

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-007673**Date Inspected:** 09-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, 7/09/09, 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 - This QA Inspector observed NIS NDE technician Mr. R.Kumagai #132 in progress performing dry MT on finished weld joints W1Y-17U-1, -15U, -11U and -11V, per procedure SF-MT-01. This inspection follows PWHT and fulfills a "hold point" requirement. Located in Fabrication Shop #4.

W2W3 - Welder Y.Maeyama 94-5234, was FCAW welding lifting lugs to ends of saddle casting at locations previously buttered. The built up plate portion has returned to Fabrication shop #4 with mill to bear lands having been completed, this section now awaits bevel preparation.

TOWER SADDLES

T1-2 - Stiffeners are welded and contour grinding is in process to profile the welds.

T1-3 - Base plate, 9-4, was being welded by three individuals, K.Kobayashi 08-5023, Y.Watanabe 73-3873 and K.Sadakawa 06-2929, joints in process were 9Y-12L-1, 9Y-12L-2 and 9Y-12L-3 respectively. Procedure in use was SJ-3012-3, SMAW, 5mm E7016 electrode, in Fabrication Shop #4. These functions were being monitored by QC CWI Mr. Pin-Tang Hsu on a random basis.

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EAST SADDLES

E2E1 - Cast section is now undergoing repair welding to repairs identified as 1-7 and 1-5 in ECS BG-ECS-08-038, by H.Sato 69-2697 and M.Hidaka 72-2081 respectively. Procedure and parameters met SJ-3026-4 for SMAW process and 5mm E9016 electrode.

E2W1 - Casting has been relocated for blast cleaning in preparation repairs for NDE, in Foundry.

West Jacking Saddle - Cast Section is being ground by hand held power grinders by four individuals to provide a proper surface to meet ASTM A802 and to provide a appropriate surface to NDE. The cast section is located 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:

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
