

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-006873**Date Inspected:** 23-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**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, 5/23/09, 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 at Japan Steel Works, Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E3 - Saddle section is scheduled to be put through the Post Weld Heat Treat process on or about Monday, 25 May 2009 (per JSW representative Mr. Hideaki Kon).

W2W1 and W2W3 - Mr Chung Fu Kuan, QC CWI, informed QA Inspector these sections will not be welded this shift.

TOWER SADDLES

T1-2 - Upon arrival of QA Inspector at Fabrication shop #4, weld joints were all still under preheat temperatures and being monitored by QC CWI. Shortly thereafter, joint temperatures exceeded the minimum temperature of 110 degrees Celsius, and four welders were given permission to begin joining plate stem to base plate, joints 8Y-5L-3 and -4 by welder Y.Watanabe 73-3873, 8y-5L-1 and -2 by M.Inoue 92-5683, 8Y-11L by T.Watanabe 08-5169 and joint 8Y-9L by S.Hayashi 08-3113, the FCAW process utilizing 1.6mm TM55 consumable wire per procedure WPS SJ-3012-3 and its parameters were being met by all, and verified by QC CWI Mr. Chung Fu Kuan.

T1-3 - Carbon Arc removal of weld tabs was being followed by grinding of weld ends on Tower Saddle located

WELDING INSPECTION REPORT

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in Fabrication shop #4. No welding was planned, nor noted for remainder of shift.

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
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Reviewed By:	Lanz,Joe	QA Reviewer
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