

**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-001823**Date Inspected:** 25-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Or.**CWI Name:** Steve Williams**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.

During the first part of his shift the QA Inspector performed random observations in the fabrication and machine shops at OIW. The QA Inspector observed 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 OIW has drilled and tapped holes in components marked a106.

**Summary of Conversations:**

The QA Inspector was informed By OIW Welding Engineer Mr. Greg Roberts that sections from procedure qualification record (PQR) OIW-PQR-025 and OIW-PQR-027 are at the Koon Hall Testing facility ready to be cut and machined into Charpy V Notch, Macro etch, side bend and all weld metal specimens. See TL-6034 created this date for additional information.

**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.

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# WELDING INSPECTION REPORT

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**Inspected By:**      White,Danny

Quality Assurance Inspector

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**Reviewed By:**      Wright,Mark

QA Reviewer