

**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-003461**Date Inspected:** 12-Aug-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, Oregon**CWI Name:** Scott Reed**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 components**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 and welding operations of the Hinge K Pipe Beam at the OIW fabrication and welding shop in Clackamas, Oregon.

The QA Inspector randomly observed that third party Quality Control (QC) Inspector Mr. Scott Reed was monitoring a hand held submerged arc welding (SAW) welder qualification test being performed by OIW Welding Operator Mr. Randy Kleeman, welder identification (WID) K20. Please see photo below for additional information. During one of the weld passes the QA Inspector observed that Mr. Kleeman performed a travel speed of approximately 215 millimeters per minute. The QA Inspector asked Mr. Reed what the minimum travel speed allowed by the welding procedure specification (WPS). The QA Inspector observed that the WPS referred to a table for the travel speed limitations and the table was not attached to the WPS. The QA Inspector inquired as to how a welder qualification test could be performed if the travel speed information is not available. Mr. Reed informed the QA Inspector that he would contact OIW Welding Engineer Mr. Greg Roberts and obtain the travel speed information to determine if the above mentioned travel speed is within the limitations of the WPS. Mr. Reed also informed the QA Inspector that if the travel speed observed during the test did not conform to the limitations of the WPS he would fail the test.

The QA Inspector observed machinist Mr. Scott Jones was utilizing the 30 foot planer mill located in Bay #1 to perform machining operations on the Base-plate marked a110-3 for this job.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

Within the body of the report.

## 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 Ryan Smith, (858) 232-6799, 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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