

**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-005784**Date Inspected:** 19-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

|                                    |                               |           |            |                                  |                                      |           |            |
|------------------------------------|-------------------------------|-----------|------------|----------------------------------|--------------------------------------|-----------|------------|
| <b>CWI Name:</b>                   | Imai Jomio, Weld Sup, Foundry |           |            | <b>CWI Present:</b>              | <b>Yes</b>                           | <b>No</b> |            |
| <b>Inspected CWI report:</b>       | <b>Yes</b>                    | <b>No</b> | <b>N/A</b> | <b>Rod Oven in Use:</b>          | <b>Yes</b>                           | <b>No</b> | <b>N/A</b> |
| <b>Electrode to specification:</b> | <b>Yes</b>                    | <b>No</b> | <b>N/A</b> | <b>Weld Procedures Followed:</b> | <b>Yes</b>                           | <b>No</b> | <b>N/A</b> |
| <b>Qualified Welders:</b>          | <b>Yes</b>                    | <b>No</b> | <b>N/A</b> | <b>Verified Joint Fit-up:</b>    | <b>Yes</b>                           | <b>No</b> | <b>N/A</b> |
| <b>Approved Drawings:</b>          | <b>Yes</b>                    | <b>No</b> | <b>N/A</b> | <b>Approved WPS:</b>             | <b>Yes</b>                           | <b>No</b> | <b>N/A</b> |
|                                    |                               |           |            | <b>Delayed / Cancelled:</b>      | <b>Yes</b>                           | <b>No</b> | <b>N/A</b> |
| <b>Bridge No:</b>                  | 34-0006                       |           |            | <b>Component:</b>                | Tower, Jacking and Deviation Saddles |           |            |

**Summary of Items Observed:**

On this date 3/19/09, Caltrans OSM Quality Assurance (QA) Inspector, Mike Brcic, was present during the times noted above for observation relative to work performed in Foundry at Japan Steel Works (JSW).

W2E3 - Moved to Fabrication Shop #4.

W2W1 - Magnetic Particle complete, sitting idle.

W2W2 - Waiting for sandblast, idle.

W2W3 - Idle, awaiting repairs of indications removed.

E2E1 - Moved to pit in foundry for dimensional layout.

T1-3 - (Located in Fabrication Shop #4) Buttering, (weld surfacing) of squared cast rib face being performed by welder R. Kato ID 07-4510, using technique SJ-3012-1-1 Rev 2, second layer being started on joint #9S-2U. Procedure is being followed in regards to contract requirements and Special Provisions, (ie. 159 degrees preheat, 254 Amps. witnessed CWI Mr. Kuan actively verifying conditions)

Unless otherwise noted, all observations reported above appear to be in general compliance with applicable contract documents.

**Summary of Conversations:**

No significant conversations were reported on this date.

**Comments**

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# WELDING INSPECTION REPORT

*( Continued Page 2 of 2 )*

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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 for your project.

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| <b>Inspected By:</b> | Brcic,Michael | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Lanz,Joe      | QA Reviewer                 |

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