

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 #: 04-0120F4Cty: 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-007923**Date Inspected:** 23-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, 7/23/09, 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 - This deviation saddle is having lifting lugs and staybars removed by way of Oxy Propane torch by Mr. Ohta of JSW. This observation took place in Fabrication Shop #4.

W2W3 - Prior to the start of the welders this QA Inspector observed two Heated quivers holding E9018 weld electrodes, unplugged and cold, QC CWI Mr Chung Fu Kuan immediately had welders empty and discard the electrodes. QA Inspector proceeded to inform QC of the importance of not only verifying the use but the temperature of 120° Celsius in the quivers (per AWS Bridge Welding Code D1.5 ¶ 4.5.2). The welders on A shift were T.Watanabe 08-5169, K.Kobayashi 08-5023 and M.Kato 08-5018 were welding joints W3Y-7U, W3Y-6U and W3Y-11U respectively, using SMAW and WPS SJ-3011-7 with E9018 electrode. The parameters were verified by QC CWI Mr. Chung Fu Kuan and the B shift welders, S.Watanabe 08-5159 and M.Matudate 08-5151, welding joints W3Y5U and W3Y-6U respectively, were monitored by Mr. Pin-Tang Hsu.

TOWER SADDLES

T1-2 - Saddle section has PWHT Magnetic Particle testing (dry powder, continuous method) being completed on

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

CJP joint 8Y-12L-1 by NIS technician, Mr K.Kobayashi #141 in the Fabrication shop #4.

T1-3 - This saddle was observed to have been repositioned and JSW personnel are actively stabilizing the Saddle section and building staging for the continuing of welding of the two Stem to base plate joints. This observation took place in the Fabrication Shop #4.

EAST SADDLES

E2E1 - Cast section is now had repairs completed and is awaiting a Post Repair weld Heat Treat in Foundry.

E2W1 - Casted section is awaiting flip to allow for inspection of base of saddle. Located in Foundry Shop.

West Jacking Saddle ~ Cast Section surface is now shaped/dressed and is awaiting NDE, personnel begin the process of laying out grid lines for tracking purposes. The cast section is located in the Foundry.

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
