

**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-005817**Date Inspected:** 20-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Japan Steel Works**Location:** Muroran, Japan

<b>CWI Name:</b>	Kuang Fu Kuan (Fab shop CWI)			<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>

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

On this date 3/20/09, 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, awaiting fit up to built section.

W2W1 - Sitting idle.

W2W2 - Intermediate Stress Relief (ISR) complete. Awaiting sandblast, idle.

W2W3 - Idle, awaiting repairs of indications removed.

E2E1 - Moved to pit in foundry for dimensional layout, currently shaping in progress, (carbon arc).

E2W1 - Four (4) men in process of shaping by grinding the pattern left by carbon arc method of shaping.

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 finished on joint #9S-2U.

Procedure is being followed in regards to contract requirements and Special Provisions, (ie. 161 degrees Celsius preheat, 254 Amps parameters collected by QC Inspector Mr Chung Fu Kuan)

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.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

## 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.

---

<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

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