

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-006135**Date Inspected:** 30-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**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, 3/30/09, Caltrans OSM Quality Assurance (QA) Inspector Mike Brcic was present during the times noted above for observations relative to the work being performed on castings, in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

W2E3 - Still waiting for fit-up to built up section.

W2W1 - Moved to Fabrication Shop #4, (sitting idle)

W2W2 - Being shotblast, NDT of casting is scheduled to begin tomorrow.

W2W3 - Repair welding has commenced, welder H. Sato was in process of preparations repairs identified as #'s 20 through 28 between ribs 1U and 2U. Repair procedure employed was SJ-3026-2. Electrode handling and storage appeared in compliance per AWS A5.5 for LB-106 low hydrogen electrodes.

E2E1 - Casting has been flipped, currently laying out saddle to begin carbon arc.

E2W1 - Idle, sitting at 80% complete.

T1-3 - Buttering procedure (SJ-3012-1-1) followed by welders D. Hirakawa ID 08-3566 (2st layer of joint 9Y-8U) and T Kawagashi ID 08-5026 (1st layer of joint 9Y-12U-3) rod in use is 7016 5mm, heated quivers in use at this time.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations to report on this day.

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.

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