

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-007637**Date Inspected:** 06-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

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|------------------------------------|--------------|----|-----|
| 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, 7/06/09, 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

W2W1 - In Fabrication Shop #4 this saddle has had MT to welds on one side of this saddle by NIS inspector R. Kumagai #132, QC NDE technician. This is the NDE hold point following Post Weld Heat Treat.

W2W2 - Joint welding has resumed to this deviation saddle. Welders J.Yaegashi 07-2941, M.Kato 08-5018 were welding non-std joints W2Y-10U and W2Y-11U with the proper SJ-3011-7 procedure by FCAW, 1.6mm TM95 consumable weld wire. The parameters were being monitored by QC CWI Mr. Chung Fu Kuan.

W2W3 - Buttering is being performed at each end of the cast Saddle section by T.Inoue 08-5163 per SJ-3012-1-2 at lifting lug locations while welder T.Isobe uses a local procedure to join anti-distortional stay bars inside and spanning the trough with FCAW process and fillet welds. The criteria of the procedures was monitored randomly by Mr. Chung Fu Kuan.

TOWER SADDLES

T1-2 - As the saddle sits in Fabrication Shop #4, the 150mm stiffener plates are being welded by K.Kobayashi 08-5023, T.Watanabe 08-5169, M.Inoue 92-5683 and D.Kito 08-5175 on plates 8ST-19, 8ST-21, 8ST-22 and

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8ST-24 with fill welds to PJP joint. Process in use was FCAW, 1.6mm TM55 consumable weld wire. Parameters of WPS SJ-3012-8-2 were monitored on a random basis by QC CWI Mr. Chung Fu Kuan and later by CWI Mr. Pin-Tang Hsu.

T1-3 - Fit of saddle section to base is complete and welders Y.Watanabe 73-3873 and K.Sadawaka 06-2929 were welding stem to plate base at joint 9S-2L while R.Iizuka 06-2643 was welding joint 9S-3L, also using SMAW 5mm E7016 electrode with parameters of WPS SJ-3012-2 being monitored randomly by Mr. Pin-Tang Hsu, while in Fabrication Shop #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).

E2W1 - Idle.

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

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.

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| Inspected By: | Brcic,Michael | Quality Assurance Inspector |
| Reviewed By: | Peterson,Art | QA Reviewer |
