

**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-009216**Date Inspected:** 16-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Hideaki Kon**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** 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 Machine shop #2 and the Foundry shop at Japan Steel Works.

**Machine Shop #2:**

QA NDT Verification of End Splay Cover Plate: East Saddle E2-W1 (steel section)

The QA Inspector performed ultrasonic test (UT) verification inspection on a complete-joint penetration (CJP) tee joint weld on the outside stiffener plate no. 24-5 to the end splay cover plate no. 24-1 for east saddle E2-W1 in accordance with AWS D1.5-2002 section 6.13 and to the UT acceptance-rejection criteria- compressive stress in Table 6.4. The QA Inspector verified that the UT inspection results were in compliance with Table 6.4. See Ultrasonic Test Inspection Report TL-6027 dated September 16th 2009 for details of equipment used and location of inspection on the outside stiffener plate CJP tee joint weld on the end splay cover plate for east saddle E2-W1.

**Foundry:**

Repair Weld Operation pending on Saddle: West Jacking Saddle

The JSW Representative Mr. Hideaki Kon informed the QA Inspector that the NIS QC Inspection personnel completed the engineering communication sheet (ECS) for both the major repair weld excavations and minor repair weld excavations and JSW also has received approval from the Engineer to start the major repair weld operation on the west jacking saddle. The major and minor repair weld operation is tentatively scheduled to start on September 23rd 2009.

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# WELDING INSPECTION REPORT

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Unless otherwise noted in this report, 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 at (510) 385-5910, who represents the Office of Structural Materials for your project.

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