

**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-006336**Date Inspected:** 10-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**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, 4/10/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on castings, in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

Reviewed Mr Chung Fu Kuan's most recent Daily Visual Inspection record, the records appear accurate and requirements of the Weld Quality Control Plan are met.

W2E1 - Section is resting on train flatbed outside of Machine Shop #2.

W2E3 - Preparations for joining cast to build up in progress.

W2W2 - Wet Magnetic Particle testing (MT) complete. Awaiting Ultrasonic Testing (UT).

W2W3 - All repairs to "lower" side ground to flush to adjacent surface. Upper side yet to be complete.

T1-1 - Delivered section to undergo Post Weld Heat Treat process.

T1-2 - Welders 08-5153 and 08-5018 are SMAW welding per SJ3012-4 on joints 8Y-12U-1 & 2 and 8Y-12U-2 & 3 respectively utilizing 5mm rod and all pertinent parameters applicable.

T1-3 - All mating surfaces of casting have now been buttered, now layout and preparations are being made to butter areas for temporary lifting lugs.

E2E1 - Riggers were preparing to move to a location for mechanical shaping by way of grinding.

E2W1 - Casting sitting idle. Ready for NDE testing.

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# WELDING INSPECTION REPORT

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QAI witnessed PQR Fillet weld soundness test in Fabrication Shop #4 for FCAW weld of plate to plate (SW-16) and plate to casting (SW-17). Welder 08-5023, 2F position, CO2 gas, Hobart Brothers 1.6mm TM-55 weld wire lot H25343T. JSW report will follow with opportunity to apply Caltrans Lot#'s (see Welding Witness Report TL-6032 dated 4/10/09).

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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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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