

**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-007249**Date Inspected:** 16-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

<b>CWI Name:</b>	Pin-Tang Hsu		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

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

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

On this date, 6/16/09, 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 Foundry and the associated built up plate sections in the Fabrication shop #4 and at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

**WEST DEVIATION SADDLES**

W2W1 - JSW personnel are grinding the locations of former stay bars and weld reinforcements. Assembled saddle is awaiting completion of Magnetic Particle (MT) testing by Nikko Inspection Services.

W2W2 - Cast section is in Fabrication Shop #4 in preparation for fit up to the built up plate portion, which is located adjacent its mating casting, having bevels cut on the stem, areas at plate ribs are required to be beveled by hand grinding due to inability of track automated equipment to reach stem in those areas. The process did continue through QA Inspector's shift.

W2W3 - Saddle Casting is observed as idle in Foundry. Built up section undergoing contour grinding of reinforcements in Fabrication Shop #4.

**TOWER SADDLES**

T1-2 - Tower Saddle is now completely welded to its base plate, and is undergoing MT of all welds and Ultrasonic testing of the Complete Joint Penetration (CJP) welds. Mr. R. Kumagai, Level II UT, #132, and associate NIS inspector were in process UT of joint 8Y-5L-1 using 60 degree shear wave transducer by way of an

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# WELDING INSPECTION REPORT

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AWS Snail wedge. OSM/Mets QA Inspector, Mr. M.Brcic, arrived to perform 10% verification UT inspection of welds previously inspected by QC inspectors, but was informed by Mr. Kobayashi of NIS team, that the Tower Saddle was not complete, and therefore not ready for QA's verification inspection.

T1-3 - QA Inspector observed results of MT inspection by QC NDE personnel in Fabrication Shop #4 as having been marked up as requiring grind on 85% of welds. Results of MT inspection by QC NDE personnel are still pending.

## EAST SADDLES

E2E1 - In the Foundry it was noted by this QA Inspector one individual was grinding out excavations for removal of indications noted by PT and MT. Observed welder R.Iizuka 06-2643 performing SMAW per procedure SJ-3177-1 on plate 24-5 to base plate 24-1 using 5mm E7016 electrode. Parameters of procedure were randomly verified by QC CWI Mr. Chung Fu Kuan.

E2W1 - Welders, Y.Kabutomori 06-8000 is performing weld of Major repair identified as 4-2 in ECS ABF-SUB-000643R14 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 is being joined to 21-2 MC channel by welder T.Inoue 08-5163. Welder was being monitored Mr. Pin-Tang Hsu, QC CWI, as he met the criteria set forth by SJ-3177-4.

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.

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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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