

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-006234**Date Inspected:** 13-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 4/13/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

W2E3 - Welder 08-3566 is awaiting casting to come to temperature to begin weld of strongbacks located inside upper trough at position similar to that of tie-rods, areas are appropriately buttered.

W2W2 - Casting Idle. Awaiting Ultrasonic Testing (UT) to begin.

- Built up section; Welder 91-2247 preparing to weld vertical joint W2Y-9V per SJ3011-3, SMAW, 4mm, 3G.

Witnessed QCI, Mr Kuan verify weld parameters of contract documents and special provisions.

W2W3 - Idle, awaiting flip to begin grinding of "Upper" side repair welds.

T1-1 - Sent for blasting after Post Weld Heat Treat process.

T1-2 - Staging being installed due to repositioning (flip) of section.

T1-3 - More layout and preparations are being made to butter areas for temporary lifting lugs, nothing active at this time.

E2E1 - Idle, grinding of carbon arc surface set to begin.

E2W1 - Idle. Ready for NDE testing.

West Jacking Saddle is in #4 Machine shop for rough machining.

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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.

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