

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-006759**Date Inspected:** 11-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, 5/11/09, 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 side one of joint E3S-2U in preparation for piece to be turned over.

W2W1 - Welder M.Kashiwada 08-2008 was in process welding joint W1Y-4U-1, end plate to cast end root with E9018M 4mm followed with 4.8 electrode, per procedure SJ-3011-6 and contract document specifications.

W2W2 - Finished joints are having their reinforcement contoured and blended by two men grinding.

W2W3 - Plate build up idle in Fabrication shop 4. Wet Magnetic Particle inspection in process by H.Kohama #86 in Foundry. QAI also completed the ASME Magnetic Particle Verification of Saddle by testing 24 areas, 3000sq mm, areas inside trough, see TL-6028 Report of Magnetic Particle Inspection dated 5/11/2009.

Tower Saddles:

T1-3 - Welder, T.Ohkawa 03-3091 was joining piece mark 9-7 to cast rib, joint 9Y-7U, FCAW process with TM-55 1.6mm in a 1G (Flat) position.

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

WELDING INSPECTION REPORT

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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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