

**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-007965**Date Inspected:** 24-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

|                                    |               |    |     |
|------------------------------------|---------------|----|-----|
| <b>CWI Name:</b>                   | Chung Fu Kuan |    |     |
| <b>Inspected CWI report:</b>       | Yes           | No | N/A |
| <b>Electrode to specification:</b> | Yes           | No | N/A |
| <b>Qualified Welders:</b>          | Yes           | No | N/A |
| <b>Approved Drawings:</b>          | Yes           | No | N/A |

|                                  |     |    |     |
|----------------------------------|-----|----|-----|
| <b>CWI Present:</b>              | Yes | No |     |
| <b>Rod Oven in Use:</b>          | Yes | No | N/A |
| <b>Weld Procedures Followed:</b> | Yes | No | N/A |
| <b>Verified Joint Fit-up:</b>    | Yes | No | N/A |
| <b>Approved WPS:</b>             | Yes | No | N/A |
| <b>Delayed / Cancelled:</b>      | 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 the Foundry at Japan Steel Works.

**Foundry:**

Post Weld Heat Treatment Operation pending on Saddle: East Saddle E2-E1 (cast saddle)

The QA Inspector observed that east saddle E2-E1 was being re-located to have the post weld heat treatment (PWHT) operation performed on the east saddle after the repair weld operation was completed. The PWHT operation is scheduled to start on July 25th, 2009. The QA Inspector observed that no other work was performed on east saddle E2-E1.

Re-positioning of Saddle in process on Saddle: East Saddle E2-W1 (cast saddle)

The QA Inspector observed that the JSW personnel were in process on re-positioning east saddle E2-W1 in preparation to complete the NDT magnetic particle test (MPT) inspection (wet particles) by the yoke method on the base plate of the saddle. The JSW representative Mr. Hideaki Kon informed the QA Inspector that the MPT inspection would resume on July 27th, 2009. The QA Inspector observed that the re-positioning of the saddle was in process at the end of the QA Inspectors' shift.

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

The QA Inspector observed that the JSW personnel completed 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

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

JSW Representative Mr. Hideaki Kon informed the QA Inspector that the next operation will be the layout of the grid lines on the west jacking saddle by marking (300 mm x 300 mm) grid lines on the inside and outside of the trough and on the rib sections for the purpose of tracking and identification for the following NDT operations: visual test (VT), liquid penetrant test (PT), magnetic particle test (MPT), and ultrasonic test (UT) methods which is scheduled to start on July 27th, 2009. On this date, the QA Inspector observed that no other work was being performed on the west jacking saddle.

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.

## 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.

---

|                      |                |                             |
|----------------------|----------------|-----------------------------|
| <b>Inspected By:</b> | Peterson, Art  | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Guest, Kittric | QA Reviewer                 |

---