DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-007010
Date Inspected: 27-May-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 730
OSM Departure Time: 1600
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, 5/27/09, 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 section has been sent for cleaning/blast following Post Weld Heat Treat.

W2W1 - QA Inspector noted saddle section undergoing grinding side #2 of PJP joint W1S-2U, cast stem to plate stem. Upon completion of reinforcement contour of weld reinforcement, the saddle will be inverted for joint to be completed.

W2W2 - Saddle Cast section is relocated to Fabrication Shop #4. Built up plate portion has undergone Intermediate Stress Relief and is awaiting cleaning/blast.

W2W3 - Saddle Casting is located in Foundry. Built up portion, plate stem to plate base, is being welded by D. Kito 08-5175 (W3S-2L) and T.Kawakami 08-2008 (W3S-2L) using procedure SJ-3011-1, FCAW, 1.6mm, TM95, consumable wire. QA Inspector observed QC CWI Mr. Chung Fu Kuan reviewing the procedure and verifying both welders' parameters.

TOWER SADDLES

T1-2 - During the QA Inspector's observance of Tower Saddle T1-2, only one welder was in process of welding plate rib to base plate, joint 8Y-8L using TM55 consumable wire, 1.6mm, and WPS SJ-3012-3. Welder was Mr.

M. Kashiwada 08-2008.

T1-3 - Saddle is in process of being joined to its steel plate portion in Fabrication Shop #4. QA Inspector observed welder joining cast stem to plate stem, joint 9S-2U using FCAW process and 1.6mm TM55 consumable weld wire per WPS SJ 3012-5. Mr. Chung Fu Kuan was assuring the weld process was within criteria setforth by procedure and contract documents.

EAST DEVIATION SADDLES

E2E1 - Mr. H.Kohama, #86 NDE Technician, was actively performing UT of the as finished surface of casting in Foundry Shop. Process employed was longitudinal scan of Level 1 and 3 areas utilizing a 2 MHz dual element transducer displaying on an 'A' scan type display.

E2W1 - Per JSW Representative, Mr. Hideaki Kon, an ECS is being prepared by JSW, having identified all Major repair areas/excavations.

WEST JACKING SADDLE - Ultrasonic inspection of casting is complete on all rough machine surfaces. Magnetic Particle inspection is still yet to be complete. Saddle rests in Foundry.

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