

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-007678**Date Inspected:** 02-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2000**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	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 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-8:

a125 stiffener ring to a124-8 Fuse

The QA Inspector intermittently monitored OIW welder Yuriy Bannikov (WID B61) during in progress Submerged Arc Welding (SAW) at weld joint WM3-14. The referenced connection joins a125 stiffener ring to a124-8 Fuse Section. The QA Inspector observed as OIW QC Inspector Steve Barnett performed Magnetic particle Testing (MT) and Visual Inspection (VT) of the completed root pass at weld WM3-14. Mr. Barnett stated that he had located no rejectable indications. The QA Inspector subsequently performed 100% VT & 10% MT verification at the location noted above finding the root pass to be in general compliance with contract documents. Please reference TL-6028 report for this date for details. Welder B61 deposited SAW fill and cover passes in the flat (1G) position in accordance with approved welding procedure 4020 at the location referenced above. The QA Inspector noted the OIW welder was maintaining continuous preheat utilizing two torches. An OIW helper was observed assisting welder B61 during SAW process. 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 -- (35 volts, 585 amperes,

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457mm/min travel speed).

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-5:

a124-14 to a124-2

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

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

A124-9 to a124-1

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-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-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 W1-108. The referenced connection joins stiffeners b106 and ab106. The QA Inspector observed as OIW QC Inspector Steve Barnett performed Magnetic particle Testing (MT) and Visual Inspection (VT) of ground tack welds and subsequently the completed root pass at weld W1-108. This testing was performed for informational purposes at the behest of OIW quality control management. Mr. Barnett stated that he had located no rejectable indications. The QA Inspector intermittently observed as welder B10 continued to deposit SAW fill and cover passes in the flat (1G) position in accordance with approved welding procedure. The QA Inspector noted the OIW welder was maintaining continuous preheat utilizing a torch. Weld joint W1-108 was completed during the shift. The QA Inspector observed OIW QC Inspector 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 -- (W1-82: 35 volts, 585 amperes, 432mm/min travel speed).

Hinge-K Pipe Beam Fuse Assembly 120A-3:

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

OIW Fabrication Shop-Bay 6

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.

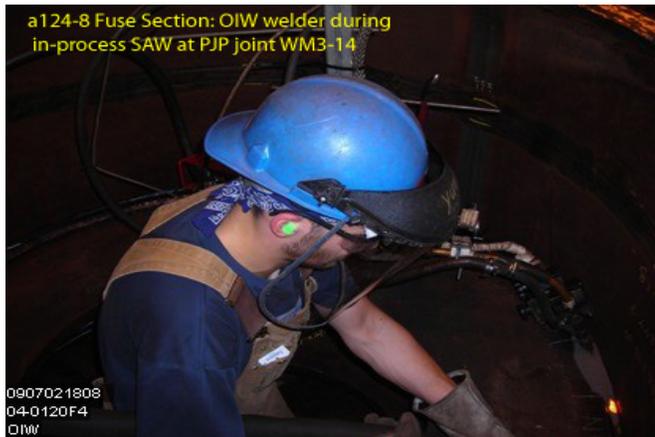
Material, Equipment, and Labor Tracking:

The QA Inspector performed verification of personnel involved with this project and equipment in use. The

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QA Inspector accounted for 3 OIW production personnel and 1 Quality Control Inspector present on this date.



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