

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008525**Date Inspected:** 17-Aug-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

CWI Name:	Chung Fu Kuan		
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 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 Fabrication shop #4 and the Foundry at Japan Steel Works.

Fabrication Shop #4:

Re-positioning of Saddle: Tower Saddle Segment T1-3

The QA Inspector observed that JSW personnel were re-positioning tower saddle segment T1-3 in preparation to start the welding on the 2nd side of the middle stiffener plates to the exterior of the trough section and in between the rib plates. The QA Inspector observed that the re-positioning of the tower saddle segment was in process at the end of the QA Inspectors' shift.

Grinding Operation in-process on Saddle: West Deviation Saddle Segment W2-W3

The QA Inspector observed JSW personnel performing the grinding operation on the cover passes of the partial-joint penetration (PJP) groove welds on the stem plate (built-up section) to stem (cast section) of west deviation saddle segment W2-W3. The JSW personnel were grinding on the cover passes of the PJP groove welds to a visual acceptable profile prior to Quality Control (QC) Inspector Mr. Chung Fu Kuan performing a visual inspection for acceptance in accordance with the approved shop drawings and AWS D1.5-2002 Section 3.6. The QA Inspector observed that the grinding operation was in process on west deviation saddle segment W2-W3 at the end of the QA Inspectors' shift.

ABF-RFI-001811R00: Modified MC Shapes for East Saddle Rocker Bearing Plates E2-E1 and E2-W1

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The QA Inspector observed (1) JSW personnel (grinder) performing the grinding operation around the (8) each 70 mm radius copes on the upper and lower flanges of (2) miscellaneous channels (13 * 31.8). The 70 mm radius copes were previously made on the (2) miscellaneous channels by a JSW machinist as per ABF-RFI-001811R00. The sharp edges were being removed prior to the fit-up operation of the (8) each JIS channel 3350 (150 * 75* 75). The QA Inspector also observed Certified Weld Inspector (CWI) Mr. Chung Fu Kuan verify the dimensions and the locations of the (8) each 70 mm radius copes on the upper and lower flanges of the (2) miscellaneous channels (13 * 31.8). The QA Inspector observed that the total time spent on this date was (8) hours for the (1) JSW personnel (grinder) to remove the sharp edges around the 70 mm radius copes on the (2) miscellaneous channel- (1) each for east saddle rocker bearing plate E2-W1 and E2-E1 with the work still in process and (4) hours for (1) CWI to perform and complete the dimensional inspection to verify the locations of the 70 mm radius copes on the upper and lower flanges of the (2) miscellaneous channels- (1) each for east saddle rocker bearing plate E2-W1 and E2-E1.

Foundry:

Grinding Operation in-process on Saddle: East Saddle E2-E1 (cast saddle)

The QA Inspector observed (2) JSW personnel performing the grinding operation on the major excavation and minor excavation repair welds previously performed on east saddle E2-E1. The purpose of the JSW personnel performing the grinding operation is to grind the repair welds to an acceptable profile in accordance with ASTM A802 surface quality category (J) - (metal removal marks- welds) to a visual quality level (3). The QA Inspector observed that the grinding operation was in process at the end of the QA Inspectors' shift.

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.

Inspected By:	Peterson, Art	Quality Assurance Inspector
Reviewed By:	Guest, Kittric	QA Reviewer
