

**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-007060**Date Inspected:** 05-Jun-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, 6/05/09, 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 (JSW), Muroran, Hokkaido, Japan.

**WEST DEVIATION SADDLES**

W2E2 - Saddle Section is idle in Fabrication shop #4.

W2E3 - While awaiting disposition of repair of joint E3S-2U, saddle section has been forwarded on to No.4 Machine Shop for final machining.

W2W2 - QC Mr Chung Fu Kuan, informed this QA Inspector the locations for lifting lugs on ends will be beginning in a day or so, in Fabrication Shop #4.

W2W3 - Saddle Casting is idle in Foundry. CWI QC Inspector Mr. Chung Fu Kuan is overseeing welders T. Inoue 08-5163, M.Kashiwada 08-2008 as they were welding joints W3Y-14V, W3Y-15V (respectively) using FCAW, TM95 in the 1G position. This same QA Inspector observed second shift QC CWI Mr. Makhmud Ashadi as he made his rounds verifying parameters of these welders assuring compliance to procedure SJ-3011-3.

**TOWER SADDLES**

T1-2 - This Tower saddle structure, having been joined its plate section and gone through PWHT, is now being welded to its plate base, welders actively depositing were T.Kawakami 08-5079, D.Kito 08-5175 and M.Kabota 74-3666, joints assigned were 8S-2L, 8S-3L (Kito and Kabota). QC CWI Mr. Chung Fu Kuan randomly assured

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compliance to procedure SJ-3012-3, FCAW process utilizing consumable wire TM55 in the 1G position.

T1-3 - Saddle structure (minus its base plate) has been Intermediate Stress Relieved (ISR) and is currently located outside the oven in Fabrication Shop #4.

## EAST DEVIATION SADDLES

E2E1 - Saddle casting is having excavations, on ID'd side of the casting, mapped and measured in the Foundry. The QA Inspector conducted Ultrasonic inspection of a previously QC accepted, CJP joint, created by plate pc mk 24-3 and base plate pc mk 24-1 in Fabrication Shop #4. Results and testing parameters can be review on UT report UTR-mbrcic-000001.

E2W1 - Japan Steel Works (JSW) has received approval to go ahead with repairs to both major and minor classified repairs per ECS BG-ECS-08-030 and -031, weld repairs will begin Monday, per Mr. Hideaki Kon representative of JSW. In Fabrication Shop #4, Bearing plate is idle at this time.

West Jacking Saddle has one JSW personnel actively shaping by way of Carbon Arc, in Foundry, approximately 35% complete.

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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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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