

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-005783**Date Inspected:** 12-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

Bridge No: 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date 3/12/09, 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 of final machined surfaces.

W2E2 - Moved to Machine Shop and presently performing layout for final machining.

W2E3 - Awaiting QC magnetic particle testing of built up section.

W2W1 - Post Weld Heat Treatment is complete.

T1-1 - Stem to base plate weld in progress, (joint #7Y-5L-1,3 50% complete; 7Y-9L-1, both 20% complete) and (Welder ID 08-5169 and 08-5163,73-4195 respectively), process in use was FCAW, 1G position, Preheat, Amperages maintained to an acceptable level per procedure WPS SJ-3012-3 and contract documents.

T1-2 - Sitting idle, awaiting weld.

T1-3 - Bevel Prep in progress, (Casting being moved from Foundry to Fabrication shop #4).

Accompanied Mr Jay Dorst to Lab to observe mechanical testing of weld coupons (total 3 welders), QC CWI Mr. Kuan performed inspection of bent coupons deemed them acceptable, awaiting report from JSW.

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

WELDING INSPECTION REPORT

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remedial efforts please contact Nina Choy @ 1(510)385-5910, who represents the Office of Structural Materials for your project.

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