

**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-005735**Date Inspected:** 16-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:** Muroran, Japan

<b>CWI Name:</b>	Chung Fu Kuan		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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 partial-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. T. Watanabe (08-5153) on weld joint no. 7Y8L, and Mr. K. Kobayashi (08-5023) on weld joint no. 7Y6L were in compliance with WPS SJ-3012-3 per the FCAW process in the (1G) flat position. The QA Inspector observed that 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 verified that west deviation saddle segment section W2-E2 is in Machine Shop #2 to have the final machining performed. The final machining has started on the base plate on this date and is estimated to take approximately one month to machine west deviation saddle segment W2-E2.

**Dimensional Inspection of Steel Section: West Deviation Saddle Segment W2-E1 (After PWHT and Final Machining)**

The QA Inspector observed that JSW moved the west deviation saddle segment W2-E1 to an area in preparation to perform the dimensional inspection which is scheduled to take place on March 17, 2009.

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## WELDING INSPECTION REPORT

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### Machining of Steel Section: West Deviation Saddle Segment W2-E3 (After PWHT)

The QA Inspector observed that west deviation saddle segment W2-E3 is in Machine Shop #2 to have the root face dimension on the stem and ribs machined prior to the fit-up operation so the root face will meet the mill to bear surface requirements per the contract specifications.

### NDT of Steel Section: West Deviation Saddle Segment W2-W1 (After PWHT)

The QA Inspector observed NIS NDT Inspector Mr. R. Kumagai performing magnetic particle testing (MPT) inspection (dry method) on the partial-joint penetration groove welds after the post weld heat treatment operation on the rib to stem and rib to base plate of west deviation saddle segment W2-E1. The QA Inspector observed that the MPT inspection was in process at the end of the QA Inspectors' shift.

### 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 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 QA Inspector observed that tower saddle section T1-2 is being prepared (staging is being formed around the tower saddle section) so the preheat operation can begin.

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

The QA Inspector observed that the fit-up operation (stem plate to base plate, rib plate to stem plate, and rib plate to base plate) of west deviation saddle steel section W2-W2 has not started on this date.

### 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 on the machined partial penetration double groove areas of the stems and ribs on tower saddle steel section T1-3. The final layout (placement of scribe lines and punch marks) was performed in preparation of fitting up the tower saddle steel section to the tower saddle cast 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.

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

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