

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-007388**Date Inspected:** 22-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, 6/22/09, 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 Foundry at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

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

W2E2 ~ This QA Inspector, M.Brcic, completed the QA 10% verification MT inspection of casted portion of this West Deviation Saddle. Magnetic Particle method, results and specifics are reported on TL-6028 dated 22 June 2009. It was also noted, JSW Casting department NDE technician, H.Kohama #86, was also performing a Post machining Wet MT of Saddles end faying surfaces, remainder machine surfaces in trough are scheduled to be completed tomorrow.

W2W1 ~ Assembled Section has been sent for Post Weld Heat Treat PWHT.

W2W2 ~ Two welders currently active performing SMAW process to cast stem to plate stem, joint W2S-2U. Per procedure SJ-3011-5, Mr. T.Watanabe 08-5153 and S.Watanabe 08-5159, were depositing root passes with 4mm E9018 electrode.

W2W3 ~ Saddle Casting is located in No. 2 Machine shop. Built section is undergoing Intermediate Stress Relief of plate to plate welds.

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TOWER SADDLES

T1-2 ~ While located in Fabrication Shop #4, stiffener plates 8ST-22 and 8ST-24 are being welded by welders M.Yamashita 73-4195, M.Matudate 08-5151 respectively, using SMAW 4mm E7016 electrode and procedure SJ-3012-8-1. The weld parameters and the 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 and groove preparation.

EAST SADDLES

E2E1 ~ Classification of excavations, after mapping process was completed, is being determined for ECS on casting repairs, located in Foundry. In Fabrication Shop #4, the Splay Plate Covers for both East Saddles are being MT'd by NIS Technician K.Kobayashi #141

E2W1 ~ Casting has had repairs completed, per JSW representative Mr. Hideaki Kon, and has been post weld heat treated. Currently is being ground and blasted. Bearing plate is being dimensionally checked by NIS technician K.Kobayashi #141.

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
