

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-007871**Date Inspected:** 13-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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 Fabrication shop #4 and the Foundry at Japan Steel Works.

Fabrication Shop #4:

Grinding Operation in process on Saddle: Tower Saddle Segment T1-2

The QA Inspector observed JSW personnel performing the grinding operation on the partial-joint penetration (PJP) groove welds on the stiffener plates welded to the rib, stem and trough of tower saddle T1-2. The completed welds were being ground to a visual acceptable profile prior to Quality Control (QC) Inspector Mr. Chung Fu Kuan performing a visual inspection for acceptance in accordance with the approved shop drawings and AWS D1.5-2002 Section 3.6. The QA Inspector observed that the grinding operation was in process at the end of the QA Inspectors' shift.

Re-positioning of Saddle: Tower Saddle Segment T1-3

The QA Inspector observed that JSW personnel were re-positioning tower saddle segment T1-3 in preparation to change the location on the rib plate to base plate complete-joint penetration (CJP) double bevel groove butt-joint weld operation. The change in location of the weld operation allows for the JSW welding personnel to be able to weld in a more ideal position. The QA Inspector observed that the re-positioning of the tower saddle segment was in process at the end of the QA Inspectors' shift.

NDT Operation pending completion on Saddle: West Deviation Saddle Segment W2-W1

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The QA Inspector observed that the magnetic particle test (MPT) inspection (dry method) has been completed on the partial-joint penetration (PJP) groove welds and adjacent base metal of west deviation saddle W2-W1. The QA Inspector observed that there are areas marked up by Nikko Inspection Services (NIS) NDT QC Inspectors' that will require rework- (grinding) to determine the extent of the rejectable indications detected. On this date, the QA Inspector observed that no work was performed on west deviation saddle segment W2-W1.

Grinding Operation in process on Saddle: West Deviation Saddle Segment W2-W2

The QA Inspector observed the JSW personnel were performing the grinding operation around the radius of the cope holes- (weld access) after the partial-joint penetration (PJP) groove weld operation was completed on the rib (cast section) to rib plate (built-up section) of west deviation saddle segment W2-W2. The QA Inspector also observed that the JSW personnel were performing the grinding operation on the cover passes of the PJP groove welds to grind to a visual acceptable profile prior to Quality Control (QC) Inspector Mr. Chung Fu Kuan performing a visual inspection for acceptance in accordance with the approved shop drawings and AWS D1. 5-2002 Section 3.6. The QA Inspector observed that the grinding operation was in process at the end of the QA Inspectors' shift.

Weld Operation of Temporary Attachments completed on Saddle: West Deviation Saddle Segment W2-W3

The QA Inspector observed that the JSW welding personnel completed the welding of the lifting lugs onto the end ribs (cast section). On this date, the QA Inspector observed that no work was performed on west deviation saddle segment W2-W3.

Foundry:

Weld Operation on Cast Saddle: East Saddle E2-E1 (cast saddle)

The QA Inspector observed the repair weld operation on excavated areas on exterior of the trough (opposite the ID side) on east saddle E2-E1. The QA Inspector observed Quality Control (QC) Inspector Mr. T. Imai verify prior to and during the weld operation that the minimum preheat temperature of 150 degrees Celsius was maintained and the welding parameters of JSW welding personnel Mr. M. Hidaka (72-2081) and Mr. K. Komai (06-8002) were in compliance with WPS SJ-3026-4 per the SMAW process in the (1G) flat position using (5.0) mm diameter E9016-G electrode. The QA Inspector observed that the repair weld operation was in process at the end of the QA Inspectors' shift.

Grinding Operation on Saddle: West Jacking Saddle (cast saddle)

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

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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.

Inspected By:	Peterson, Art	Quality Assurance Inspector
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Reviewed By:	Guest, Kittric	QA Reviewer
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