

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-006866**Date Inspected:** 19-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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, 5/19/09, 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 (Saddle welded to its built up plate section) - K.Nakasato 91-2247, welding joint W1Y-13U using FCAW per procedure SJ-3011-7; welder T.Watanabe 08-5153 was welding W1Y-14U per same procedure. All weld parameters were verified by QC CWI Chung F. Kuan, and continued through QA Inspector's shift.

W2W2 - Saddle Cast section is stowed in Foundry awaiting 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 completed and a final NDE complete, saddle casted section awaits transfer from Foundry to Fabrication shop #4. Built up section, in Fabrication shop #4, welders M.Kato 05-5018 and T. Watanabe 08-5169 were in process of using SMAW process with E9018 electrode, diameter 4mm, 3G position, to weld vertically joints W3Y-11V and W3Y-4V, respectively. These in process welds were being monitored by QC

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Inspector Mr. Chung Fu Kuan and parameters met requirements of WPS SJ-3011-4, contract documents and special provisions.

TOWER SADDLES

T1-1 - Assembled Saddle is currently in No.4 Machine shop being milled/machined inside the South Cable trough.

T1-2 - With base plate now fit up and prepared, QA Inspector has observed welder K.Kobayashi 08-5023 welding joint 8Y-12L-4, rib to base plate with 5mm electrode, SMAW, in accordance with WPS SJ-3012-2.

T1-3 - QA Inspector observed two welders, both using WPS SJ-3012-5 procedure, FCAW process, to weld joints 9Y-12U-2 and 9Y-12U-3 utilizing 1.6mm, TM55 consumable wire. Welders K.Igarashi 92-2226 and S.Hayashi 05-3113, respectively, were meeting the procedure requirements and contract requirements. They were still in process as QA Inspector completed his review of operations.

EAST DEVIATION SADDLES

E2E1 - Shaping process has been completed. QA Inspector was informed by JSW Representative, Mr. Hideaki Kon, the NDE process will probably not begin until next week.

E2W1 - Saddle Casting has been inverted to expose carbon arced repair excavations, to continue the NDE process of verifying removal of earlier noted rejections identified by JSW Nikko Inspection Services personnel.

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
