

**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-007495**Date Inspected:** 02-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

<b>CWI Name:</b>	Pin-Tang Hsu		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Component:</b>	Tower, Jacking and Deviation Saddles		

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date, 7/02/09, 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 - Section is undergoing Final Dimensional inspection by JSW 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 welds, now that it has been through Post Weld Heat Treat.

W2W2 - Requires relocation / repositioning to continue welding opposing side of weld joints, if Fabrication Shop #4.

**TOWER SADDLES**

T1-2 - As the saddle sits in Fabrication Shop #4, the stiffener plates are being welded by K.Kobayashi 08-5023, T.Watanabe 08-5169, Y.Watanabe 73-3873 and K.Sodawaka 06-2929 on plates 8ST-16, 8ST-15, 8ST-18 and 8ST-13, respectively. Parameters were monitored on a random basis by QC CWI Mr. Chung Fu Kuan and later by CWI Mr. Pin-Tang Hsu.

T1-3 - Base plate is in process of being Fit-up to the assembled tower saddle section, located in Fabrication Shop

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# WELDING INSPECTION REPORT

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#4.

## 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 being tested following PWHT, 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 in the Foundry, it appears to have approximately 7% complete.

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.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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