

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-006523**Date Inspected:** 29-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, 4/29/09, 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, Japan Steel Works, Muroran, Hokkaido, Japan.

West Deviation Saddles:

W2E3 - Currently two individuals contour grinding of welds (cast to plate built up section) before saddle is inverted for opposing side weld of double bevel Partial Joint Penetration (PJP) welds.

W2W1 - Cast in Fabrication Shop #4. One man completing the fillet welding of the last anti-distortion brace in upper part of trough.

W2W2 - Built up plate portion is being welded, joint W2Y-4L-1, by welder, T.Watanabe 08-5153 using the Shielded Metal Arc Welding (SMAW) process, these passes are the finishing "cap" passes per SJ3011-2, and being deposited in the 2G (Horizontal) position, per applicable contract documents and special provisions.

Tower Saddles:

T1-3 - The built up section has been tacked in place with strong backs at the cast previously buttered locations. The anti-distortion bars, spanning both troughs are being attached by R.Iizuka 06-2643 and R.Katou using the FCAW process and 1.2mm wire.

Observed bend test being conducted by JSW Lab personnel and witnessed by QC CWI Mr Chung Fu Kuan. Weld specimens were of welders Tomoki-Takeshita 08-5024 and Takao-Abiko 73-2320, utilizing Flux Core Arc Welding in the 1G position results were deemed acceptable by QC CWI.

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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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