

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-007928**Date Inspected:** 22-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, 7/22/09, 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 has been repositioned for the "lower" side to have its welds ground and profiled. This will take place in its current location of Fabrication Shop #4.

W2W3 - This QA Inspector observed two welders on A shift and two welders on B shift actively welding root passes. Day shift: K.Kobayashi 08-5023 and M.Kato 08-5018; B shift - S.Watanabe 08-5159 and M.Matodate 08-5151 joints were W3Y-8U, W3Y-13U, W3Y-10U and W3Y-9U respectively. All four welders utilized SMAW 4mm/4.8mm E9018 electrode. The parameters of SJ-3011-7 were verified by QC CWI Mr. Chung Fu Kuan and the B shift welders was monitored by Mr. Pin-Tang Hsu.

TOWER SADDLES

T1-2 - Saddle section has PWHT Ultrasonics testing being carried out by NIS personnel in the Fabrication shop #4.

T1-3 - This saddle was observed to be welded by nine welders throughout the course of this QA inspector's shift. Joint 9S-3L was being welded by, A shift - D.Kito 08-5175, J.Yaegashi 07-2941 and Y.Watanabe 08-5169, B

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shift - H.Mitsumori 81-5438. Joint 9S-2L was being welded by, A shift - M.Inoue 92-5683 and T.Watanabe 08-5169, B shift - R.Kito 08-5174, T.Watanabe 08-5153 and T.Ohkawa 03-3091. All welders were using FCAW process with SJ-3012-3 and monitored randomly by, A shift - Chung Fu Kuan and B shift - Mr. Pin-Tang Hsu. This observation took place in the Fabrication Shop #4.

EAST SADDLES

E2E1 - Cast section is now undergoing repair welding to lack of thickness area identified in ECS BG-ECS-08-038 as 1-2, by A.Takenami 06-8001. Procedure and parameters met SJ-3026-4 for SMAW process and 5mm E9016 electrode, in Foundry.

E2W1 - Casted section is having its inner trough Wet MT inspection completed to procedure SF-MT-01, by H. Kohama #86 and A.Seino #82 of JSW Foundry shop inspection team. On Weld Inspection report WIR-007454 it was noted that the Casting was inadvertently Identified with its stamp on wrong side, QA Inspector observed the ID stamp has been ground away and restamped on correct side (the "Upper" side of saddle section) there are no outstanding discrepancies related to the condition.

West Jacking Saddle - Cast Section surface is now considered shaped/dressed and is awaiting NDE. 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
