

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-007638**Date Inspected:** 07-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, 7/07/09, 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 is awaiting MT to welds by QC NIS personnel, now that it has been through Post Weld Heat Treat.

W2W2 - First shift welders were Y.Maeyama 94-5234 and T.Isobe 08-5176 welding non-std joints W2Y-16U and W2Y-7U respectively, with QC CWI Mr Chung Fu Kuan randomly monitoring their activities. Second shift began welders M.Kato 08-5018, D.Kito 08-5175, J.Yaegashi 07-2941 welding non-std joints W2Y-5U, W2Y-17U-1 and W2Y-8U respectively all welders were adhering to WPS SJ-3011-7 with the FCAW process, 1.6mm TM95 consumable weld wire. Their parameters were scrutinized by CWI Mr. Pin-Tang Hsu, on a random basis.

TOWER SADDLES

T1-2 - With saddle located in Fabrication Shop #4, a 150mm stiffener plate, 8ST-23, was being welded by T. Inoue 08-5163 utilizing WPS SJ-3012-8-2 using FCAW 1.6mm TM55 weld wire, upon the start of second shift this welder was relieved by M.Inoue 92-5683. Parameters were monitored on a random basis by QC CWI Mr.

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Chung Fu Kuan and later by CWI Mr. Pin-Tang Hsu.

T1-3 - The observed welders by this QA Inspector at the beginning of his shift was R.Iizuka 06-2643 welding joint 9Y-5L-3 and -4. Another welder welding 9Y-5L-1 and -2 was K.Nakasato 91-2247, these are rib to base plate CJP joints, per WPS SJ-3012-2, in Fabrication Shop #4. Upon the start of second shift welder, K.Sadakawa 06-2929 began welding 9Y-10L-1 and -2, with parameters found in WPS SJ-3012-2 and they were monitored randomly by Mr. Pin-Tang Hsu.

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 - 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 two individuals to further shape the texture left by Carbon Arc process in the Foundry, approximately 9% 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.

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