

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-005619**Date Inspected:** 04-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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:

QA Inspector Brannon randomly observed OIW personnel and 1 helper continuing in Bay 1 at the CNC mill for facing hinge k pipe beam post tension cap plate (A825M) MK#a109 in preparation for welding.

OIW Fabrication Shop-Bay 3:

QA Inspector was informed by OIW Forman Mr. Troy Smith that on the swing shift OIW had buttered ring stiffener plate MK#a125 due to during fit-up gap exceeding the 2mm requirement per the joint detail. Mr. Smith also stated that after buttering the land the stiffener was re-fit into position and the gap still exceeded the 2mm tolerance. Mr. Smith stated that OIW will remove ring stiffener plate and butter the land on the area that exceeds the 2mm tolerance.

QA Inspector Brannon observed OIW preheating and buttering approximately 1600mm. QA Inspector Brannon randomly observed OIW qualified welder Mr. Craig Jacobson ID#J6 and one helper butter welding ring stiffener plate MK#a125 (HPS 485 W). Mr. Jacobson was observed welding in the 1G (flat) position utilizing flux cored arc welding (FCAW) process with a 1.6mm diameter electrode, filler metal brand Hobart Fabco 91k2 class E91T1-k2 semi-automatic. QA Inspector Brannon observed the OIW QC CWI Inspector Mr. Rob Walters verifying that the pre-heat and welding parameters were in accordance with the Welding Procedure Specification (WPS). Welding parameters observed by QA Inspector Brannon appear to be in general compliance with the approved WPS 3046

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revision number 3. QC Inspector Mr. Mike Gregson stated that OIW will submit a welding repair report (WRR-2244-05).

OIW Fabrication Shop-Bay 3:

QA Inspector Brannon randomly observed OIW personnel rough machining flat side of hinge k forging sections a111-1, and a111-3 (A508 Gr. 4N Class 2) in preparation for welding to hinge k base plate MK#a110.

OIW Fabrication Shop-Bay 3:

QA Inspector Brannon randomly observed OIW personnel preparing positioner for welding forging MK#a111 (A508 Gr. 4N Class 2) to base plate ML#a110 in preparation for welding.

Material, Equipment, and Labor Tracking:

QA Inspector Brannon performed a verification of personnel at OIW. QA Inspector Brannon observed 1 Supervisor, 4 Quality Control and 6 production personnel on this date.

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



Summary of Conversations:

AS stated within this 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 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