

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-005014**Date Inspected:** 15-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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 Beams at the OIW fabrication and welding shop in Clackamas, Oregon.

The QA Inspector observed that Cooper heating elements were on and continued maintain interpass temperature of the Fuse weld joint area.

The QA Inspector periodically observed Welding Operator Mr. Craig Jacobsen, welder identification (WID) #J6 deposit weld metal on the outside 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.

The QA Inspector verified the welding parameters utilizing his Fluke meter and a stop watch and the welding parameters appeared to be in compliance with welding procedure specification (WPS) 4020 Revision 0.

Summary of Conversations:

The QA Inspector observed faintly marked indications which had previously marked on the inside diameter of the above mentioned Fuse weldment. The QA Inspector met with Quality Control (QC) Supervisor Mr. Mike Gregson to discuss the indications mentioned above and was informed that these indications had been found by OIW QC Inspector Mr. Ron Brown several months ago. Mr. Gregson informed the QA Inspector that that OIW is looking into this issue and is aware that the indications had been discovered.

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The QA Inspector informed Supervisor Mr. Joe Adame by email of the above mentioned issue.

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
