

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-006692**Date Inspected:** 12-May-2009**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 730**OSM Departure Time:** 1530**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, 5/12/09, 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 and Foundry at Japan Steel Works, Muroran, Hokkaido, Japan.

West Deviation Saddles:

W2E3 - Assembled Section has one (1) man grinding weld profiles in preparation for piece to be turned over.

W2W2 - Cast section is in foundry awaiting transfer. Welder T.Watanabe 08-5153 is FCAW joint W2Y-15L, rib to baseplate per procedure SJ-3011-2 using consumable weld wire TM-95. All parameters appear met at this time.

W2W3 - R.Kito 08-5174 was in process of finishing fit up process with welding temporary strongbacks to excess material on base plate (utilizing SMAW process, 4mm E7016 electrode).

Tower Saddles:

T1-3 - Welder, M.Yamashita 73-4195, was welding joint 9Y-12U-2 with FCAW process with TM-55 1.6mm in a 1G (Flat) position per procedure SJ-3012-5 and contract documents.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
