

**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-006626**Date Inspected:** 01-May-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, 5/01/09, 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 - Welding of Saddle cast rib to plate portion rib per SJ-3011-6/-7 by way of Flux Core Arc Welding with 1.6mm wire is underway by welders K.Kobayashi 08-5023, T. Watanabe 08-5153, T. Ohkawa 03-3091. Joints, respectively, being worked are E3Y-4U-2, E3Y-17U-2, E3Y-17U-1.

W2W2 - Built up plate portion weld joints are welded on one side of the Partial Joint Penetration (PJP) welds, awaiting flip of section to allow access to opposing sides of welds in the appropriate position. Cast is still located in Foundry, in storage.

**Tower Saddles:**

T1-3 - R.Iizuka 06-2643 and M.Kato 08-5018 are depositing root passes on 9Y-12U-3, 9Y-12U-2, cast rib to plate rib, using Shielded Metal Arc Weld (SMAW) process and 5mm E7016 electrode for root. NDT Technician Mr K.Kobayashi #141 standing by to perform dry magnetic particle (MT), of root passes. All weld parameters appear to be met at this time.

Performed Dry Powder MT of selected welds of T1-2 following its Post Weld Heat Treat. The 10% QAI verification completed with no rejects noted. See TL-6028 dated 5/01/09 for process and results.

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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.

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