

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-005017**Date Inspected:** 18-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**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 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 outside diameter of the complete joint penetration longitudinal weld joint marked as #W3-01B. This work was performed on Fuse Heat D5002-2 utilizing 3/32 inch diameter Lincoln LA-85 submerged arc welding (SAW) wire and Lincoln MIL 800-HPNi granular flux.

The QA Inspector observed the welding parameters appeared to be in compliance with welding procedure specification (WPS) #4020.

Summary of Conversations:

As noted above in 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.

WELDING INSPECTION REPORT

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Inspected By: White,Danny

Quality Assurance Inspector

Reviewed By: Adame,Joe

QA Reviewer