

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-007387**Date Inspected:** 20-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Japan Steel Works**Location:** Muroran, Japan

CWI Name:	Chung Fu Kuan		
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, 6/20/09, 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 at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E1 ~ In Fabrication Shop #4, the assembled Saddle is idle.

W2E2 ~ Casting awaits Wet MT inspection performed by casting NDE department of the final Machined surfaces, scheduled for Monday 6/22/2009.

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

TOWER SADDLES

T1-2 ~ While located in Fabrication Shop #4, stiffener plates 8ST-25, -26, -27 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. The weld parameters and the monitoring was randomly verified by QC CWI Mr. Chung Fu Kuan. Following review of shop welding operations, this QA Inspector, performed a 10% weld UT verification of CJP joints on T1-2 saddle, results as well as all parameters used can be viewed on TL-6027 dated 20 June 2009.

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EAST SADDLES

E2E1 and E2W1 ~ Welder K.Nakasato 91-2247, in Fabrication Shop #4, is actively welding multiple diaphragms between plates making up the Splay Plate Covers. Welder utilized SMAW 4mm for root and 5mm for fill, adhering to procedure SJ-3177-3 and verified by Mr. Chung Fu Kuan, QC CWI.

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
