

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-003545**Date Inspected:** 19-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon**CWI Name:** Scot 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 performed random observations in the fabrication shop (Bay #1). The QA Inspector observed machinist Mr. Scott Jones was utilizing the 30 foot mill to machine the Base-plate component marked as a110-4 for this job.

The QA Inspector randomly observed that third party Quality Control (QC) Inspector Mr. Scott Reed was monitoring welder qualification tests being performed by Welding OIW Welding Operators.

Summary of Conversations:

The QA Inspector met with OIW Welding Engineer Mr. Greg Roberts to correspond regarding the CO₂ gas certification supplied on 8/18/08. The QA Inspector observed that the CO₂ gas was utilized for the flux core arc welding (FCAW) stainless steel repair procedure performed the day prior. It is noted that the gas certification mentioned above denoted a dewpoint of -32 Fahrenheit (F). Mr. Roberts presented the QA Inspector with what appears to be a Certificate of Conformance from AIRGAS dated 6/25/2008 which denotes the dewpoint at -40F.

The QA Inspector also inquired as to the materials certifications for the filler metals and tungsten inserts utilized during the gas tungsten arc welding (GTAW) stainless steel repair procedure performed the week prior. Mr. Roberts refused to supply the QA Inspector with the certifications.

WELDING INSPECTION REPORT

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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.

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