

**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-007063**Date Inspected:** 07-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon

**CWI Name:** Jon Nickolich  
**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 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 3 (sub-assembly):**

QA Inspector Brannon observed no production activity on Hinge K Pipe Beam sub assemblies noted below for the duration of the shift.

Hinge-K Pipe Beam Sub Assembly, MK#102A-1 - MK#a111-1 forging to MK#a110-1 base plate idle.

Hinge-K Pipe Beam Sub Assembly, MK#102A-4 - MK#a111-4 forging to MK#a110-4 base plate idle.

Hinge-K Pipe Beam Sub Assembly, MK#120A-2 - MK#a124-3 half fuse to MK#a124-11 half fuse.

Hinge-K Pipe Beam Sub Assembly, MK#120A-4 - MK#a124-4 half fuse to MK#a124-13 half fuse.

Hinge-K Pipe Beam Sub Assembly, MK#120A-6 - MK#a124-1 half fuse to MK#a124-9 half fuse.

Hinge-K Pipe Beam Sub Assembly, Half fuse section MK#a124-15.

**OIW Fabrication Shop-Bay 6 (sub-assembly):**

QA Inspector Brannon observed no production activity on Hinge K Pipe Beam sub assemblies noted below for the duration of the shift.

Hinge-K Pipe Beam Sub Assembly, MK#120A-1 - MK#a124-6 half fuse to MK#a124-7 half fuse.

Hinge-K Pipe Beam Sub Assembly, MK#120A-3 - MK#a124-10 half fuse to MK#a124-12 half fuse.

**OIW Storage Yard**

Hinge-K Pipe Beam Sub Assembly, MK#102A-2 - MK#a111-2 forging to MK#a110-2 base plate idle.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Hinge-K Pipe Beam Sub Assembly, MK#102A-3 - MK#a111-3 forging to MK#a110-3 base plate idle.

Note: QA Inspector Brannon also, observed pending repairs for MK#102A-2 weld joint W2-13 and MK#102A-3 weld joint W2-13 both have pending 1st time UT repairs.

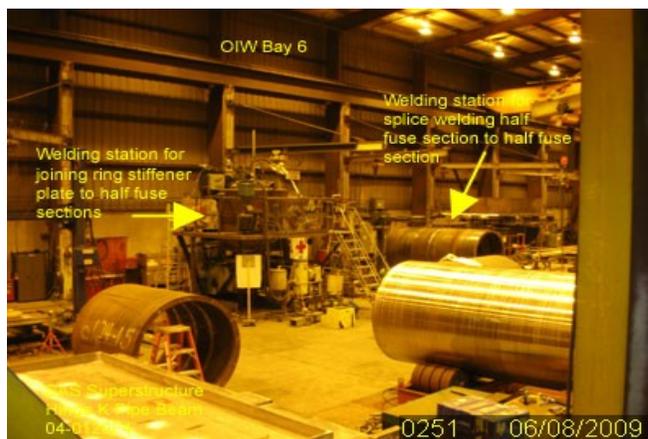
### Caltrans Status and Production Tracking:

QA Inspector Brannon also updated Caltrans status and production tracking logs for tracking of check samples, procedure qualification record (PQR), critical weld repairs (CWR), non-critical welding repairs (WRR), completed and in process welding, QC/QA non-destructive testing.

### Material, Equipment, and Labor Tracking:

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

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



### Summary of Conversations:

As noted 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.

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

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