

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-003593**Date Inspected:** 22-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:** 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 (QA) Inspector 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) and observed Machine Shop Foreman Mr. Eric Kirkwood was utilizing the 30 foot mill to machine the base-plate component marked as a110-4 for this job.

The QA Inspector observed that OIW personal utilized plasma arc cutting (PAC) to remove the flux cored arc welding (FCAW) and gas tungsten arc welding (GTAW) stainless steel overlay repair tests previously performed. See photo below for additional information. The QA Inspector observed that after being removed the test plates were placed on a wood pallet and stored inside of bay #1.

Quality Control (QC) Inspector Mr. Scott Reed informed the QA Inspector that no welder qualification testing was performed this day.

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Summary of Conversations:

The QA Inspector met with OIW Quality Control (QC) Manager Mr. Tom Tomovick and was presented with certifications for the 309L and 316L filler rod utilized on the GTAW stainless steel overlay procedure qualification record (PQR) tests performed the week prior. Please see the TL-6032 created this day for additional information. The QA Inspector inquired for information on the GTAW inserts utilized during the test. Mr. Tomovick referred the situation to OIW Foreman Mr. Vern Taute. After several attempts to meet with Mr. Taute during the shift the QA Inspector was unsuccessful.

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
