

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-005733**Date Inspected:** 13-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Japan Steel Works**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

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 at Japan Steel Works.

Welding Operation: Tower Saddle Segment T1-1

The QA Inspector observed the complete joint penetration groove welding operation on the structural steel Rib plate to structural steel Base plate on tower saddle segment T1-1. The QA Inspector observed Quality Control (QC) Inspector Mr. Chung Fu Kuan verify prior to the start of welding that the preheat temperature of 110 degrees Celsius was maintained and the welding parameters of JSW welding personnel Mr. S. Watanabe (08-5169) on weld joint no. 7Y9L-1, Mr. T. Inoue (08-5163) on weld joint no. 7Y9L-4, Mr. M. Yamashita (73-4195) on weld joint no. 7Y5L-2, and Mr. T. Watanabe (74-3666) on weld joint no. 7Y5L-3 were in compliance with WPS SJ-3012-3 per the FCAW process in the (1G) flat position. The QA Inspector observed the welding was in process at the end of the QA Inspectors' shift.

Machining of Steel Section: West Deviation Saddle Segment W2-E2

The QA Inspector was informed by JSW Representative Mr. Hideaki Kon that west deviation saddle segment section W2-E2 was moved to Machine Shop #2 to have the final machining performed. Mr. Kon also informed the QA Inspector that the final machining will take approximately one month to complete.

NDT of Steel Section: West Deviation Saddle Segment W2-E1 (After Post Weld Heat Treatment)

The QA Inspector observed NIS NDT Inspector Mr. R. Kumagai performing magnetic particle testing (MT) inspection (wet method) on the final machined areas inside of the trough of west deviation saddle segment W2-E1.

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The QA Inspector observed that the MT inspection was in process at the end of the QA Inspectors' shift.

NDT of Steel Section: West Deviation Saddle Segment W2-E3 (After Post Weld Heat Treatment)

The QA Inspector observed NIS NDT Inspector Mr. Atsusi Seino performing magnetic particle testing (MT) inspection (dry method) on the partial joint penetration groove welds (cover pass) after PWHT on west deviation saddle segment W2-E3. The QA Inspector observed that the MT inspection was in process at the end of the QA Inspectors' shift.

Heat Treatment of Steel Section: West Deviation Saddle Segment W2-W1

The QA Inspector was informed by JSW Representative Mr. Hideaki Kon that the post weld heat treatment has been completed on west deviation saddle segment W2-W1. Afterwards, the west deviation saddle segment will be moved to have the saddle segment cleaned prior to performing the NDT operation.

Welding of Steel Section to Cast Section: Tower Saddle Section T1-2

The QA Inspector observed that tower saddle steel section T1-2 is fit-up to the tower saddle cast section T1-2 and all of the strong backs and temporary supports have been completely welded into place for distortion control. The QC Inspector Mr. Chung Fu Kuan informed the QA Inspector that the steel and cast tower saddle section welding will start on or around March 16, 2009 in fabrication shop #4.

Fit-up of Steel Section: West Deviation Saddle W2-W2

The QA Inspector was informed by QC Inspector Mr. Chung Fu Kuan that the fit-up operation (stem to base plate and rib to stem to base plate) of west deviation saddle steel section W2-W2 will start during the week of March 16, 2009.

Grinding of Steel Section: Tower Saddle T1-3

The QA Inspector observed that JSW personnel were grinding to final dimension the beveled face and root face of the machined partial penetration double groove areas on the stems and ribs of tower saddle steel section T1-3 after final layout (placement of scribe lines and punch marks) in preparation of fitting up the tower saddle steel section to the tower saddle cast section. The QA Inspector observed that the grinding operation was in process at the end of the QA Inspectors' shift.

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
