

**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-008743**Date Inspected:** 05-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Japan Steel Works**Location:** Muroran, Japan

<b>CWI Name:</b>	Pin-Tang Hsu		
<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
<b>Component:</b>	Tower, Jacking and Deviation Saddles		

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date, 8/05/09, 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 and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

**WEST DEVIATION SADDLES**

W2E2 - Saddle section is being relocated to Wharf for storage.

W2W2 - Saddle section is awaiting Final PWHT NDE.

**TOWER SADDLES**

T1-3 - JSW employees M.Kato 08-5018, T.Watanabe 08-5169, K.Kobayashi 08-5023 and M.Inoue 92-5683 were in process welding stiffener plates 9ST-24, -22, -21 and -23 per SJ-3012-8-2, respectively. Process observed was FCAW 1.6 TM55 consumable weld wire in 1G and 3G positions (due to slope of stiffener). This QA Inspector arrived and observed the aforementioned weld processes in progress at 06:07 through 06:42, without a CWI present, the QAI proceeded to QC office to find Mr. Pin-Tang Hsu documenting his shift's operations. At this time, the QAI asked the QC CWI to fulfill requirements of special provisions and OSM/PP. Mr. Hsu immediately resumed duties of verifying the parameters randomly, until the arrival of his CWI relief, Mr. Chung Fu Kuan.

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# WELDING INSPECTION REPORT

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## EAST SADDLES

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

E2W1 - Idle. Now located in Fabrication Shop #4.

West Jacking Saddle - Located in the Foundry remaining NDE of shaped/dressed surface of casting being completed.

This QAI also approved a OK to cut of JIS channel (150mm x 75mm x 4.5mm thick) HT# CB4566, the intended use is the modification of bearing plates, E2W1 and E2E1. Assigned Caltrans Lot# was B275-015-09.

This QAI also observed deviation by JSW from original nesting of a previously OK to cut, previous Caltrans lot# was B275-013-09, 18mm plate, HT#847474-1 (no longer intended for use for divider plate, but instead, for pipe sleeve flanges x100).

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.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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