

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-007453**Date Inspected:** 25-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, 6/25/09, 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 associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2E2 ~ Completed section is in process of relocation in Fabrication shop #4, as observed by the QA Inspector.

W2W1 ~ Assembled Section has now been Post Weld Heat Treated and back in Fabrication Shop #4 as it awaits cleaning by shot blasting.

W2W2 ~ QA Inspector observed welders S.Watanabe 08-5159 and M.Matudate 08-5151 welding joints W2Y-17U-2 and W2Y-14U while following procedure SJ-3011-7, as they used SMAW process, 4.8mm (4mm for vertical and root welds) E9018 electrode with all parameters monitored by QC CWI Mr. Chung Fu Kuan and later by CWI Pin-Tang Hsu. The addition of T.Inoue 08-5163 welding W2Y-10U (side 2 of weld) SMAW cast rib to plate rib with parameters established by procedure SJ-3011-6, was after the start of "B" shift.

W2W3 ~ Saddle Casting is located in No. 4 Fabrication Shop. Built up Plate Section, having now been through Intermediate Stress Relief (ISR), was observed by QA Inspector awaiting shot blast cleaning, then layout, also in Fabrication Shop#4.

TOWER SADDLES

WELDING INSPECTION REPORT

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T1-2 ~ While located in Fabrication Shop #4, 150mm stiffener plates 8ST-20 and 8ST-21 are being welded by welders T.Watanabe 08-5153 and M.Yamashita 73-4195, using FCAW 1.6mm, TM55 consumable wire and procedure SJ-3012-8-2. Welder T.Ohkawa 03-3091 was depositing a root pass on stiffener 8ST-23 using SMAW 4mm E7016 electrode, the start of "B" shift had welder T.Kawakami 08-5079 begin 8ST-23's fill passes with FCAW TM55 1.6mm weld wire. The weld parameters and the monitoring were continued, randomly verified by QC CWI Mr. Pin-Tang Hsu.

T1-3 ~ Saddle with its plate portion as one section, is now having bevels intended for joints to base plate ground to a final angle and condition. JSW technician Mr. Minami ended his shift (1600) with no further bevel preparation to be done today.

EAST SADDLES

E2E1 ~ ECS on casting repairs has been drafted and released for approval, cast awaits in Foundry. Splay plate cover has been sent out for Post Weld Heat treat. Bearing plate has had blocks 20-4 (qty 21) tacked in place by Fitter K.Koyanagi 08-5144.

E2W1 ~ Per QA Inspector's observance the cast section is in Foundry currently being ground mechanically at its repair locations. Splay plate cover has also been sent out for Post Weld Heat Treating. Bearing plate was sent to Machine shop #2 for layout.

West Jacking Saddle ~ Cast Section is being carbon arc shaped 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
