

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001722**Date Inspected:** 14-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:	Steve Williams		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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 and sizing operations on stiffener plates as well as pipe components by utilizing automatic track type torches and 30 foot planer mill in the fabrication shop (Bay #1) and a vertical turret lathe (VTL) in the machine shop (Bay #5). The QA Inspector observed that the work performed appears to be within the drawings specifications.

Summary of Conversations:

The QA Inspector met with Mr. Steve Williams and Welding Engineer Mr. Greg Roberts and was informed that the PQR test plate CS-025 and CS-027 were shipped to production sawing Incorporated to be cut into adequate sized parts so that Koon Hall can remove the mechanical samples from them. Mr. Williams informed the QA Inspector that the State will receive adequate notice prior to the PQR test plates being cut.

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.

WELDING INSPECTION REPORT

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Inspected By: White,Danny

Quality Assurance Inspector

Reviewed By: Wright,Mark

QA Reviewer