

**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-007677**Date Inspected:** 13-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, 7/13/09, 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 - Saddle section is idle, in Fabrication shop #4.

W2W3 - QA Inspector observations were, Cast portion has had all four (4) lifting lugs attached, welded to its appropriately buttered surface at each end (2 each end) of the Saddle. JSW technician, Mr. Minami, has started the process of cutting, with an automated cutting rig, the bevels on the built up plate portion, as both sections, cast and plate are located in the Fabrication Shop #4.

**TOWER SADDLES**

T1-3 - Base plate, 9-4, was being welded by two individuals, T.Watanabe 08-5153 and S.Watanabe 08-5159, joints in process were 9Y-9L and 9Y-11L respectively. Post shift change, welders K.Nakasato 91-2247, T. Kawakami 08-5079, M.Kashiwada 08-2008 and R.Iizuka 06-2643 were actively welding 9Y-10L-2, 9Y-11L, 9Y-9L and 9Y-10L-1. Procedure in use was SJ-3012-3, FCAW, 1.6mm TM55 weld wire, in Fabrication Shop #4. These functions were being monitored by QC CWI Mr. Pin-Tang Hsu on a random basis.

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# WELDING INSPECTION REPORT

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## EAST SADDLES

E2E1 - Cast section is now undergoing repair welding to repair identified as 2-2 in ECS BG-ECS-08-038, by welder K.Komai 06-8002. Procedure and parameters met WPS SJ-3026-4 for SMAW process, 5mm, E9016 electrode.

E2W1 - Casting has been blast cleaned in preparation for NDE which is scheduled for tomorrow 7/14/2009, in Foundry.

West Jacking Saddle - Cast Section is being ground by two individuals with hand held power grinders to provide a proper surface to meet standards of ASTM A802 and to provide an appropriate surface to NDE. The cast section is located in the Foundry, approximately 35% 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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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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