

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-003510**Date Inspected:** 13-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: Mike Gregson
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 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 met with OIW Welding Engineer Mr. Greg Roberts to review the minimum travel speed allowed by the welding procedure specification (WPS) 4006. The QA Inspector observed that the previous day OIW Welding Operator Mr. Randy Kleeman performed a hand held submerged arc welding (SAW) test which was being monitored by Quality Control (QC) Inspector Mr. Scott Reed. The QA Inspector observed that during the test the travel speed information pertaining to the WPS was not available.

After viewing the WPS information provided by Mr. Roberts the QA Inspector observed that the travel speed performed by Mr. Kleeman did not appear to be in compliance with the WPS. The QA Inspector was informed by Mr. Roberts that OIW considers the test performed by Mr. Kleeman invalid.

The QA Inspector also 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.

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

WELDING INSPECTION REPORT

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remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	White,Danny	Quality Assurance Inspector
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Reviewed By:	Wright,Mark	QA Reviewer
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