

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-006770**Date Inspected:** 20-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR

CWI Name:	Steve Barnett		
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
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Hinge-K Components**Summary of Items Observed:**

Summary of Items Observed: On this date, Caltrans Quality Assurance Inspector (QA) Clete Henke was present at Oregon Iron Works, Inc. (OIW) in Clackamas, OR for observation of fabrication of the Hinge K Pipe Beams and related activities including in process welding and OIW Quality Control (QC) visual and nondestructive testing. The following observations were recorded:

OIW Fabrication Shop-Bay 3

Hinge-K Pipe Beam Fuse Sub-Assembly 120A-6:

a125 stiffener ring to a124-9 Fuse

The assembly was complete; the QA Inspector observed no production activity for the duration of the shift.

Hinge-K Pipe Beam Base Assembly 102A-1:

a111-1 forging to a110-4 base plate

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Base Assembly 102A-2:

a111-2 forging to a110-2 base plate

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Base Assembly 102A-3:

a111-3 forging to a110-3 base plate

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

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Hinge-K Pipe Beam Base Assembly 102A-4:

a111-4 forging to a110-4 base plate

The QA Inspector intermittently monitored OIW welder Bui Liem (WID B10) during in progress Submerged Arc Welding (SAW) at weld joint W2-04 joining a107 stiffener plate to a110-4 base plate. Welder B10 deposited SAW fillet passes in the horizontal (2F) position in accordance with approved welding procedure 4020. The QA Inspector noted that welder B10 maintained continuous preheat utilizing electric resistance heating cords held in place with clamps prior to welding and two torches during welding. The QA Inspector observed OIW QC Inspector Steve Barnett regularly monitoring and recording the in process SAW parameters. The QA Inspector also intermittently observed in process welding parameters and determined that the SAW parameters and minimum preheat/interpass temperature appeared to be in general compliance with the contract requirements -- (33 volts, 500 amperes, 457mm/min travel speed).

Hinge-K Pipe Beam Fuse Assembly 120A-1:

a124-6 to a124-7

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Fuse Assembly 120A-2:

a124-3 to a124-11

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Fuse Assembly 120A-4:

a124-13 to a124-4

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Fuse Assembly 120A-5:

a124-14 to a124-2

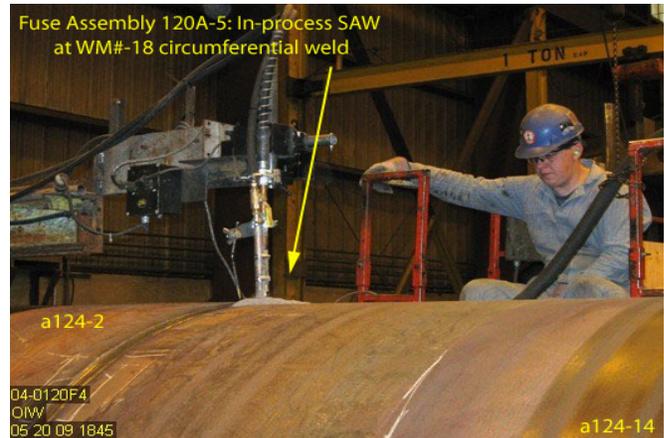
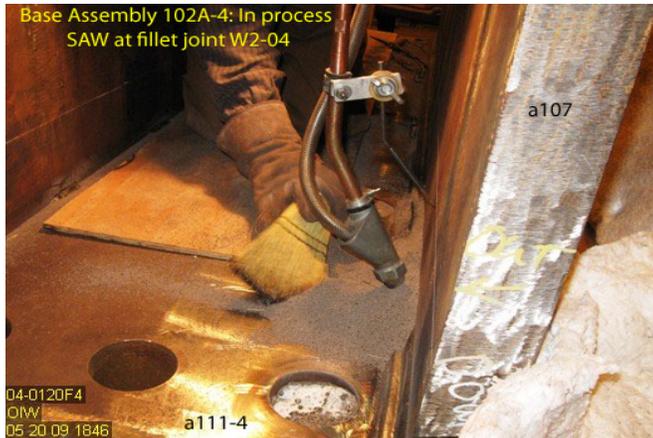
The QA Inspector observed in-progress Submerged Arc Welding (SAW) at Outside Diameter (OD) portion of circumferential weld joining a124-14 to a124-2 identified as WM3-18 on approved shop drawings. OIW welder Mikhail Bannikov (WID B28) deposited SAW fill and cover passes in the flat (1G) position in accordance with approved welding procedure 4020. The QA Inspector noted the OIW welder was maintaining continuous preheat utilizing two torches. The QA Inspector observed OIW QC Inspector Steve Barnett regularly monitoring and recording the in process SAW parameters. The QA Inspector also intermittently observed the in process welding parameters and determined that the SAW parameters and minimum preheat/interpass temperature appeared to be in general compliance with the contract requirements -- (33 volts, 575 amperes, 457mm/min travel speed).

Material, Equipment, and Labor Tracking:

The QA Inspector performed verification of personnel involved with this project and equipment in use. The QA Inspector accounted for 2 OIW production personnel and 1 Quality Control Inspector present on this date.

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Summary of Conversations:

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

Inspected By: Henke,Clete

Quality Assurance Inspector

Reviewed By: Adame,Joe

QA Reviewer