

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-006760**Date Inspected:** 13-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		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	Tower, Jacking and Deviation Saddles		

Bridge No: 34-0006**Summary of Items Observed:**

On this date, 5/13/09, 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 - Welds joining saddle casting and built up section have been ground to a very nice profile and copes have had radii worked as well. No work occurring at this time.

W2W1 - K.Nakasato 91-2247, has begun root passes on non-standard joint W1Y-15U using 4mm E9018M electrode per procedure SJ-3011-7 with Mr. R.Kumagai #132 standing by to perform dry Magnetic Particle (MT) inspection of passes. All weld parameters were verified by QC CWI Mr. C.Kuan.

W2W3 - All plates for built up section are now fit up and tacked in place, welder R.Kito was in process of attaching temporary attachments, strong backs spanning outside ribs, using SMAW process with E7016 electrode in preparation for root passes to begin tomorrow.

TOWER SADDLES

T1-2 - In preparation for attachment to base plate, all plate rib bevels have been ground and MT'd by R.Kumagai #132 prior to the beginning of fit up process.

T1-3 - Four welders in process, all using FCAW 1.6mm TM55 consumable weld wire, per SJ-3012-5 to weld joints 9Y-10U, 9Y-12U-1, 9Y-12U-2, 9Y-12U-3 by H.Mitsumori 81-5438, M.Matudate 08-5151, S.Watanabe

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08-5159, K.Sadakawa 06-2929, respectively. Welding was in compliance with weld procedure and contract requirements.

EAST DEVIATION SADDLES

E2E1 - Four (4) men in process of shaping by way of grinding, appears 85% complete.

E2W1 - Casting has had defects removed (only accessible indications noted by QC NDE personnel). Tomorrow Penetrant and MT of ground excavations will begin.

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
