

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-009905**Date Inspected:** 22-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:

Dismantling of Segments in-process after the Trial Assembly Survey: West Deviation Saddle Segments - East Side

The QA Inspector observed that the JSW personnel were in-process on dismantling west deviation saddle segments W2-E1, W2-E2, and W2-E3. The JSW personnel have completed the trial assembly survey on assembled west deviation saddle segments W2-E1, W2-E2, and W2-E3. The JSW Representative Mr. Hideaki Kon informed the QA Inspector that JSW will prepare the dimensional inspection report this week and afterwards submit a copy of the report to the Engineer for review. The west deviation saddle segments will be placed into storage until the paint quality work plan (PQWP) has been submitted and approved.

Layout Operation in-process on Saddle: West Deviation Saddle W2-W1 (after final machining)

The QA Inspector observed that Nikko Inspection Services (NIS) Non-Destructive Testing (NDT) Quality Control (QC) Inspector Mr. N. Osawa (#340) was in preparation to perform the final magnetic particle test (MPT) inspection on the machined surfaces on the interior of the trough and the machined surfaces on the exterior of the end rib sections and base plate of west deviation saddle segment W2-W1 by performing the layout operation-marking (300 x 300) mm grid lines on the saddle sections for record purposes, identification, and guidance in inspection. The QA Inspector observed that the layout operation was in-process on west deviation saddle segment W2-W1 at the end of the QA Inspectors' shift.

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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 the visual quality level (3) requirement. The QA Inspector observed that the grinding operation was still in-process at the end of the QA Inspectors' shift.

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.

Inspected By:	Peterson, Art	Quality Assurance Inspector
Reviewed By:	Edmondson, Fred	QA Reviewer
