E2 base. The grinding was performed to smooth the weld joint surface and remove all rust prior to fit up to W2-E2 casting. Work was not completed on this date and appears to meet the minimum requirements of the contract documents.

W2-W3 Casting

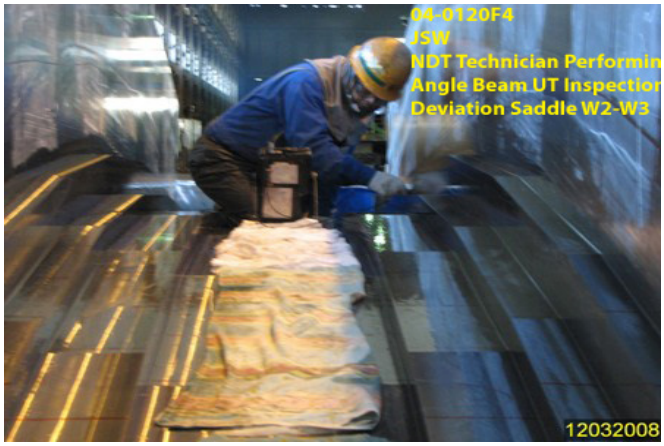
The QA inspector periodically observed the Nikko Inspection Services QC/NDT Level II technician Mr. Harumi Kohama perform shear wave ultrasonic testing of casting W2-W3 trough areas where straight beam testing could not be confirmed due to loss of the back wall signal. The testing was performed with a 2 MHz, 20mm by 22mm 45 degree rectangular shear wave transducer. The testing was performed in accordance with JSW procedure specification number SJ-2878 revision 2. The testing was not completed on this date and the work appears to meet the minimum requirements of the contract specifications.

T1-2 Base

The QA inspector observed The Nikko Inspection Services QC/NDT technician Mr. R. Kumaga perform magnetic particle (MT) testing of the weld terminations on welds 8Y7V (2-2), 8Y7V (2-3) and 8Y8V (2-3). The

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. Kumaga. 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 installing temporary bracing to hold the components stationary during the welding process.



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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Weaver,James	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer