DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 13.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-004935
Date Inspected: 12-Dec-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Oregon Iron Works Clackamas, Or.

OSM Arrival Time: 530
OSM Departure Time: 1600
Location: Clackamas, Oregon

CWI Name:	Mike Gregson			**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) as requested for the purpose of monitoring fabrication and welding operations performed on the Hinge K Pipe Beams 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 and maintain interpass temperature of the Fuse weld joint area.

The QA Inspector did observe that Welding Operator Mr. Craig Jacobsen, welder identification (WID) #J6 deposited weld metal on the inside diameter of the complete joint penetration longitudinal weld seam marked as #W3-01A on Fuse Heat #D5551-6A utilizing 3/32 inch diameter Lincoln LA-85 submerged arc welding (SAW) wire and Lincoln MIL 800-HPNi granular flux. Following the above mentioned welding Mr. Jacobsen utilized carbon arc cutting to backgouge the root of the weld on the outside diameter of the Fuse. Mr. Jacobsen then utilized a grinder to dress the weld joint and the QA Inspector observed Quality Control (QC) Inspector Mr. Mike Gregson performed magnetic particle (MT) inspection on 100% of the weld joint and the immediate surrounding area. Please see photo below for additional information. Mr. Gregson indicated several locations which contained indications. Mr. Jacobsen utilized a die grinder to dress the above mentioned areas and Mr. Gregson performed MT on the areas addressed and accepted the backgouge. Mr. Jacobsen then deposited weld metal on the outside diameter of the weld joint. The QA Inspector observed that the welding parameters appeared to be in compliance with welding procedure specification (WPS) 4020 Revision 0.

WELDING INSPECTION REPORT

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Summary of Conversations:

Mr. Gregson informed the QA Inspector that swing shift Welding Operator Mr. Huymh Phoung, WID #H4 would most likely be welding on the above mentioned weld joint.

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