

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-006138**Date Inspected:** 03-Apr-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

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|------------------------------------|---------------|----|-----|
| 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, 4/3/09, 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 and/or Foundry Shop at Japan Steel Works.

QAI reviewed QC CWI Mr Chung Fu Kuan's daily report 4/2 all data entries appears accurate and complete.

W2E3 - Casting section idle, built up section is having small areas on stem plate bevel preparation done by hand (Carbon Arc) due to inaccessibility of automated equipment.

W2W2 - QC NDE technician Mr H. Kohama was in process of conducting Wet Magnetic Particle testing of casted/shaped/blasted Level 1 areas, approximately 75% of the external areas complete, (trough area yet to be started).

W2W3 - Casting is in process of Post Weld Heat Treat (PWHT) following repair weld.

T1-2 - QAI witnessed QCI verify amps and technique of welders Murai 97-2118, M. Yamashita 73-4195, and T. Sudo 03-3082, welding 8Y-12U-3, 8Y-12U2, and 8Y-10U respectively. All weld parameters were found to be in conformance to contract documents and special provisions.

T1-3 - Buttering procedure SJ3012-1-1 was used by welders D. Hirakawa 08-3566, H. Narita 08-5092, T. Kawagishi 08-5026, and T. Mitsui 07-4428, on joints 9Y-11U (3rd layer), 9Y-9U (2nd layer), 9Y-5U-2 (1st layer) and 9Y-12U-1 (1st layer) respectively, all parameters set forth appeared to be met at this time.

E2E1 - No activity, shaping appears to be 75% complete.

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E2W1 - Three men actively grinding, 95% complete.

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

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.

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