

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-007052**Date Inspected:** 29-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**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, 5/29/09, 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 in its second day of Magnetic Particle (MT) inspection in Fabrication shop #4. Identified indications are being ground for further evaluation. Technician Mr. R.Kumagai #132 was through testing for the evening and did not return during QA Inspector's shift.

W2W1 - Saddle section, joined, cast to plate section, is in Fabrication Shop #4. Joint W1S-2U, which joins the plate stem to Cast stem is now having its reinforcement contour ground in preparation for Magnetic Particle (MT) inspection. Grinding continued through QA Inspector's shift.

W2W2 - Saddle Cast section is resting idle adjacent its plate section. Built up plate portion has been shot blasted and has had its first round of MT completed, JSW personnel were actively grinding indications identified by Nikko Inspections Service (NIS) technicians.

W2W3 - Saddle Casting is located in Foundry, idle. Built up portion is being welded by T.Inoue 08-5163 and D. Kito 08-5175, joint W3S-2L, plate stem to base, FCAW, both running consumable wire 1.6mm TM95, process was per SJ-3011-1, the welding continued, with CWI Mr. Makhmud Ashadi performing checks to verify parameters of procedure periodically, through to end of QA Inspector's shift.

TOWER SADDLES

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T1-2 - During the QA Inspector's review of Fabrication Shop #4, JSW personnel were actively rotating the Saddle section. CWI Mr. Chung Fu Kuan stated to QA Inspector no welding would be done prior to AM.

T1-3 - NDE has been performed to saddle in Fabrication Shop #4. QA Inspector was informed that Mr. M.Sato #81 had just completed UT of joint 9Y-5U-1, -2, -3. QAI was unable to ascertain results at this time.

EAST DEVIATION SADDLES

E2E1 - Ultrasonic testing, by Mr. H.Kohama #86, is expected to be complete today in Foundry Shop. QA Inspector observed technician utilize a 45 degree shear wave, 2MHz transducer, on "as finished" surfaces outside trough.

E2W1 - Casting is awaiting ECS to begin weld repairs. Splay plate fit up continues, currently only one plate to base has been tacked in place.

West Jacking Saddle - Non-Destructive Inspection of Rough Machined Surfaces has been completed, next process is Shaping of as casted surface by way of Carbon Arc.

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:	Peterson,Art	QA Reviewer
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