

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-007394**Date Inspected:** 23-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, 6/23/09, 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

W2E2 ~ JSW Casting department NDE technician, H.Kohama #86, was performing a Post machining Wet MT of Saddles trough. The inspection was completed, results to follow in report submitted by JSW QC personnel in Foundry.

W2W1 ~ Assembled Section has now been Post Weld Heat Treated and is just outside oven awaiting ambient temperature and then shot blast cleaning.

W2W2 ~ QA Inspector observed multiple welders work throughout his shift on the Cast Stem to Plate Stem, joint W2S-2U. First welders were S.Watanabe 08-5159, T.Watanabe 08-5153 and M.Matudate 08-5151, then Mr. T.Watanabe and M.Matudate were replaced by T.Inoue 08-5163 and T.Kawakami 08-5079. All followed procedure SJ-3011-5 as they used SMAW process, 4.8mm E9018 electrode with the first wave being monitored by QC CWI Mr. Chung Fu Kuan and second by CWI Pin-Tang Hsu.

W2W3 ~ Saddle Casting is located in No. 4 Fabrication Shop. Built up Plate Section has now been Intermediate Stress Relieved and is outside oven awaiting ambient temperature and then shot blast.

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TOWER SADDLES

T1-2 ~ While located in Fabrication Shop #4, 150mm stiffener plates 8ST-19, 8ST-20 and 8ST-21 are being welded by welders Y.Maeyama 94-5234, H.Mitsumori 81-5438, R.Kito 08-5174, respectively, using FCAW TM55, 1.6mm consumable wire and procedure SJ-3012-8-2. The weld parameters and the monitoring, randomly verified by QC CWI Mr. Pin-Tang Hsu.

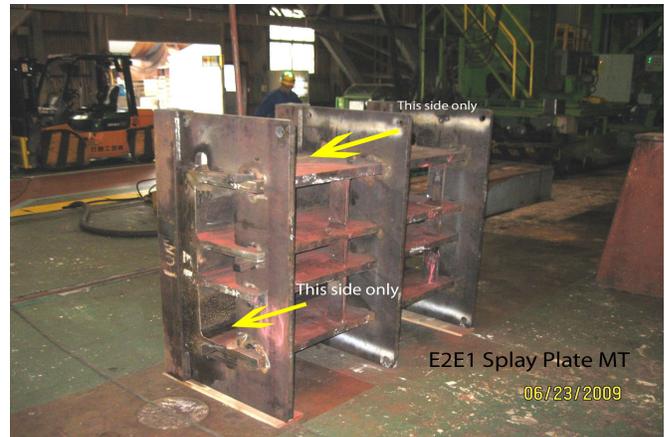
EAST SADDLES

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 QA Inspector, to fulfill the 10% verification inspection of previously inspected welds by QC. Results and method can be reviewed on TL-6028 Report of Magnetic Particle Inspection dated 6/23/2009. Attached are digital photographs that depict exactly the cover orientation and side of weld under examination.

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 was idle in Fabrication shop #4.

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

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Reviewed By: Peterson, Art

QA Reviewer