

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-007310**Date Inspected:** 19-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, 6/19/09, 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 - In Fabrication Shop #4, the assembled Saddle is idle.

W2E2 - As QA Inspector conducted his walk through of Fabrication shop #4 it was noted that the Identifying stamp of the assembled saddle is located on wrong side of casting. Because the saddle is symmetric, traceability of plates, welds to welders is rendered impossible after blast and paint.

W2W2 - Cast section is now placed atop its built up section, awaiting fitup inspection by QC personnel.

W2W3 - Saddle Casting is located in No. 2 Machine shop. Built section is under scrutiny by NIS inspectors using the dry Magnetic Particle continuous method per SF-MT-01 rev 1.

TOWER SADDLES

T1-2 - While located in Fabrication Shop #4, stiffener plates 8ST-28, -29, -30 were being welded by welder M. Kashiwada 08-2008, T.Kawakami 08-5079, T.Inoue 08-5163, respectively, using FCAW weld wire 1.6mm TM55, and procedure SJ-3012-3. After the start of B shift the following welders assumed the duties and responsibilities, M.Inoue 92-5683, K.Kobayashi 08-5023 and J.Yaegashi 07-2941 respectively, the weld parameters and the

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monitoring were continued, randomly verified by QC CWI Mr. Pin-Tang Hsu.

T1-3 - Saddle structure, minus baseplate, has been sent out for machining process of mill to bear.

EAST SADDLES

E2E1 - One JSW NDE technician continues the mapping and classification of excavations on casting located in Foundry.

E2W1 - Casting has had repairs completed, per JSW representative Mr. Hideaki Kon, and forwarded to Heat Treat Shop for Post Weld Heat Treat. In Fabrication Shop #4, the Splay Plate Cover is idle.

West Jacking Saddle - Cast Section continues carbon arc shaping to casting in the Foundry by one individual.

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
