

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-006342**Date Inspected:** 21-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroan, 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, 4/21/09, 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 and their associated built up plate sections in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

West Deviation Saddles:

W2E1 - Still located in #2 Machine Shop, having lifting lugs removed by machining/milling process.

W2E2 - Final Machining of section taking place in Machine Shop #2.

W2E3 - Sections are being joined together with strongbacks, in Fabrication #4. Welder G. Tanaka 73-4004 and M. Sainokami 08-5141 are Fillet welding (3F) end plates piece marks 3-17 and 3-4 to cast utilizing FCAW process and an JSW in house procedure. (Cast material is buttered properly).

W2W1 - Cast now in Fabrication Shop #4, awaiting the completion of beveling process, beveling being accomplished manually (grinding) in piece mark 4-2 (stem).

W2W2 - Sitting Idle in Foundry, built up plate portion is idle, with heat being maintained on baseplate, opposing side to stem plate piece mark 5-2.

W2W3 - Cast is idle with blasted surface condition, final NDE of cast is scheduled for next week.

Tower Saddles:

T1-1 - Built up Saddle section is in the #4 Machine Shop being Final Machined.

T1-2 - Fabrication Shop #4, contour grinding of welds occurring at this time, only remaining welding taken place will occur after stress relieving (PWHT), the baseplate will be joining the built up section after a Mill to Bear condition is completed in machine shop.

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T1-3 - Cast section is currently in #4 Machine shop having its buttered surfaces machined. Built up section is resting in #4 Fabrication Shop idle.

East Saddles:

E2E1 - Cast is idle, stage of progression is shaping by way of grinding, still approximately 5% complete.

E2W1 - Volumetric Ultrasonic testing being done to cast section in Foundry by H. Kohama (#86), Longitudinal testing utilizing a dual element straight beam transducer. It appears at this time that all contract documents, special provisions and Weld Quality Control Plan (WQCP) are being met at this time.

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
Reviewed By:	Lanz,Joe	QA Reviewer
