

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-007687**Date Inspected:** 14-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, 7/14/09, 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

W2W2 - Weld observances were as follows: This QAI noted at beginning of the shift welders T.Watanabe 08-5153 and S.Watanabe 08-5159 welding the upper cast to plate stem joint W2S-2U, after the change between A and B shift, the welders changed to T.Kawakami 08-5079 and R.Iizuka 06-2643. The A shift personnel were under the cognizance of QC CWI Mr. Chung Fu Kuan and the B shift personnel were monitored by CWI Mr. Pin-Tang Hsu. Parameters under scrutiny were both FCAW, TM95 weld wire and SMAW, E9018 electrode, preheat 160° Celsius, amps/voltage. All data met WPS SJ-3011-5 criteria.

W2W3 - Cast sits awaiting its plate portion. The built up plate portion is having bevel preparation done by Mr. Minami of JSW. This bevel cutting is being performed by Oxygen/Propane automated rig, in the Fabrication shop.

TOWER SADDLES

T1-2 - Stiffeners welds are being contour ground in Fabrication Shop #4.

T1-3 - This Saddle section is under-going relocation, upon relocation the base plate welds will require to be

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placed under preheat status throughout the remainder of this QA Inspector's shift.

EAST SADDLES

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

E2W1 - Casting is having whole cast section Wet MT inspection completed in Foundry.

West Jacking Saddle - Cast Section is being ground by hand held power grinders by three 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, approximately 43% 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
