

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005780**Date Inspected:** 11-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, 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

Component: Tower, Jacking and Deviation Saddles

Bridge No: 34-0006**Summary of Items Observed:**

On this date 3/11/09, Caltrans OSM Quality Assurance (QA) Inspector, Mike Brcic, was present during the times noted above for observation relative to work performed in Fabrication Shop #4, Japan Steel Works (JSW).

W2E1 - Sits idle, awaiting Quality Control (QC) Magnetic Particle Testing (MT) of final machine surfaces.

W2E2 - Inspected discrepant weld profile noted on Vertical weld stem to rib (see MT report TL-6028) has been reinspected and found acceptable following contouring.

W2E3 - Quality Control Magnetic Particle Test in process by R. Kamagai on welded plate build-up (dry method) of Partial Joint Penetration welds, NDE still in progress as QA inspector departed.

W2W1 - In process Post Weld Heat Treat (PWHT) of built up assembly.

T1-1 - Stem to base plate weld in progress, (partial joint penetration weld), reviewed weld technique (WPS SJ-3012-3, joint #7Y-5L-1,2,3) and welder cert (Welder ID 73-4195 and 08-5169) all parameter in compliance to procedure and contract documents, FCAW, 1G position, preheat 110 degrees Celsius was being maintained.

T1-2 - Sitting idle.

T1-3 - Bevel Prep in progress.

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 @ 1(510)385-5910, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
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Reviewed By:	Lanz,Joe	QA Reviewer
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