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 #: 70.28

WELDING INSPECTION REPORT

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

Report No: WIR-007929
Date Inspected: 21-Jul-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 1300
OSM Departure Time: 2130
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**		

Bridge No: 34-0006
Component: Tower, Jacking and Deviation Saddles

Summary of Items Observed:

On this date, 7/21/09, 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 - This QA Inspector observed two welders on A shift and one welder on B shift actively welding the same weld joint (W3S-2U) and process due to root passes being deposited by all. Day shift: T.Watanabe 08-5169 and K.Kobayashi 08-5023, Night shift: S.Watanabe 08-5159 all three utilized SMAW 4mm E9018 electrode. The parameters of WPS SJ-3011-5 were verified by QC CWI Mr. Chung Fu Kuan and the second shift welder was monitored by Mr. Pin-Tang Hsu. The root passes were being tested utilizing dry MT powder, conducted by Mr. K. Kobayashi #141, of Nikko Inspection Services (NIS).

TOWER SADDLES

T1-2 - Saddle section has returned from blast shop cleaned with QC inspection personnel beginning MT of stiffeners, test is being carried out by R.Kumagai #132, of NIS.
T1-3 - This saddle was observed to be idle due to need for staging and preheat to support welding of stem plate to base plate. This observation took place in the Fabrication Shop #4.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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 Wet MT inspection completed to procedure SF-MT-01, by H.Kohama #86 of JSW Foundry shop test team.

West Jacking Saddle - Cast Section is being ground by hand held power grinder by one individual 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 95% 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