

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009698**Date Inspected:** 14-Oct-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:** T. Imai**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:**

Trial Assembly Survey: West Deviation Saddle Segments on East Side

The QA Inspector observed that the JSW personnel positioned west deviation saddle segments W2-E1, W2-E2, and W2-E3 onto jacks in preparation to perform the trial assembly survey of the west deviation saddle segments. The trial assembly survey will be performed using a 3D Laser system after the segments are bolted together to check for height and length dimensions, flatness between the faying surfaces, divider plate groove alignment between the segments, and the parallel wire strand (PWS) compartment widths as per the approved final machined drawings. The QA Inspector observed that the preparation for the trial assembly survey of west deviation saddle segments W2-E1, W2-E2, and W2-E3 were in-process at the end of the QA Inspectors' shift.

**Foundry Shop:**

Grinding Operation in-process on Saddle: West Jacking Saddle

The QA Inspector observed (1) JSW personnel was in process performing the grinding operation on the major excavation and minor excavation repair welds previously performed on the west jacking saddle. The purpose of the JSW personnel performing the grinding operation is to grind the repair welds to an acceptable profile in accordance with ASTM A802 surface quality category (J) - (metal removal marks- welds) to a visual quality level (3). The QA Inspector observed that the grinding operation was still in-process at the end of the QA Inspectors'

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## WELDING INSPECTION REPORT

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shift.

**Other:**

"Ok to Cut" on HPS ASTM A709 Grade 485W Material: Divider Plates for West Deviation Saddle

The QA Inspector was escorted by JSW representative Mr. Hideaki Kon to Narasaki-Seisakusyo Company in Muroran, Japan to perform an "OK to Cut" on (12) steel plates to be used for cutting out the divider plates for the west deviation saddles. The plates were identified as follows: Plate (#1) ASTM A709 Grade HPS 485W-T2- (16 mm x 2280 mm x 6610 mm) Plate Heat No. 446306-2; Plate (#2) ASTM A709 Grade HPS 485W-T2- (16 mm x 2280 mm x 6610 mm) Plate Heat No. 443734-1; Plate (#3) ASTM A709 Grade HPS 485W-T2- (16 mm x 2280 mm x 5830 mm) Plate Heat No. 443734-2; Plate (#4) ASTM A709 Grade HPS 485W-T2- (16 mm x 2280 mm x 5830 mm) Plate Heat No. 443729-1; Plate (#5) ASTM A709 Grade HPS 485W-T2- (16 mm x 2190 mm x 5990 mm) Plate Heat No. 444495-1; Plate (#6) ASTM A709 Grade HPS 485W-T2- (16 mm x 2160 mm x 5830 mm) Plate Heat No. 444496-2; Plate (#7) ASTM A709 Grade HPS 485W-T2- (16 mm x 2070 mm x 5990 mm) Plate Heat No. 016635-1; Plate: (#8) ASTM A709 Grade HPS 485W-T2- (16 mm x 2050 mm x 5830 mm) Plate Heat No. 016637-2; Plate (#9) ASTM A709 Grade HPS 485W-T2- (16 mm x 2050 mm x 5830 mm) Plate Heat No. 016635-2; Plate (#10) ASTM A709 Grade HPS 485W-T2- (18 mm x 2390 mm x 6610 mm) Plate Heat No. 443727-1; Plate (#11) ASTM A709 Grade HPS 485W-T2- (18 mm x 2300 mm x 5990 mm) Plate Heat No. 443728-2; and Plate (#12) ASTM A709 Grade HPS 485W-T2- (18 mm x 2280 mm x 5830 mm) Plate Heat No. 443730-2. The QA Inspector verified the plate heat numbers stenciled on the steel plate against the material test reports for accuracy and also verified that the mechanical properties and chemistry results were in compliance with the material specification and contract specifications. The QA Inspector assigned Caltrans Lot number B273-015-09 for Narasaki-Seisakusyo personnel to proceed with the cutting operation.

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

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