

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-007160**Date Inspected:** 15-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:	Pin-Tang Hsu		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	Tower, Jacking and Deviation Saddles		

Bridge No: 34-0006**Summary of Items Observed:**

On this date, 6/15/09, 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 in the Foundry and associated built up plate sections in the Fabrication shop #4, Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2W1 ~ Casting has had stay bars, that span rib to rib lengthwise, removed by JSW technician K.Koyanagi 08-5144, removal process was by Oxygen/Propane cutting torch. Upon removal, Mr. Y.Ohta is grinding the remaining rough cut condition to a smooth surface. Assembled saddle is awaiting completion of Magnetic Particle (MT) testing by Nikko Inspection Services.

W2W2 ~ Cast section is in Fabrication Shop #4 having been inverted and all 4 lugs welded, two at each end of the casting. The built up plate portion, which is located adjacent its mating casting, is having bevels cut, all but 4 plate ribs are completed. The process did not resume during QA Inspector's review of shop operations.

W2W3 ~ Saddle Casting is observed as idle in Foundry. The QA Inspector observed JSW personnel grinding the reinforcement for inspection and carbon arc removal of run off tabs. No welding occurred during A Shift, on this plate section for W2W3 in Fabrication Shop #4.

TOWER SADDLES

T1-2 ~ Tower Saddle is now completely welded to its base plate, and is undergoing extensive grinding to all the

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reinforcements in preparation for MT and Ultrasonic testing of the Complete Joint Penetration (CJP) welds.

T1-3 ~ Observations noted on this day by the QA Inspector was of Mr. R.Kumagai #132, NIS Level II inspection technician, completing the post ISR MT of all welds and copes (minus the welds not yet accomplished joining the base plate). This testing was observed in the Fabrication Shop #4.

EAST SADDLES

E2E1 ~ It was noted by this QA Inspector one individual was mapping out excavations for the future report identifying repair locations. Per JSW Representative Mr. Hideaki Kon, excavations are still undergoing grinding to remove indications noted by visible Dye Penetrant and visible wet MT inspection methods.

E2W1 ~ Welders, Y.Kabutomori 06-8000 is performing weld repair of excavations per procedure SJ-3026-4, using SMAW process and 5mm E9016 electrode. The process in the Foundry of repairing the excavation are being monitored by JSW Weld Engineer Mr. T.Imai. In Fabrication Shop #4, bearing plate to MC style channel (21-3-2) is being welded by Y.Watanabe 73-3873, as well as Splay plate cover plate 24-2 to its base by M.Kato 08-5018. Mr. Pin-Tang Hsu, QC CWI, is randomly monitoring these weld functions through the QA Inspector's shift, all parameters of procedures SJ-3177-4 and SJ-3177-2 (respectively) appear met at this time.

West Jacking Saddle ~ Section has been observed by QA Inspector as having completed the shaping of the ID'd side of the casting. JSW personnel now await the flip of this cast section to continue with Carbon Arc process.

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
Reviewed By:	Peterson,Art	QA Reviewer
