DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 73.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-007894
Date Inspected: 14-Jul-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: HoChang, Korea

OSM Arrival Time: 800
OSM Departure Time: 1800
Location: Unyang, Korea

CWI Name: Sang Ho Kwak

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Pier E2 bearing and Shear key

Summary of Items Observed:

The following report is based on METS observations at HoChang Machinery Industries (HCMI). Current work: Casting, forging and machining.

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at HoChang Machinery Industries (HCMI) located at Unyang, Korea and DooSan Heavy Industries(DHIC) located at Changwon, Korea. The Purpose of this trip was to observe quality control during fabrication and process of following items.

Forging

1. Bearing Bottom Housing (B1-07/F07302-010): Transfer to KPC for final machining.
2. Bearing Bottom Housing (B2-07/F07302-020): Start final machining.
3. Bearing Bottom Housing (B3-07/F07302-030): Transfer to KPC for final machining.
4. Bearing Bottom Housing (B4-07/F07302-040): Transfer to KPC for final machining.
5. Spherical Ring (S1-07/F07302-050): Continue to pre machining for SS overlay welding.
6. Spherical Ring (S2-07/F07302-060): Continue to pre machining for SS overlay welding.
7. Spherical Ring (S3-07/F07302-070): Continue to pre machining for SS overlay welding.
8. Spherical Ring (S4-07/F07302-080): Continue to pre machining for SS overlay welding.
9. Solid Shaft (B1-02/F07302-090): Completed pre machining for SS overlay welding.
10. Solid Shaft (B2-02/F07302-100): Completed pre machining for SS overlay welding.
11. Solid Shaft (B3-02/F07302-110): Completed pre machining for SS overlay welding.
12. Solid Shaft (B4-02/F07302-120): Completed pre machining for SS overlay welding.

• F number is DooSan Production Number.
• B number is drawing Number.

Casting

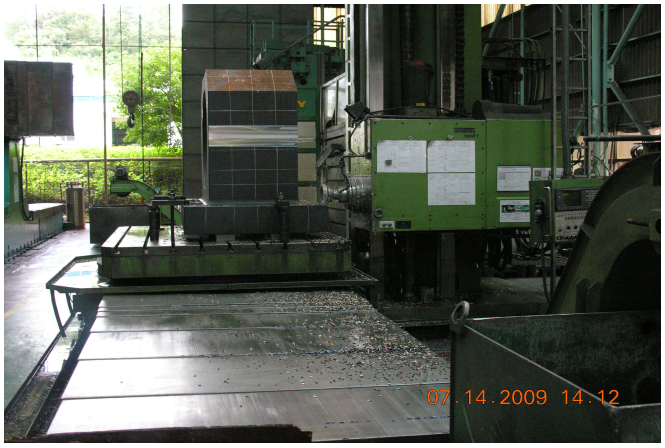
On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at HoChang Machinery Industries (HCMI) located at Unyang, Korea and DooSan Heavy Industries(DHIC) located at Changwon, Korea. The Purpose of this trip was to observe quality control during fabrication and process of following items.

1. Bearing Top Housing (B1-06, C07039-010): Completed repair welding.
2. Bearing Top Housing (B2-06, C07039-020): Completed PWHT.
3. Bearing Top Housing (B3-06, C07039-030): Transfer to KPC for final machining.
4. Bearing Top Housing (B4-06, C07039-040): Transfer to KPC for final machining.
5. Bearing Hold Down Assembly (B1-01-1, C07039-050): Continue to final machining.
6. Bearing Hold Down Assembly (B1-01-2, C07039-060): Continue to final machining.
7. Bearing Hold Down Assembly (B2-01-1, C07039-070): Continue to final machining.
8. Bearing Hold Down Assembly (B2-01-2, C07039-080): Start final machining.
9. Bearing Hold Down Assembly (B3-01-1, C07039-170): Start final machining
10. Bearing Hold Down Assembly (B3-01-2, C07039-180): Start final machining.
11. Bearing Hold Down Assembly (B4-01-1, C07039-190): Start final machining.
12. Bearing Hold Down Assembly (B4-01-2, C07039-200): Continue to final machining.
13. Shear Key Stub (S1-01, C07039-090): Continue to final machining.
14. Shear Key Stub (S2-01, C07039-100): Transfer to KPC for final machining.
15. Shear Key Stub (S3-01, C07039-110): Transfer to KPC for final machining.
16. Shear Key Stub (S4-01, C07039-120): Completed PWHT.
17. Shear key Housing (S1-03, C07039-130): Completed PWHT.
18. Shear key Housing (S2-03, C07039-140): Transfer to KPC for final machining.
19. Shear key Housing (S3-03, C07039-150): Continue to repair welding.
20. Shear key Housing (S4-03, C07039-160): Completed repair welding.

* S and B number is drawing number.
* C number is DSHI ID number.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

*Discuss with Mr. S. H. Kwak regarding general project schedule.

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:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer