

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005467**Date Inspected:** 16-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon**CWI Name:** See below**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 Pipe Beams**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Oregon Iron Works, Inc. (OIW) jobsite in Clackamas, Oregon for the purpose of observing fabrication of the Hinge K Pipe Beams.

OIW Fabrication Shop-Bay 1 (sub-assembly):

QA Inspector Brannon randomly observed two OIW personnel continuing prepping internal ring stiffeners round plate MK# a125 – 40mm x 1720mm x 1720mm and round plate MK#b125- 50mm x 1720mm x 1720mm (HPS 485 W) for fit-up and welding. Internal ring stiffeners will be welded inside the hinge k pipe beam fuse half sections. Ring stiffeners plates are being beveled to 55 degrees on both sides with a 4mm land. See OIW fabrication drawing 2244-123 sheet 1 of 2 for bevel profile and weld detail.

OIW Fabrication Shop-Bay 1 (sub-assembly):

QA Inspector Brannon randomly observed OIW personnel cutting internal ring stiffeners round plate MK# a125 – 40mm x 1720mm x 1720mm and round plate MK#b125- 50mm x 1720mm x 1720mm (HPS 485 W). QA Inspector Brannon observed OIW personnel using an oxy-fuel programmable CNC machine to remove the center portion of the ring stiffener plates.

OIW Fabrication Shop-Bay 1 (Check Samples):

QA Inspector Brannon witnessed OIW personnel cutting check samples in bay 1 using an oxy-fuel programmable CNC machine to cut the samples. QA Inspector Brannon reviewed material testing reports (MTR) and verified heat numbers of each plate. QA Inspector Brannon assigned and marked lot number and Caltrans EA# on the below listed plate samples.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

TL-101 #C714977 – Lot # B208-004-09 – HPS 485 WF3 – 12 x 12 x 4 Heat #D5002-4

TL-101 #C714977 – Lot # B208-004-09 – HPS 485 WF3 – 12 x 12 x 4 Heat #D4076-6A

TL-101 #C714977 – Lot # B208-004-09 – HPS 485 WF3 – 12 x 12 x 4 Heat #D4076-7A

TL-101 #C714977 – Lot # B208-004-09 – HPS 485 WF3 – 12 x 12 x 4 Heat #D4076-8A

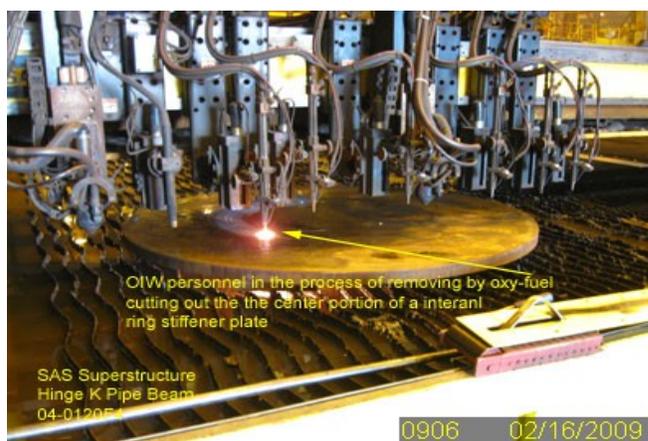
TL-101 #C714977 – Lot # B208-004-09 – HPS 485 WF3 – 12 x 12 x 4 Heat #D4076-9A

QA Inspector Brannon inserted material test reports and TL-101 into Caltrans packing slip and affixed the packing slip to 1 of the 5 samples. OIW is sending the check samples to the Caltrans Laboratory, in Sacramento California for mechanical testing.

Material, Equipment, and Labor Tracking:

QA Inspector Brannon performed a verification of personnel at OIW. QA Inspector Brannon observed 1 Supervisor, 3 Quality Control and 4 production personnel on this date.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

No relevant conversations on this date.

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 Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Adame, Joe

QA Reviewer
