

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-008589**Date Inspected:** 31-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, 7/31/09, 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 - Saddle structure is located in Fabrication Shop #4 awaiting Final PWHT.

W2W3 - Saddle section in Fabrication Shop #4, is being welded by 4 welders on A shift and 3 on B shift. A shift consisted of 1) M.Kashiwada 08-2008 2) T.Kawakami 08-5079 3) Y.Maeyama 94-5234 4) R.Iizuka 06-2643 welding joints W3Y11U, W3Y-12U, W3Y-4U-1, W3Y-4U-2 respectively. B shift personnel were T.Watanabe 08-5169, M.Kato 08-5018 and M.Inoue 92-5683 welding W3Y-9U, W3Y-10U and W3Y-4U-1 respectively. The requirements established by SJ-3011-7 WPS were confirmed and verified periodically by QC CWI Mr. Chung Fu Kuan and Mr. Pin-Tang Hsu.

TOWER SADDLES

T1-3 - JSW employee Y.Ohta was in process tack welding 50mm stiffener plates 9ST-25, -26, -27 in place to complete the fitup. Also observed was, plate 9-9 edge, noted in WIR-007639, was finished getting built up by surfacing per BG-ECS-08-041.

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EAST SADDLES

E2E1 - Cast section is having excess reinforcement ground, JSW representative Mr. Hideaki Kon, in the weld pit in Foundry, the NDE of the repair welding will then commence.

E2W1 - Casted section is idle to completion of UT and MT of repair welds. Located in Foundry Shop.

West Jacking Saddle - Foundry NDE technician H.Kohama #86 and N.Osawa #340 were in process of performing UT of as shaped/dressed surface of casting, currently scanning ribs with longitudinal dual element transducer and both were utilizing A scan type scopes. This 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
