

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-005730**Date Inspected:** 10-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Imai Jomio**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 Art Peterson was present during the times noted above for observations relative to the work being performed in the Foundry Shop at Japan Steel Works.

NDT of Cast Section: West Deviation Saddle Segment W2E3

The QA Inspector observed NIS NDT Personnel preparing the cast saddle segment for NDT Inspection by (setting up) placing grid lines on the casting for magnetic particle testing (MT) and ultrasonic testing for tracking and identification.

Cleaning Operation of Cast Section: West Deviation Saddle Segment W2W1

The QA Inspector verified that west deviation saddle segment W2W1 is being cleaned (sand blasted) on this date. Afterwards, NIS NDT personnel will perform the required NDT of the repaired areas on the stem section.

Repair welding pending on Cast Section: West Deviation Saddle Segment W2W3

The QA Inspector was informed by JSW Representative Mr. Hideaki Kon that no repair welding will be performed on the outside of the trough section on west deviation saddle segment W2W3 on this date.

Repair welding of Cast Section: West Deviation Saddle Segment W2W2

The QA Inspector observed and verified that the following work was completed on the build up of the Rib cast sections on west deviation saddle segment W2W2. The west deviation saddle segment is being moved to have the saddle segment post weld heat treated.

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NDT of Cast Section: West Deviation Saddle Segment E2E1

The QA Inspector observed NIS NDT Inspector Mr. Atsui Seino performing magnetic particle testing (MT) inspection (wet method) on the rough machined areas of the ribs and inside of the trough sections.

Shaping of Cast Section: East Deviation Saddle Segment E2W1

The QA Inspector observed and verified that JSW personnel completed the shaping (scarfing) operation on the outside of the trough section and the sections were profiled to the proper radius.

Moving of Cast Section: Tower Saddle Segment T1-3

The QA Inspector was informed by JSW Representative Mr. Hideaki Kon that tower saddle segment section T1-3 is in preparation to be moved to Machine Shop #4 to layout (locate the assembly control lines) and place the scribe lines and punch marks on the cast saddle segment prior to being moved to Fabrication Shop #4 for fitting to the T1-3 built up steel plate section.

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

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 Nina Choy, 510 385-5910, who represents the Office of Structural Materials for your project.

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