

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-007768**Date Inspected:** 16-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, 7/16/09, 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

W2W3 - Casting sits idle, while its built up plate portion is having final bevel prep (radius of plate ribs that match up with cast stem) hand worked. Both sections are in Fabrication Shop #4.

TOWER SADDLES

T1-2 - Still undergoing Final Post Weld Heat Treat process.

T1-3 - Base plate, 9-4, was being welded by five individuals, T.Kawakami 08-5079, R.Iizuka 06-2643, M. Kubota 74-3666, M.Kashiwada 08-2008, K.Nakasato 91-2247, Y.Maeyama 94-5234, joints in process were 9Y-6L, 9Y-8L, 9Y-12L-3, 9Y-12L-2, 9Y12L-1, 9Y7L-1 respectively. 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.

EAST SADDLES

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E2E1 - Cast section is now undergoing repair welding to excavations identified as 2-1 and 5-9 in ECS BG-ECS-08-038, by Y.Kubotomori 06-8000 and K.Komai 06-8002 respectively. Procedure and parameters met SJ-3026-4 for SMAW process and 5mm E9016 electrode. These activities are taking place 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 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 65% 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
