

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-006993**Date Inspected:** 25-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, 5/25/09, 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 - Built up Saddle section is moved to undergo Post Weld Heat Treat process.

W2W1 - As QA Inspector observed welders D.Kito 08-5175 and Y.Maeyama 94-5234 welding joint W1S-2U, FCAW process, 1.6mm TM95 wire per SJ-3011-5, these joints were Cast stem to plate stem. All parameters correct, verified by QC CWI Mr Chung Fu Kuan, during time of walk through of QA Inspector.

W2W2 - Saddle Cast section is located in Machine Shop #2, but is expected to arrive in Fabrication Shop #4 by Tuesday. Built up section is undergoing Intermediate Stress Relief.

W2W3 - Cast section rests idle in Foundry Shop. QA Inspector observed welder Mr. T.Kawakami 08-5079 depositing weld to joints W3Y-2L in Fabrication Shop #4. QC CWI performed weld parameter verification to assure requirements of WPS SJ-3011-2 plate section joints' root, utilizing 4.8mm E9018M electrode, (SMAW) were met.

TOWER SADDLES

T1-2 - During the QA Inspector's observance of Tower Saddle T1-2, four welders were joining plate ribs to base plate, joints 8S-12L-1, 8Y-12L-4, 8Y-7L-2, 8Y-7L-1 using TM55 consumable wire, 1.6mm, and WPS SJ-3012-3.

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Welders were: M.Kashiwada 08-2008, R.Iizuka 06-2643, G.Tanaka 73-4004 and Y.Nakagawa 98-2024 respectively. These welding operations continued through to end of QA Inspector's shift, periodically having operating parameters checked by QC CWI Chung Fu Kuan.

T1-3 - Saddle is in process of being joined to its built up plate steel section in Fabrication Shop #4. QA Inspector observed JSW personnel are in process of removing temporary attachments by way of Carbon Arc followed by grinding. Saddle section and went through another relocation and joints were returned to a preheat status.

EAST DEVIATION SADDLES

E2E1 - Shaped Casted section is observed to have Wet Magnetic Particle inspection process being completed to the as finished surface exterior to the trough by H.Kohama #86, per contract documents and special provisions.

E2W1 - The Casted Saddle section is still having repair excavations tested indications removed and sized.

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:	Peterson,Art	QA Reviewer
