

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: 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-007081**Date Inspected:** 08-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, 6/08/09, 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**

W2E1 - QA Inspector noted Saddle Section being prepared for welding in Fabrication shop #4. Per JSW representative, Mr. Hideaki Kon, the repair of joint E1Y-5U is scheduled for mid day tomorrow, 6/9/09.

W2W2 - Welder Mr. M.Inoue 92-5683 is buttering (surfacing cast material) the right end of Cast, exterior the trough, in preparation for weld of lifting lugs in Fabrication Shop #4. Procedure randomly monitored by QC CWI Mr. Chung Fu Kuan was SJ-3012-1-2, SMAW E7016 electrode, depositing material in a horizontal pattern.

W2W3 - Saddle Casting is idle in Foundry. In the Fabrication Shop #4, CWI QC Inspector Mr. Chung Fu Kuan informed this QA Inspector of the fact that no welding was intend to be done on the built up section until C shift (24:00 to 08:00).

**TOWER SADDLES**

T1-2 - This Tower saddle structure, located in Fabrication Shop #4, is presently being relocated to continue welding of baseplate to rest of Saddle section.

T1-3 - Following Post Intermediate Stress Relief Cleaning, JSW QC Inspectors are preparing to performing Dry Magnetic Particle Inspection of completed welds, per QC CWI Mr. Chung Fu Kuan. Saddle section is located in

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# WELDING INSPECTION REPORT

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Fabrication Shop #4.

## EAST DEVIATION SADDLES

E2E1 - Saddle casting is undergoing defect removal to 2nd side, the ID'd side in the Foundry shop. Splay plate cover was under preheat, but no welding at this time.

E2W1 - Saddle casting has been moved to a weld pit, placed under fire proof blankets and per JSW Representative Mr. Hideaki Kon, welding is expected to commence during C shift (2400~0800). In Fabrication Shop #4, JSW fitter is placing C channels, pc mk's 21-2 and 21-3, in place for fit up on Bearing plate 21-1 is time.

West Jacking Saddle has one JSW personnel actively shaping by way of Carbon Arc, in Foundry, approximately 45% complete of side opposite the ID.

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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