

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-007144**Date Inspected:** 10-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR**CWI Name:** Mike Gregson, Rob Walters**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:**

The Quality Assurance Inspector Sean Vance arrived on site at Oregon Iron Works, Inc (OIW) in Clackamas, OR, to randomly observe the in process welding of the Hinge K Pipe Beam assemblies. The QA Inspector arrived on site to randomly observe the OIW Quality Control (QC) Inspectors in process and completed visual and nondestructive testing. Upon the arrival of the QA Inspector the following observations were made:

OIW Fabrication Shop-Bay 1: 6/10/09

Procedure Qualification Test (PQR)

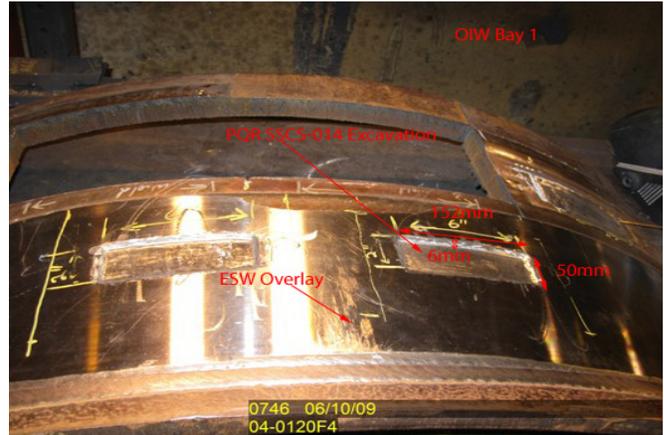
PQR #SSCS-014

QA Inspector observed OIW welder #C34, Mr. Mark Craig, performing multi-pass tungsten inert gas welding on a tubular cut test plate, in the flat position. QA Inspector was informed by OIW welding supervisor, Vern Taute, that this Procedure Qualification Test #SSCS-014, was being performed for the potential weld repairs on the stainless steel overlay process. Upon arrival, Mr. Vern Taute provided QA Inspector with the applicable material and consumable certifications. QA Inspector noted that Mr. Mark Craig would be welding using two consumable electrodes, identified as AWS A5.9 ER316L (lot #E78883)/AWS A5.9 ER309L (lot #E75276) (3/32" Harris brand), 2% thoriated tungsten electrode, utilizing a Precision TIG 275 welding machine, CK 20RG torch, size #8 nozzle and argon shielding gas, with a flow rate of 35 CFH. QA Inspector noticed the test plate was 32mm thick, Heat #108571 and had a cut square in the stainless steel overlay, approximately 152mm long x 55mm wide x 6mm deep and Mr. Kleeman would be depositing weld passes, to fill the base material and finish with a weld cap, to

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duplicate the approximate height of the overlay passes. QA Inspector noticed that QC Inspector Tony Gross was present during the welding, to monitor and document in-process welding parameters (amps/volts), pre-heat temperatures and travel speeds during each welding pass. QA Inspector noted Mr. Mark Craig was in general compliance with AWS D1.6/contract requirements and Mr. Tony Gross provided QA Inspector with copies of the Data Sheet for Procedure Qualification, after completion of this PQR SSCS-014 and QA Inspector assigned the following lot # B251-028-09.



Summary of Conversations:

As noted above.

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:	Vance,Sean	Quality Assurance Inspector
Reviewed By:	Adame,Joe	QA Reviewer
