

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-006407**Date Inspected:** 23-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**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, 4/23/09, 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:

W2E3 - Located in Fabrication Shop #4. Welder S. Watanabe 08-5159, M. Matuda 08-5151 and T. Inoue 08-5163 are Shielded metal arc welding (SMAW) joints E3Y-13U, E3Y-17U and E3Y-12U respectively, in accord with procedure SJ3011-7, contract documents and special provisions. CWI, Mr Chung Fu Kuan verified for QAI, proper values and settings for process and 4.8 mm electrode.

W2W1 - Cast located in Fabrication Shop #4, Buttering process SJ3012-1-2 employed by welder M. Sainokami 08-5141 on upper interior trough at sites intended for temporary attachments. He was beginning a second layer, utilizing 5mm 7016 electrode, as QC CWI Mr Chung Fu Kuan scrutinized his process and settings. All parameters were satisfactory at this time.

Tower Saddles:

T1-3 - Witnessed Casting being transported by way of train from Machine shop #4, presently outside of Machine Shop #2, lands "mill to bear" appear completed at this time.

East Saddles:

E2E1 - Cast is in process of shaping by way of grinding, by one (1) man approximately 20% complete.

E2W1 - Full Volumetric Ultrasonic testing being done to cast section in Foundry by H. Kohama (#86),

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Longitudinal testing, utilizing a dual element, straight beam transducer was in use. Approximately 50% of casting appears to be finished. It appears at this time that all contract documents, special provisions and Weld Quality Control Plan (WQCP) are being met.

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
