

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-007485**Date Inspected:** 03-Jul-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, 7/03/09, 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 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2E2 - Final Dimensional inspection by JSW contracted personnel is in process in the Fabrication Shop #4.

W2E3 - Saddle has been located in Machine Shop 2 awaiting final machining.

W2W1 - In Fabrication Shop #4 this saddle is awaiting MT to weldments, now that it has been through Post Weld Heat Treat, by QC NIS personnel.

W2W2 - Requires relocation / repositioning to continue welding opposing side of weld joints. Prior to movement, JSW personnel are contour grinding the welds while these joints are still accessible.

W2W3 - Welder, Mr D.Kito had just finished for his shift ending at 1600, but as this QA Inspector observed, his buttering, first layer, had occurred on left end of saddle casting at location intended for lifting lug. His procedure, monitored by QC Mr Chung Fu Kuan, was SJ-3012-1-2, and process was SMAW 4mm E7016 electrode.

TOWER SADDLES

T1-2 - As the saddle rests in Fabrication Shop #4, the stiffener plates are being welded by M.Matuda 08-5151 and S.Watanabe 08-5159, stiffener plate 8ST-13 is being welded by both individuals. Procedure is SJ-3012-3, and

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applicable process is FCAW using 1.6mm TM55 consumable weld wire. Parameters were monitored on a random basis by QC CWI Mr. Chung Fu Kuan and later, (after 2000), by CWI Mr. Pin-Tang Hsu.

T1-3 - Fitup of saddle section to base in Fabrication Shop #4 is underway with strongbacks being positioned and tack welded for distortion control.

EAST SADDLES

E2E1 - Cast section awaits JSW to commence the approved repair to major and minor excavations per ECS (as it sits in the Foundry). End Splay Cover plate fixture is in process of PWHT NDE by QC NIS personnel. UT being performed by M.Sato #81 and MT by R.Kumagai #132 of Nikko Inspection Services.

E2W1 - Casting has had weld repair reinforcements carbon arc'd followed by mechanical grinding and now awaits blast cleaning to prepare repairs for NDE, in Foundry.

West Jacking Saddle - Cast Section is being ground by hand held power grinders by one individual to further shape the texture left by Carbon Arc process, approximately 10% complete, in the Foundry.

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

Summary of Conversations:

In regards to VT inspection of W2E1 performed on 6/27/09, SMR Mr. Jay Dorst has inspected and deemed acceptable, the surface conditions previously noted in WIR-007455. Area noted in the report as in "radius of rib 4-U" was adhered foreign matter that was removed by scraping as opposed to a rejectable surface condition. Area noted as "between ribs 4-U and 5-U" was deemed acceptable due to an over all view of the area between ribs, versus smaller, select areas.

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
