

**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-006402**Date Inspected:** 25-Apr-2009**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1330**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, 4/25/09, 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 the Fabrication shop #4 at Japan Steel Works.

**West Deviation Saddles:**

W2E3 - All 1G position welding appear to have had root pass complete, section is awaiting to be flipped to allow access to opposing side of PJP weld to have root passes completed, per CWI Mr Chung Fu Kuan.

**Tower Saddles:**

T1-2 - QAI witnessed Section being moved into the Heat Treat location for post weld stress relieving.

T1-3 - Casting is having buttered surfaces (radii at cast ribs and stem) machined by hand following the Carbon Arc process. As QAI was beginning rounds, noted three welders beginning the buttering of temporary attach points inside troughs of tower saddle (SJ3012-1-2), when the "break bell" cause them to stop, each had only enclosed the area perimeter with a bead (250mm x 250mm). QAI proceeded to check each location for minimum preheat of 150 degrees Celsius. Upon realizing they had not the required temperature, QAI located QC CWI Mr Chung Fu Kuan who then took immediate action to inform welders of requirements that shall be adhered to. Upon departure all three locations were undergoing a preheat operation. Electrode in use was E7016 5mm. Welders in question were M.Inoui 92-5683, S.Watanabe 08-5159, and T.Watanabe 08-5169, all working to procedure SJ3012-1-2.

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

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# WELDING INSPECTION REPORT

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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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