

**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-007757**Date Inspected:** 08-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking, and Deviation Saddles**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Art Peterson was present during the times noted above for observations relative to the work being performed in the Foundry at Japan Steel Works.

Cleaning Operation pending on Saddle: East Saddle E2-W1 (cast section)

The QA Inspector observed that east saddle E2-W1 (cast section) is located in the Foundry Shop for storage until the JSW personnel move the east saddle to have the saddle blast cleaned in preparation for the NDT operations - liquid penetrant test (PT), magnetic particle test (MPT), and ultrasonic test (UT) to be performed on the weld repair areas. On this date, the QA Inspector observed that no other work was being performed on east saddle E2-W1.

Grinding Operation in process on Saddle: West Jacking Saddle

The QA Inspector observed that JSW personnel were performing the grinding operation of the shaped areas on the outside of the trough section and on the rib sections where the removal of cast material- (scarfing operation by the air-carbon-arc method) on the rough casting was previously performed on the west jacking saddle. The purpose of the grinding operation is profile the areas to a smooth finish for the NDT operation. The QA Inspector observed that the grinding operation was in process at the end of the QA Inspectors' shift.

Preheat Operation of Saddle: East Saddle E2-E1 (cast saddle)

The QA Inspector observed that the JSW personnel have located the east saddle E2-E1 to an area for the start of the repair weld operation on the excavated areas on the exterior of the trough, stem and rib sections of east saddle E2-E1. The JSW Representative Mr. Hideaki Kon informed the QA Inspector that JSW personnel are in process of

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preheating the saddle to a temperature of 150 degrees Celsius and the repair weld operation will start on the C shift on July 8th 2009. The QA Inspector observed that the preheat operation was in process at the end of the QA Inspectors' shift.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with the applicable contract specifications.

**Summary of Conversations:**

No significant conversations were reported on this date.

**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, 510 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Peterson, Art	Quality Assurance Inspector
<b>Reviewed By:</b>	Guest, Kittric	QA Reviewer

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