

**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-003541**Date Inspected:** 15-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

<b>CWI Name:</b>	Mike Gregson		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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 was informed that the previous day OIW had repaired the cooling system leak of the gas tungsten arc welding (GTAW) machine and OIW had completed the GTAW stainless steel overlay repair procedure. It is noted that the test was completed after the QA Inspector had left. The QA Inspector was informed that OIW Welding Operator Mr. Craig Jacobsen deposited (3) additional weld passes on the third weld layer which completed the test. The QA Inspector did observe that (3) weld passes were deposited onto the above mentioned test.

The QA Inspector performed random observations in the fabrication shop. 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. The QA Inspector also observed OIW Welding Operator Mr. Rick Hinkle was fabricating fixtures which will be utilized in the construction of the Hinge K weldments.

**Summary of Conversations:**

It is noted that the QA Inspector did receive a document from OIW in lieu of the electrode certified material test report from OIW Welding Engineer Mr. Greg Roberts the previous day. The QA Inspector was presented with Part C Appendix "Guide to Specification for Bare Stainless Steel Welding Electrodes and Rods" of SFA-5.9. Part A4 Certification of the document states that: "The act of placing the AWS specification and classification designations on the packaging enclosing the product, or the classification on the product itself, constitutes the

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supplier's (manufacturers) certification that the product meets all of the requirements of the specification". The QA Inspector informed Mr. Roberts that the subtitle denotes "This Appendix in not part of the ANSI/AWS A5. 9-93, Specification for Bare Stainless Steel Welding Electrodes and Rods, but is included for information purposes only". The QA Inspector informed Mr. Roberts that the above mentioned document presented did not have mechanical properties nor did it appear to be an applicable substitute for the Electrode Manufactures Certification. It is noted that Mr. Roberts was not at the OIW fabrication facility this day for correspondence regarding this situation.

### **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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