

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-002398**Date Inspected:** 08-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1200**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 fuse overlay mockup**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA) was present as requested to observe an overlay procedure being performed at the Clackamas facility of Oregon Iron Works.

Mr. Greg Roberts was present to perform monitoring of the electro slag welding (ESW) being performed by welder, Craig Jacobsen on a mockup being performed as required by the Special Provisions and Request for Change (RFC) ABF-RFC-28R0.

The Base material was said to be ASTM A709 Gr 70W HPS heat number 108571 from Oregon Steel Mills. The Material was measured to be 32mm by the QA. The Electro used on the second and third layer was observed to be Soudotape 316L strip welding material. The flux used was EN760 (ES) AFB-2

The QA Inspector observed the Amps to be 1250 and the Volts to be 24.3. The travel speed was recorded at 275mm per minute.

OIW welder J-6 performed a FCAW repair of the second layer using 316L 1.6mm dia. wire with 100% CO₂. The amps were measured at 225 amps and 29 volts. The repair was ground smooth after welding. After the repair the final layer was started.

The photos below show the process being observed.

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Summary of Conversations:

Mr. Roberts stated that the rest of the simulated repairs will be done after the piece has been cut into smaller sections. He also stated that he would notify Caltrans when this would take place.

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: Wright,Mark

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer