

**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-005813**Date Inspected:** 18-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>	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

**Component:** Tower, Jacking and Deviation Saddles

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

On this date 3/18/09, 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 - Observed technician, Harum Kohama, (Level II, qualification due 3/31/09) completing Magnetic Particle Testing (MT), utilizing visible red dry powder and an AC only yoke. Technician demonstrated, with 4.53 kg block, efficiency of employed yoke (contour probe). Multiple indications noted by technician. CASTINGS, "Examination-Surface" paragraph in Special Provisions clearly states that dry powder method may only be used, "On as casted surfaces, outside the Level 1 areas." So, there is a potential problem with the use of dry powder, barring any RFI's accepting the method. (Design drawings depicts Level 1 to apply to whole casting minus the ribs)

W2W2 - Repairs completed and ground flush, awaiting Sandblast/final NDE.

W2W3 - Idle, awaiting repairs (indications ground out).

E2E1 - Ultrasonic Testing complete, four (4) locations on bottom surface indications have been ground out and penetrant testing being conducted to verify removal of indication.

T1-3 - Buttering, (weld surfacing) of squared cast rib face being performed by welder K. Shimazawa ID 92-2889, using technique SJ-3012-1-1 Rev 2, first layer being finished. Parameters witness by QAI as confirmed by Fab Shop CWI Mr Kuan, procedure is being followed in regards to contract requirements and Special Provisions.

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# WELDING INSPECTION REPORT

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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**

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
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<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer
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