

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-007009**Date Inspected:** 26-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, 5/26/09, 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 has undergone Post Weld Heat Treat process, and now rests outside of oven in Fabrication Shop #4.

W2W1 - QA Inspector observed one JSW individual grinding side #2 of PJP joint W1S-2U, cast stem to plate stem. Upon completion of reinforcement contour of weldment, the saddle will be inverted for joint to be completed.

W2W2 - Saddle Cast section is relocating from Machine Shop #2, and is expected to arrive in Fabrication Shop #4 on or about Wednesday. Built up plate portion has undergone Intermediate Stress Relief and is sitting outside heat treat oven, in Fabrication Shop #4.

W2W3 - Saddle Casting is located in Foundry. Built up portion is changing location, staging built around section, and preheat beginning by the end of QA Inspector's shift.

TOWER SADDLES

T1-2 - During the QA Inspector's observance of Tower Saddle T1-2, three welders were joining plate ribs to base plate, joints 8Y-6L, 8Y-8L, 8Y-12L-3 using TM55 consumable wire, 1.6mm, and WPS SJ-3012-3. Welders were:

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Y.Nakagawa 98-2024, R.Iizuka 06-2643 and M.Kashiwada 08-2008 respectively. By the end of QA Inspector's shift Mr. Iizuka had stopped welding for a different assignment and Mr. Kashiwada resumed welding of joint 8Y-8L (having finished fill passes to joint 8Y-12-3).

T1-3 - Saddle is in process of being joined to its steel plate portion in Fabrication Shop #4. QA Inspector observed two welders working joint 9S-3U, cast stem to plate stem, using FCAW 1.6mm TM55 per WPS SJ 3012-3. Weld variables in use by T.Inoue 08-5163 and D.Kito 08-5175, were within criteria set forth by procedure and contract documents.

EAST DEVIATION SADDLES

E2E1 - Magnetic Particle inspection and Dye Penetrant inspection is complete and saddle casting is awaiting Ultrasonic testing to determine the condition of the as casted saddle, in Foundry Shop.

E2W1 - The Casted Saddle section is through having excavations evaluated, sized and classified. An ECS is being prepared by JSW, per JSW Representative, Mr. Hideaki Kon.

Noted Splay Cover assembly, for E2E1, has begun assembly utilizing an elaborate distortion control plan of Gussets to maintain perpendicular plates to base. QA Inspector noted previous fitup and tack of piece mark 24-3 base to 24-1 plate.

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
