

**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-007451**Date Inspected:** 15-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 130**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon

<b>CWI Name:</b>	Steve Barnett		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A

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

OIW Fabrication Shop-Bay 1:

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, cap plates MK#109.

OIW Fabrication Shop-Bay 3 (sub-assembly):

QA Inspector Brannon randomly observed OIW qualified welder Mr. Mikhail Bannikov ID#B28 welding fill pass's joining radical stiffener MK #b108 (HPS 485 W) to tubular forging MK# a111-4 (A508 Gr. 4N Class 2) for hinge k pipe beam base assembly section a102-4. The partial joint penetration (PJP) groove weld is identified as weld joint #W1-160. Mr. Bannikov was observed welding in the 1G (flat) position utilizing submerged arc welding (SAW) process with a 2.4mm diameter electrode, filler metal brand Lincoln Electric LA85 class F9A4-Eni5-G-H2. QA Inspector Brannon observed the OIW QC CWI Inspector Mr. Steve Barnett verifying that the pre-heat of 350°F and welding parameters were in accordance with the Welding Procedure Specification (WPS). Welding parameters measured by QA are as follows for root/fill: 568 amps, /34.7 volts and a travel speed of 431mm per minute appear to be in conformance with approved welding procedure specification WPS 4016 revision number 1.

OIW Fabrication Shop-Bay 3 (sub-assembly):

QA Inspector Brannon randomly observed OIW qualified welder Mr. Liam Bui ID#B10 welding fill pass's joining radical stiffener MK #c107 (HPS 485 W) to vertical stiffener MK#a107 (HPS 485 W) for hinge k pipe beam base assembly section a102-4. The partial joint penetration (PJP) groove weld is identified as weld joint #W1-97. Mr.

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Bui was observed welding in the 1G (flat) position utilizing submerged arc welding (SAW) process with a 2.4mm diameter electrode, filler metal brand Lincoln Electric LA85 class F9A4-Eni5-G-H2. QA Inspector Brannon observed the OIW QC CWI Inspector Mr. Steve Barnett verifying that the pre-heat of 350°F and welding parameters were in accordance with the Welding Procedure Specification (WPS). Welding parameters measured by QA are as follows for root/fill: 582 amps, 34.5 volts and a travel speed of 430mm per minute respectively appear to be in conformance with approved welding procedure specification WPS 4020 revision number 1.

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 Base Assembly, MK#102A-1 - MK#a111-1 forging to MK#a110-1 base plate idle.

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

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

Hinge-K Pipe Beam Sub Assembly, Half fuse section MK#a124-5.

Hinge-K Pipe Beam Sub Assembly, Half fuse section MK#a124-16.

Note: QA Inspector Brannon also, observed pending CWR repair for MK#102A-1 weld joint W2-13 and MK#120A-4 weld joint W2-13 both have pending 1st time UT repairs.

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 this 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-4 – MK#a124-4 half fuse to MK#a124-13 half fuse.

OIW Storage Yard

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

Hinge-K Pipe Beam Base Assembly, MK#102A-3 - MK#a111-3 forging to MK#a110-3 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-6 – MK#a124-9 half fuse to MK#a124-1 half fuse.

Hinge-K Pipe Beam Sub Assembly, Half fuse section MK#a124-8.

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 2 Supervisor's, 2 Quality Control and 2 production personnel on this date.

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

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## 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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