

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-007012**Date Inspected:** 02-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2010**Contractor:** Japan Steel Works**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, 6/02/09, 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

W2E2 - Assembly has been returned to Fabrication Shop #4 after having been Final Machined in Machine Shop #2.

W2E3 - Built up Saddle section is currently undergoing AWS Magnetic Particle inspection of welds following its Post weld Heat Treat process. At end of QA Inspector's shift, QAI accompanied JSW Representatives to Fabrication Shop #4. QAI witness NIS personnel acquire replicas of indications previously noted by NIS NDT personnel, the technicians then performed an Acid Etch to determine weld toe of joint E3S-2U between ribs 3-16 and 3-17. Following the etch, JSW personnel began excavating the crack(s) to a maximum depth of 9.5mm. QAI confirmed the removal of the indications and the repair joint was deferred to the following morning. QC Inspector, Mr Chung Fu Kuan, was vigilant during process to help determine cause and correction of defect.

W2W1 - Saddle section is idle in Fabrication Shop #4.

W2W2 - Saddle Cast section is having locations identified for stay bars spanning the trough, buttered per SJ3012-1-2. Process in use by welder R.Kito 08-5174 was SMAW 5mm E7016 electrode in a vertical position. Built up plate portion has been delivered to Machine Shop #2 for layout before groove preparation. Location of W2W2 is Fabrication Shop #4.

W2W3 - Saddle Casting is being relocated, upon completion of move it will begin a preheat process to begin

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welding possibly tomorrow, 3 June 2009.

TOWER SADDLES

T1-1 - QA Inspector observed the tower saddle having had its South cable trough machined in #4 Machine Shop.

T1-2 - JSW personnel were actively welding Saddle section to baseplate at joint 8Y-11L by M. Matuda 08-5151. His process is SJ-3012-3 FCAW 1.6mm consumable wire TM55, all parameters were confirmed acceptable per CWI Mr. Chung Fu Kuan.

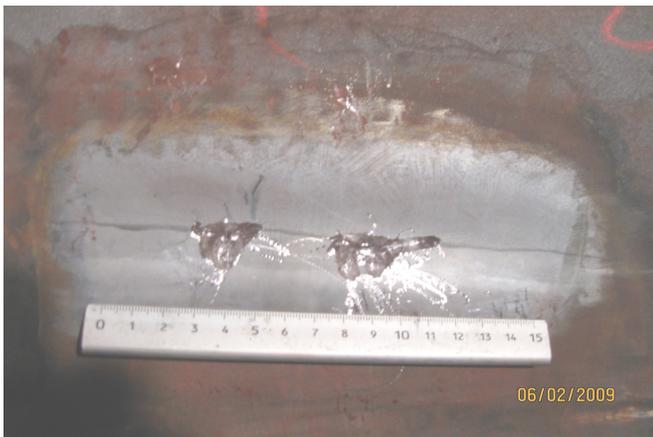
T1-3 - NDE has been performed to saddle in Fabrication Shop #4. QA Inspector was informed that Mr. R. Kumagai #132 had completed MT of weld joints, all but the base plate joints have been welded.

EAST DEVIATION SADDLES

E2E1 - Saddle casting is undergoing defect removal on the ID'd side of the casting, within the Foundry. Per JSW representative Mr. Hideaki Kon, it is expected to begin an NDE process on the excavations on Thursday, 4 June, 2009. Splay cover plate section is being fit up and welded in the Fabrication Shop #4 by M. Yamashita 73-4195 per SJ-3177-1, 1G position, SMAW, 4mm E7016 electrode.

E2W1 - While located in the Foundry, casting is awaiting ECS to begin weld repairs. In Fabrication Shop #4, Bearing plate 21-1, has had Piece mark 21-4, blocks, tack welded in place by welder Y. Ohta 08-2017.

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.

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Inspected By:	Brcic,Michael	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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