

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-006871**Date Inspected:** 22-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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, 5/22/09, 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 Fabrication shop #4 and Foundry at Japan Steel Works, Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E3 - Saddle casting is welded to its built up plate section in the Fabrication Shop #4, QA Inspector noted stay bars had been removed with sites of attachment ground smooth. Section is scheduled to undergo Post Weld Heat Treat. No work was being performed on W2E3 during QA Inspector's review of shop operations.

W2W1 - QA Inspector observed welders K. Igarashi 92-2226 and J. Yaegashi 07-2941 welding joint W1S-2U, FCAW process, 1.6mm TM95 wire per SJ-3011-5. All parameters appear met at this time.

W2W2 - Saddle Cast section is located in Machine Shop #2 for a rough dimensional layout. Built up section is having Magnetic Particle inspection by JSW Nikko Inspection personnel completed. No welding or operations scheduled for W2W2 before its Intermediate Stress Relief.

W2W3 - Cast section rests idle in Foundry Shop, no work scheduled on section until it begins its transfer to Fabrication shop #4. While in Fabrication #4, QA Inspector observed welders Mr. M. Kato 08-5018 and T. Watanabe 08-5169, running fill passes to joints W3Y-15L-1 and W3Y-16L-2 respectively. Mr. Chung Fu Kuan, QC CWI, performed weld parameter verification to assure requirements of WPS SJ-3011-2. Process utilized was SMAW 4.8mm E9018M electrode.

TOWER SADDLES

WELDING INSPECTION REPORT

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T1-2 - Tower Saddle T1-2, was suspended upon arrival and relocated to begin welding following a preheat process that was being set up as QA Inspector was departing. No welding would be done for multiple shifts, with a possibility of welding beginning on Saturday evening, per QC CWI Mr Chung Fu Kuan.

T1-3 - Saddle is in process of joint welding to its built up plate steel section, cast stem to plate stem, in Fabrication Shop #4. QA Inspector observed welding taking place to joint 9S-3U by K.Kobayashi 08-5023 and T. Isobe 08-5158, and joint 9S-2U being welded by M.Inoue 92-5683 and S.Hayashi 05-3113, all four welders adhered to criteria established by SJ-3012-5 and parameters were verified by QC CWI.

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. No work was being performed to cast section in Foundry Shop today. JSW Representative Mr. Hideaki Kon informed QA Inspector that the NDE process was to begin on Monday 25 May 2009.

E2W1 - The Casted Saddle section has been flipped over to begin the NDE personnel were in process measuring depth of excavations while at the same time drawing a repair map of saddle section.

WEST JACKING SADDLE - NDE was in process to cast section, on rough machined surfaces, Mr. A.Sieno #82 was scanning the inside trough with a 4 MHz longitudinal 25mm dual transducer, with an A scan display.

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
