

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008624**Date Inspected:** 20-Aug-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, Jose Salazar**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 3

Hinge-K Pipe Beam Assembly 102A-1: 8/20/09

a111-1 Forging to a110-1 Base Plate

QA Inspector noticed this assembly 102A-1 had been previously placed in position and welder #J6, Mr. Craig Jacobson, was in process of performing submerged arc welding, on the a106 stiffener plate to a110-1 base plate, designated as weld joint # W2-22, in the flat position. QA Inspector noted that this weld joint was designated as a multi-pass 10mm fillet weld and verified Mr. Jacobson was currently qualified for this process/position. QA Inspector noted that Mr. Jacobson was utilizing OIW approved welding procedure specification (WPS 4020) and randomly recorded pre-heat temperatures of approximately 350 degrees Fahrenheit. QA Inspector noticed QC Inspector Jose Salazar was present to monitor in-process welding parameters (amps/volts) and noted that Mr. Salazar had previously recorded in-process welding parameters of 563 amps and 35 volts, which appears to be in compliance with the applicable welding procedure specification and contract requirements.

QA Inspector witnessed welder #O6, Mr. Tim O'Brian, was in process of performing submerged arc welding, on the c106 stiffener plate to a107 stiffener plate, designated as weld joint # W1-167, in the flat position. QA

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Inspector noted that this weld joint was designated as a multi-pass 25mm fillet weld and verified Mr. O'Brian was currently qualified for this process/position. QA Inspector noted that Mr. O'Brian was utilizing OIW approved welding procedure specification (WPS 4020) and randomly recorded pre-heat temperatures of approximately 350 degrees Fahrenheit. QA Inspector noticed QC Inspector Jose Salazar was present to monitor in-process welding parameters (amps/volts) and noted that Mr. Salazar had previously recorded in-process welding parameters of 585 amps and 35 volts, which appears to be in compliance with the applicable welding procedure specification and contract requirements.

Hinge-K Pipe Beam Assembly 102A-3: 8/20/09

a111-3 Forging to a110-3 Base Plate

QA Inspector witnessed welder #H49, Mr. Rick Hinkle, was in process of submerged arc welding (SAW), on the a106 stiffener plate to a110-3 base plate, designated as weld joint # W2-21, in the flat position. QA Inspector noted that this weld joint was designated as a 10mm fillet weld and QA Inspector verified Mr. Hinkle was currently qualified for this process/position. QA Inspector noted that Mr. Hinkle was utilizing OIW approved welding procedure specification (WPS 4020) and randomly recorded pre-heat temperatures of approximately 350 degrees Fahrenheit. QA Inspector noticed QC Inspector Jose Salazar was present to monitor in-process welding parameters (amps/volts) and noted that Mr. Salazar had previously recorded in-process welding parameters of 430 amps and 28 volts, which appears to be in compliance with the applicable welding procedure specification and contract requirements.

Hinge-K Pipe Beam Assembly 102A-4: 8/20/09

a111-4 Forging to a110-4 Base Plate

QA Inspector noticed that OIW had previously placed this forging assembly 102A-4 in position and was in-process of machining the completed stiffeners, utilizing a mechanical machining bit, as shown in attached picture below. QA Inspector had previously measured the stiffener heights to be approximately 662mm and noted that approximately 12mm of material (485W) was in process of being removed, to achieve a desired result of 650mm (+3mm/-10mm), which is in accordance to contract requirements. QA Inspector spoke with OIW machinist and OIW explained that the mechanical machining bit was set to remove approximately 1/32" (.8mm) of material (485W), per each cutting pass. QA Inspector noted that once the machining process is complete, OIW will perform dimensional measurements utilizing a laser tracker, prior to fitting the a109 (Post Tension Cap) plates.

OIW Fabrication Shop-Bay 6 (ESW Overlay Process)

Hinge-K Pipe Beam Fuse Assembly 120A-2: 8/20/09

a124-3 Half Fuse to a124-11 Half Fuse

QA Inspector noticed that the ESW stainless steel overlay passes were in-process, on this fuse assembly 120A-2. QA Inspector witnessed welder #F17, Mr. Igor Frolov performing electro slag welding (ESW) on the third and final layer welding passes, (approximately 80% complete), in the flat position, utilizing Soudokay brand Soudotape 316L stainless steel consumable strip. QA Inspector noted the first layer passes were previously completed utilizing the 309L consumable strip and second layers utilizing the 316L consumable strip, per contract requirements. QA Inspector randomly noticed QC Inspector's Mike Gregson and Jose Salazar were present, to verify in-process welding parameters (amps/volts) and monitor in-process continuous pre-heat temperatures. QA Inspector spoke with QC Inspector Jose Salazar and Mr. Salazar explained that welding amps were recorded as 1200 amps/25.3 volts, travel speed at 241mm/min. and a pre-heat temperature recorded at 70 degrees Fahrenheit

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(20 C). QA Inspector verified Mr. Igor Frolov was currently qualified for this welding process/position and randomly recorded pre-heat temperatures of approximately 70 degrees Fahrenheit. QA Inspector noted that Mr. Igor Frolov appeared to be in compliance with the applicable approved welding procedure specification (WPS 7003).

A&G Machining

Hinge-K Pipe Beam Fuse Assembly 120A-8: 8/20/09

a124-8 Half Fuse to a124-16 Half Fuse

QA Inspector arrived at AG Machining, on this date and noticed that OIW had previously transferred fuse assembly 120A-8 to AG and this assembly had been placed in a horizontal lathe, in preparation for rough machining. AG machinist explained that OIW had previously picked up fuse assembly 120A-7, on this date and transferred back to OIW fabrication shop. AG explained that final outside diameter measurements were taken and recorded as follows:

1902.46mm

1902.82mm

1902.87mm

1902.94mm

1902.79mm

1902.59mm

1902.64mm

1902.74mm

1902.87mm

QA Inspector noted that these outside diameter values (after rough machining), appear to be in compliance with contract requirements of 1900mm (+/- 3mm).

Note: AG Explained that this fuse assembly 120A-8 will remain idle and rough machining would start at a later date. See attached picture below.

Material, Equipment, and Labor Tracking

QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project.

The QA Inspector observed at Oregon Iron Works: 6 OIW production personnel and 2 QC Inspectors.



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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
