

**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-001863**Date Inspected:** 02-Apr-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**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 in the fabrication and machine shops at OIW. The QA Inspector observed that the 30 foot planer mill in the fabrication shop (Bay #1) was working on components marked a112 and b107 for this job. The QA Inspector performed a random check of several these components and the machining performed appears to be in conformance with contract documents.

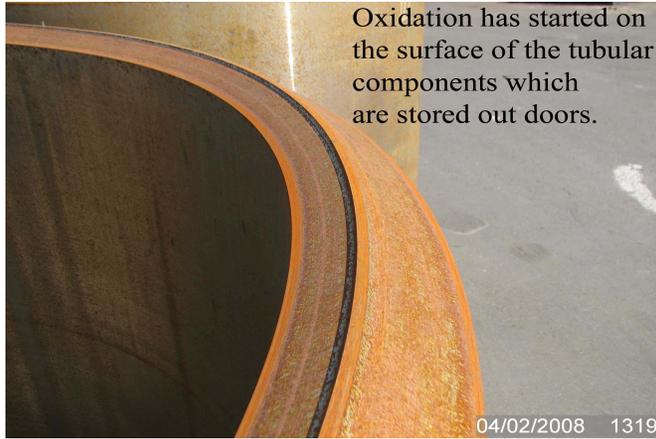
The QA Inspector observed that tubular components which have been stored in the South-West lot of Bay #8 appear to have oxidation forming on the machined surface. The QA Inspector observed that the storage of these components do not appear to be in conformance with contract documents. See photo below for additional information. The QA Inspector will inform OIW of this situation during his shift the following day.

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# WELDING INSPECTION REPORT

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Oxidation has started on the surface of the tubular components which are stored out doors.

## Summary of Conversations:

The QA Inspector met with OIW Welding Engineer Mr. Greg Roberts in person early in his shift and was informed by Mr. Roberts that he notified Koon Hall Testing by telephone and asked when destructive mechanical testing for procedure qualification record (PQR) CS-025 and CS-027 will begin.

Approximately 1330 the QA Inspector met with Mr. Roberts in person and was informed that Koon Hall Testing has not yet contacted him regarding mechanical testing and Mr. Roberts will inform the QA Inspector when Koon Hall does notify him.

## 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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<b>Inspected By:</b>	White,Danny	Quality Assurance Inspector
<b>Reviewed By:</b>	Wright,Mark	QA Reviewer

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