

**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-009269**Date Inspected:** 21-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 Fabrication shop #4 and the Foundry shop at Japan Steel Works.

**Fabrication Shop #4:**

Final NDT Operation completed on Saddle: West Deviation Saddle W2-E3

The QA Inspector observed that Nikko Inspection Services (NIS) Quality Control (QC) Non-Destructive Testing (NDT) personnel Mr. H. Kohama (#86) and Mr. N. Osawa (#340) completed the magnetic particle test (MPT) inspection by the (wet method) on west deviation saddle segment W2-E3 on the final machined surface of the level (1) area as shown on the plans of the interior of the trough and the level (1) and level (3) areas as shown on the plans of the final machined cast faying surfaces.

**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 preheat operation to perform the major and minor repair weld operation is tentatively scheduled to start on September 23rd 2009.

Unless otherwise noted in this report, all observations reported on this date appeared to be in general compliance

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# WELDING INSPECTION REPORT

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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
<b>Reviewed By:</b>	Guest, Kittric	QA Reviewer

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