

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-007455**Date Inspected:** 27-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:** Muroan, 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, 6/27/09, 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), Muroan, Japan.

WEST DEVIATION SADDLES

W2E1 ~ This Caltrans QA Inspector performed a VT of casting condition of this Deviation Saddle, with the following results: 1) Surface condition exceeding Scrata comparator A3 exists between rib 4-U and 5-U, within the first 500mm from machined top of trough, in radius of rib 4-U. 2) Mechanical dressing/tooling marks exceeding requirements of Scrata comparator H4 exists between rib 3-U and 4-U in a inclusive manner. See attached photos.

W2E2 ~ QA Inspector intended to perform VT of Cast portion, but the assembly was positioned on its side in the fabrication shop #4, no accessibility.

W2W2 ~ QA Inspector observed welders S.Watanabe 08-5159 following procedure SJ-3011-7 as he used SMAW process, 4.8mm E9018 electrode with all actions monitored by QC CWI Mr. Chung Fu Kuan.

TOWER SADDLES

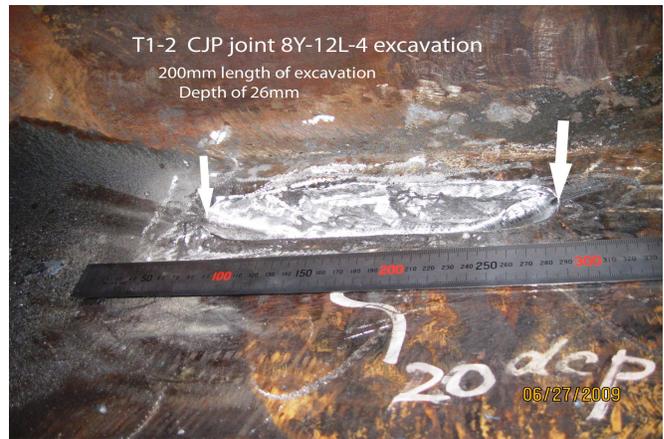
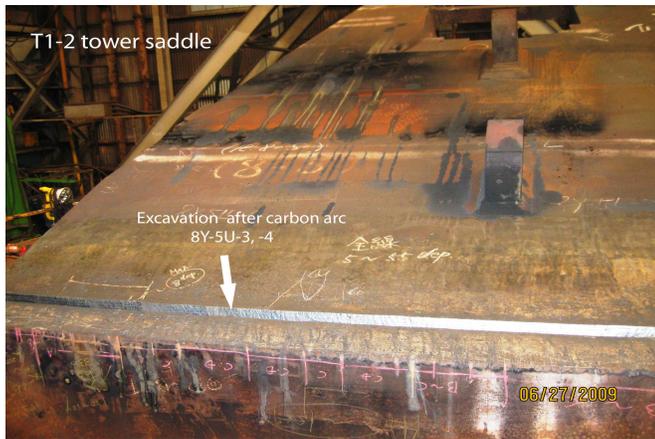
T1-2 ~ Upon arrival of QA Caltrans Inspector Mr. Mike Brcic, joint 8Y-5L-3 and -4 was already carbon arc'd, now awaiting grinding and MT to verify indication removal. Excavation extended full length due to QC NDE personnel identifying the defect by Ultrasonic method of examination, reported on weld report submitted by JSW

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

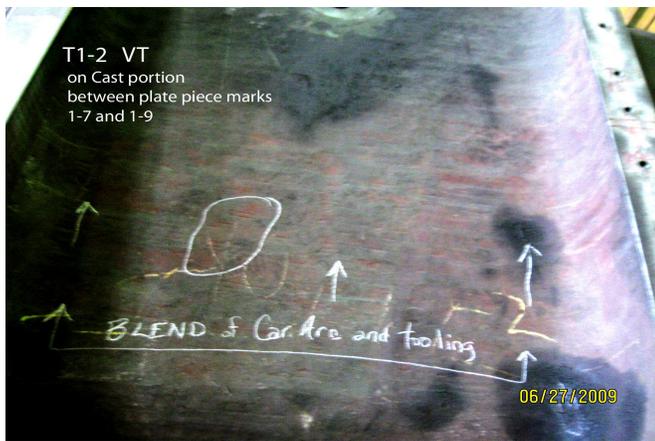
for the week of 6/21 ~ 6/27. By mid day JSW personnel had ground joint repair bevels to 8Y-5L-3 and -4. They also ground out the indication noted originally by QA Inspector, Mike Brcic in joint 8Y-12L-4. See digital photos attached. Neither excavations have been confirmed defect free by MT at this time. Welders T. Ohkawa 03-3091 and T. Watanabe 08-5153 were actively welding stiffener plates 8ST-21 and 8ST-20 respectively, FCAW process with 1.6mm TM55 weld wire. Parameters were monitored before welder began and on a random basis thereafter by QC CWI Mr. Chung Fu Kuan.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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