

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-005015**Date Inspected:** 16-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**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 joint 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. Mr. Jacobsen completed the outside weld, rolled the Fuse and deposited weld metal on the inside diameter of the weld joint.

Near the end of the shift the QA Inspector was informed by Mr. Jacobsen that the voltage output of the welding machine he was using was climbing erratically once he had started welding. This occurred on several short weld passes deposited on the inside diameter of the Fuse. Mr. Jacobsen informed the QA Inspector that the welding machine needed to be repaired before he deposited additional weld metal.

Summary of Conversations:

The QA Inspector met with Quality Control Manager Mr. Tom Tomovick and discussed the indications which were observed on the inside diameter of the above mentioned Fuse weldment. Mr. Tomovick informed the QA Inspector that OIW does not yet have a plan of action regarding the above mentioned indications and is in process

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determining the best course of action. The idea of sending the Structural Materials Representative Mr. Ryan Smith a request for information (RFI) was discussed and Mr. Tomovick informed the QA Inspector the OIW is considering the possibility of sending an RFI.

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
