

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-007250**Date Inspected:** 17-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:** Weld Engineer T. Imai**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, 6/17/09, 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

W2E1 - This QA Inspector, M. Brcic, completed the QA 10% verification MT inspection of casted portion of this West Deviation Saddle. Magnetic Particle method, results, specifics are reported on MPT-mbrcic-000009.

W2E2 - Built up saddle section is scheduled for Wet MT 10% verification inspection tomorrow 6/18/2009.

W2W2 - Cast section is now in Fabrication Shop #4. Built up plate portion located adjacent its mating casting, having bevels cut on the stem, areas at plate ribs are being beveled by hand grinding due to inability of automated track equipment to reach areas on stem. The process continued through QA Inspector's shift.

W2W3 - Saddle Casting is observed on rail car outside QA office spaces. Built up section undergoing contour grinding of reinforcements in Fabrication Shop #4.

TOWER SADDLES

T1-2 - While located in Fabrication Shop #4 base plate CJP welds' UT indications are still under review for completeness for reporting by QA NIS technicians.

T1-3 - Observations by QA Inspector are earlier welds identified by NIS MT Technicians, have been ground at

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sites identified as indications or conditions requiring grinding. Report expected to follow from NIS technicians of this NDE inspection. These observations were made in the Fabrication Shop #4.

EAST SADDLES

E2E1 - In the Foundry it was noted by this QA Inspector one individual was mapping the saddle excavations for a final classification. Observed welder M.Kato 08-5018 performing SMAW per procedure SJ-3177-1 on plate 24-5 to base plate 24-1 using 5mm E7016 electrode following back gouge MT conducted by R.Kumagai #132 NDE technician. Parameters of procedure were randomly verified by QC CWI Mr. Chung Fu Kuan.

E2W1 - Welders, Y.Kabutomori 06-8000 is continuing weld of large Major repair area 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 is being monitored by JSW Weld Engineer Mr. T.Imai. In Fabrication Shop #4, bearing plate fillet is being ground on the fillet.

West Jacking Saddle - Section has been flipped and now undergoes carbon arc shaping to the second side of the casting in the Foundry.

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
