

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 #: 73.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008791**Date Inspected:** 25-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** HoChang, Korea**Location:** Unyang/Changwon, Korea

CWI Name:	Sang Ho Kwak		
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:** Pier E2 bearing and Shear key**Summary of Items Observed:**

The following report is based on METS observations at HoChang Machinery Industries (HCMI). Current work: Casting, forging and machining.

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at HoChang Machinery Industries (HCMI) located at Unyang and Onsan Korea and Korea Precision Co., located at Dooseo Korea. The Purpose of this trip was to observe quality control during fabrication and process of following items.

QA Inspector observed HMIC QC Inspector Mr. Kwak and ABF welding engineer Mr. Craig, Knob has performed Welding procedures Qualification test with approved WPS No FC-060-F. Please see detail information in TL-6032 with following witness lot numbers.

WPS No	Supporting PQR No	QA LOT number(6032)
FC-061 1F	QFC-061-1G	B258-046-09
FC-061 2F	QFC-061-1G	B258-047-09

Forging

1. Bearing Bottom Housing (B1-07/F07302-010): Completed final MT.
2. Bearing Bottom Housing (B2-07/F07302-020): Completed final MT.
3. Bearing Bottom Housing (B3-07/F07302-030): Completed final MT.
4. Bearing Bottom Housing (B4-07/F07302-040): Completed final MT.

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5. Spherical Ring (S1-07/F07302-050): Completed pre machining for SS overlay welding.
6. Spherical Ring (S2-07/F07302-060): Completed pre machining for SS overlay welding.
7. Spherical Ring (S3-07/F07302-070): Completed pre machining for SS overlay welding.
8. Spherical Ring (S4-07/F07302-080): Completed pre machining for SS overlay welding.
9. Solid Shaft (B1-02/F07302-090): Completed pre machining for SS overlay welding.
10. Solid Shaft (B2-02/F07302-100): Completed pre machining for SS overlay welding.
11. Solid Shaft (B3-02/F07302-110): Completed pre machining for SS overlay welding.
12. Solid Shaft (B4-02/F07302-120): Completed pre machining for SS overlay welding.

- F number is DooSan Production Number.
- B number is drawing Number.

Casting

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at HoChang Machinery Industries (HCMI) located at Unyang, Korea. The Purpose of this trip was to observe quality control during fabrication and process of following items.

1. Bearing Top Housing (B1-06, C07039-010): Waiting for final machining at HMIC.
2. Bearing Top Housing (B2-06, C07039-020): Waiting for final machining at HMIC.
3. Bearing Top Housing (B3-06, C07039-030): Continue to final machining.
4. Bearing Top Housing (B4-06, C07039-040): Waiting for final machining at HMIC.
5. Bearing Hold Down Assembly (B1-01-1, C07039-050): Completed final MT.
6. Bearing Hold Down Assembly (B1-01-2, C07039-060): Completed final MT.
7. Bearing Hold Down Assembly (B2-01-1, C07039-070): Completed final MT.
8. Bearing Hold Down Assembly (B2-01-2, C07039-080): Completed final MT.
9. Bearing Hold Down Assembly (B3-01-1, C07039-170): Completed final MT.
10. Bearing Hold Down Assembly (B3-01-2, C07039-180): Completed final MT.
11. Bearing Hold Down Assembly (B4-01-1, C07039-190): Completed final MT.
12. Bearing Hold Down Assembly (B4-01-2, C07039-200): Completed final MT.
13. Shear Key Stub (S1-01, C07039-090): Continue final machining.
14. Shear Key Stub (S2-01, C07039-100): Continue final machining.
15. Shear Key Stub (S3-01, C07039-110): Continue final machining.
16. Shear Key Stub (S4-01, C07039-120): Continue final machining.
17. Shear key Housing (S1-03, C07039-130): Waiting for final machining at HMIC.
18. Shear key Housing (S2-03, C07039-140): Waiting for final machining at HMIC.
19. Shear key Housing (S3-03, C07039-150): Waiting for final machining at HMIC.
20. Shear key Housing (S4-03, C07039-160): Waiting for final machining at HMIC.

- * S and B number is drawing number.
- * C number is DSHI ID number.

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Summary of Conversations:

*Discuss with Mr. S. H. Kwak regarding general project schedule.

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: Shin,DJ

Quality Assurance Inspector

Reviewed By: Lanz,Joe

QA Reviewer