

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-007115**Date Inspected:** 11-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, 6/11/09, 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 and W2E2 ~ QA Inspector noted area on casted portion of assembled section identified as having the been wet magnetic particle tested between end rib 1-17 and rib 1-14 (W2E1), and end plate 2-4 and rib 2-7 (W2E2) to fulfill requirements of ABF-RFI-1703, results to follow.

W2W2 ~ Cast section is in Fabrication Shop #4. The built up plate portion, which is located adjacent its mating Casting, is having bevels cut by way of Oxygen and Propane automated rig on tracks. JSW employee, Mr. K. Minami has completed two ribs and is currently working on the end plate. This process continued through QA Inspector shift.

W2W3 ~ Saddle Casting is idle in Foundry. CWI QC Inspector Mr. Makhmud Ashadi randomly verified parameters described in procedure SJ-3011-2 as welders M.Kato 08-5018 and T.Watanabe 08-5169 welded joints W3Y-5L, W3Y-6L respectively, with FCAW process and TM95 consumable weld wire.

TOWER SADDLES

T1-2 ~ QA Inspector noted Tower saddle structure was undergoing repositioning in preparation for stiffener plate fit up.

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T1-3 ~ Nikko Inspection Service technician, Mr. R.Kumagai is continuing test of saddle utilizing a magnetic particle, continuous method, Dry (red) powder, with AC current magnetization applied by contour probe.

EAST SADDLES

E2E1 ~ Saddle casting is undergoing defect grinding to excavations to side opposite the ID in the Foundry shop. In Fabrication Shop #4, Splay plate cover is sitting idle.

E2W1 ~ Welders, H.Sato 69-2697 and H.Onodera 93-2272 are continuing repair of excavations per repair ECS. Parameters of procedure SJ-3026-4 are being randomly monitored by Weld Engineer Mr. T.Imai in Foundry. In Fabrication Shop #4, welder, Mr. K.Kobayashi 08-5023, was finishing joint on Splay Cover plate #24-1 base to plate 24-2. CJP was being welded with SMAW process and 4mm(followed by 5mm) E7016 electrode. Mr. Chung Fu Kuan, QC CWI randomly assure compliance to procedure SJ-3177-1.

West Jacking Saddle is being relocated prior to finish of this side, shaping will then resume in Foundry, 48% complete. The Casting has been inverted for the shaping to now begin again.

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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