

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-003710**Date Inspected:** 27-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 (QA) Inspector Mr. 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 in bay #1 and observed Mr. Scott Jones was utilizing the 30 foot mill to perform machining operations on the base-plate component marked as a110-4 for this job. Later in the shift the QA Inspector observed that Mr. Jones rolled the base plate to the opposite side and began setting up the machine for facing. Mr. Jones informed the QA Inspector that machining on the component would most likely be completed some time the following day.

Summary of Conversations:

The QA Inspector met with OIW Project Manager Mr. Bill Pender to inquire the scope and start date of fabrication. General conversations occurred regarding issues with materials, required check-samples, welding procedure specifications and approved welders. Mr. Pender informed the QA Inspector that he would need to meet with Quality Control Manager (QCM) Mr. Tom Tomovick to resolve some issues before fabrication and welding began.

The QA Inspector met with OIW Quality Control (QC) Inspectors Mr. Gary Mundt and Mr. Scott Reed to inquire about the results of the side-bend specimens from the welder qualification tests performed previously. The QA Inspector was informed by the QC Inspectors that the side bend specimens had been visually accepted.

It is noted that the following (4) rolled ASTM A709 Grade 485W fuse components have been shipped to OIW

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facility in Clackamas, Oregon: Heat D5551-6A, D5002-2, D5002-3 and D4848-5B. See photos below for additional information. The QA Inspector was informed by QA Inspector Mr. Mark Wright that he believed the above mentioned components had been shipped without being properly released. The QA Inspector contacted Mr. Tom Tomovick by telephone and inquired as to why the components were shipped with out following the proper release procedure and Mr. Tomovick informed the QA Inspector that he did not have an answer at this time.



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