

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-006765**Date Inspected:** 18-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**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, 5/18/09, 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 - (Saddle welded to its built up plate section) QA Inspector noted the stay bars spanning the outside of Ribs, plate section near cast, had been cut through approximately 90%, in preparation for these distortion control members to be removed. No work was being performed on W2E3 during QA Inspector's review of shop operations.

W2W1 - Joining of Saddle to its built up plate section in process. QA Inspector observed welder H.Mitsumori 81-5438, welding fill passes to joint W1Y-15U using FCAW per procedure SJ-3011-7; welder T.Watanabe 08-5153 was also welding FCAW fill passes to joint W1Y-16U per SJ-3011-7, both individuals were in the 1G (Flat) position. All weld parameters were verified by QC CWI Makhmud Ashadi. These operations continued through to end of QA Inspector's shift.

W2W2 - Saddle Cast section is stowed in Foundry awaiting transfer to Fabrication Shop #4 and the completion of built up plate section. Built up section was observed by QA Inspector as having weld access holes ground by two individuals and prepared for Magnetic Particle inspection by JSW Nikko Inspection personnel. Grinding process was still in process at the end of QA inspector's shift.

W2W3 - Having had all weld repairs and NDE completed, the Cast section rests idle in Foundry Shop. QA Inspector observed Welders Mr. M.Kato 08-5018 and T.Watanabe 08-5169, beginning 2nd passes to the built up

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plate section joints' root utilizing 4.8mm E9018M electrode (SMAW) to joints W3Y-17L-1 and W3Y-4L-2 respectively. Mr. Makhmud Ashadi, performed weld parameter verification to assure requirements of WPS SJ-3012-2 were met.

### TOWER SADDLES

T1-2 - During the QA Inspector's observance of Tower Saddle T1-2, three welders were joining plate stem to base plate, joints 8S-3L, 8S-2L, using E7016 electrode, 5mm, and WPS SJ-3012-2. Welders were K.Kobayashi 08-5023, Y.Watanabe 73-3873, and M.Yamashita 73-4195, respectively. These welding operations continued through to end of QA Inspectors shift.

T1-3 - Saddle is in process of being joined to its built up plate steel section. QA Inspector observed JSW personnel actively changing the slope of the saddle to provide a safe and appropriate angle to which welders will deposit welds. Upon departure saddle section joints were returned to a preheat status.

### EAST DEVIATION SADDLES

E2E1 - QA Inspector noted Casted Saddle section had shaping process complete, which encompasses both carbon arc and mechanical grinding to produce a better surface to complete the NDE processes.

E2W1 - The Casted Saddle section has been flipped over to begin the NDE process to the repair excavations, Dye Penetrant, and Magnetic Particle inspection to assure full removal of indications found during the Ultrasonics inspection process.

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
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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