

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-005616**Date Inspected:** 04-Mar-2009**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1630**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**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 OSM Quality Assurance (QA) Inspector Mr. Art Peterson was present during the times noted above for observations relative to the work being performed in Fabrication shop #4.

Grinding Operation and NDT: West Deviation Saddle Segment W2W1

The QA Inspector observed the following work in process: grinding operation of the cope holes on the Rib plate to Stem Plate prior to performing NDT MT inspection by Quality Control (QC) Inspector Mr. R Kumagai (#132) at Rib to Stem locations 4-10, 4-14, and 4-16.

Back-gouge and Welding Operation: Tower Saddle Segment T1-1

The QA Inspector observed the following work in process: after the back-gouge operation was completed on complete-joint penetration double groove weld 7Y-5L-2 and the gouged groove was prepared by grinding for NDT inspection, The QA Inspector observed QC Inspector Mr. R Kumagai (#132) performing the MT inspection (dry method) of the prepared groove weld. After Mr. R Kumagai completed and accepted the the prepared groove, the QA Inspector observed JSW production personnel Welder ID 912247, performing the root pass welding per the SMAW process in the (1G) flat position. The QA Inspector verified that QC CWI Inspector Mr. Chung Fu Kuan, prior to the start of welding, verified that the welding parameters and the minimum preheat temperature were in compliance with approved WPS SJ-3012-2.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Peterson,Art	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
