

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 #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001719**Date Inspected:** 11-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Or.**CWI Name:** Greg Roberts**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:** Hinge K Pipe Beam (62F)**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Danny C. White (B89) was present at Oregon Iron Works (OIW) for the purpose of monitoring fabrication operations of the Hinge K Pipe Beam at the OIW fabrication and welding shop in Clackamas, Oregon.

The QA Inspector performed random observations of operations in the fabrication shops mentioned below at OIW. The QA Inspector observed that OIW welding operators and machinists are performing bevel operations on stiffener plates as well as pipe components by utilizing automatic track type torches in the fabrication shop (Bay #1) and a vertical turret lathe (VTL) in the machine shop (Bay #5). The QA Inspector observed several components which bevels had been completed and the work performed appears to comply with the drawings specifications.

Summary of Conversations:

The QA Inspector notified OIW Welding Engineer Mr. Greg Roberts by telephone with regards to the current status of the (2) procedure Qualification Record (PQR) test plates which OIW welding operators had completed the week prior. The QA Inspector was informed that PQR test plate CS-025 and CS-027 were sent back from Koon Hall Testing Laboratories to OIW. Mr. Roberts informed the QA Inspector that the plates were too large for the capability's of Koon Hall's equipment to begin cutting and machining the samples from them and the PQR test plates needed to be trimmed to a smaller size.

Later in the shift, the QA Inspector observed that both ends of each PQR plate mentioned above had been trimmed and the PQR test plates were placed on a wooden pallet in Bay #1. See photo below for additional information.

WELDING INSPECTION REPORT

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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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: White, Danny

Quality Assurance Inspector

Reviewed By: Wright, Mark

QA Reviewer