

**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-007767**Date Inspected:** 15-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, 7/15/09, 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 - Welder T. Ohkawa 03-3091, was SMAW welding saddle casting at the cast stem to plate stem joint. These passes constitute the final passes at the toe of weld joint W2S-2U on the cast side of the joint. The parameters of WPS SJ-3011-5 were met and verified by Mr. Chung Fu Kuan, the QA CWI during this welder's shift.

**TOWER SADDLES**

T1-2 - The Saddle section has been sent for Post Weld Heat Treat.

T1-3 - Base plate, was being welded by five (5) individuals, M. Matudate 08-5151, H. Mitsumori 81-5438, T. Sudo 03-3082, M. Yamashida 73-4195 and R. Kito 08-5174 joints in process were 9Y-11L, 9Y-9L, 9Y-5L-1, 9Y-5L-3 (which was finish before shift change) and 9Y-10L-1 respectively. Following shift change the welders assign to continue these joints were Y. Maeyama 94-5234, T. Isobe 08-5176, M. Kubota 74-3666, M. Kashiwada 08-2008 respectively. Procedure in use was SJ-3012-3, FCAW, 1.6mm TM95 consumable 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 excavations (or lack of thickness) identified in ECS BG-ECS-08-037, -038, and -039 by welder K.Komai 06-8002. Procedure and parameters met SJ-3026-4 for SMAW process and 5mm E9018 electrode. Mr. T.Imai, Weld Engineer was overseeing the conditions and parameters in Foundry today.

E2W1 - Casting is having whole cast section Wet MT inspected by technician H.Kohama #86, inspection completed 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, approximately 60% 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
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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