

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-004907**Date Inspected:** 11-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**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 (QA) Inspector Danny C. White (B89) was present at Oregon Iron Works (OIW) as requested for the purpose of monitoring fabrication and welding operations performed on the Hinge K Pipe Beam at the OIW fabrication and welding shop in Clackamas, Oregon.

The QA Inspector observed that Cooper heating elements were on and continued to pre-heat the Fuse weld joint area.

The QA Inspector did observe that Welding Operator Mr. Craig Jacobsen, welder identification (WID) #J6 had installed 3/32 inch diameter Lincoln LA-85 submerged arc welding (SAW) wire onto the welding machine and deposited Lincoln MIL 800-HPNi granular flux into the gravity fed hopper. The QA Inspector then observed Mr. Jacobsen verified preheat and utilized this hand held SAW machine to tack-weld run-off tabs onto the ends of the longitudinal weld seam and the tack welds were deposited in such a manner which would be reincorporated into the weld joint.

The QA Inspector then met with Quality Control (QC) Inspector Mr. Mike Gregson and was informed that the run-off tabs which had been tack-welded onto the ends of the longitudinal weld seam mentioned above were made from Fuse material remnants and were ASTM A709 Grade 485W.

The QA Inspector then observed Mr. Jacobsen deposit the root pass on the inside diameter of the Fuse. Upon completion and cleaning of the weld the QA Inspector observed what appeared to be (2) porosity holes approximately 3 mm in diameter in the above mentioned weld at different locations. Mr. Jacobsen was observed

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

utilizing a grinder to remove the porosity and tapered the repair areas. Please see photo below for confirming information. Mr. Jacobsen then performed SAW to make repairs. The QA Inspector observed that the welding parameters appeared to be in compliance with welding procedure specification (WPS) 4020 Revision 0.

It is noted that no other welding was performed this day.



Summary of Conversations:

As noted above in 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 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:	Adame,Joe	QA Reviewer
