

**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-005016**Date Inspected:** 17-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 periodically observed Welding Operator Mr. Craig Jacobsen, welder identification (WID) #J6 deposit weld metal on the inside 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 weld joint early in the shift, disconnected the Cooper-heating elements and removed the Fuse from the SAW welding area.

Mr. Jacobsen then placed Fuse D5002-2 into the welding area and affixed Cooper heating elements with clamps and pre-heated the weld joint and surrounding area.

Once the pre-heat was sufficient, Mr. Jacobsen then deposited weld metal into the inside diameter side of the weld joint utilizing the same welding equipment as mentioned above.

**Summary of Conversations:**

The QA Inspector met with Supervisor Mr. Joe Adame and QA Inspector Mr. Rick Bettencourt at the OIW shop in Portland, Oregon and discussed the issue with the indications which exist on the inside diameter of Fuse D5551-6A as well as D5002-2 (please see photo below for confirming information). The QA Inspector pointed

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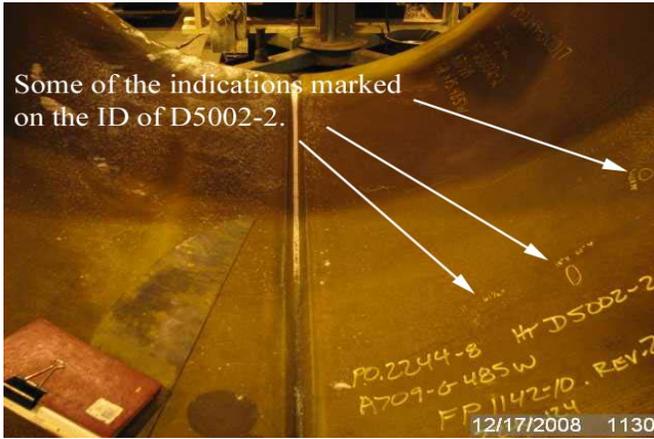
# WELDING INSPECTION REPORT

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out several examples of these areas to Mr. Adame and Mr. Bettencourt and informed the above mentioned inspectors that OIW is currently exploring options on how to proceed on this 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.

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<b>Inspected By:</b>	White,Danny	Quality Assurance Inspector
<b>Reviewed By:</b>	Adame,Joe	QA Reviewer

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