

**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-009245**Date Inspected:** 28-Sep-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-2: 9/28/09

a111-2 Forging to a110-2 Base Plate

QA Inspector noticed that welder #O6, Mr. Tim O'Brian and #J6, Mr. Craig Jacobson, were in-process of grinding and performing weld clean-up, on the PJP and fillet welds stiffeners to a111-2 forging and a107/b106/ab106 stiffeners. QA Inspector spoke with lead QC Inspector Mike Gregson and Mr. Gregson explained that the blending and weld clean-up was being performed on the weld transitions and weld spatter/undersize welds were being repaired, which were previously marked by QC Inspector Jose Salazar. Mr. Gregson also explained that the completed fillet and PJP welds on the radial stiffeners, which were found to be visually acceptable per AWS D1.5 and contract requirements, were in process of 100% magnetic particle inspection by QC Inspector Jose Salazar. QA Inspector noted that the in-process visual and magnetic particle testing by OIW QC Inspectors appeared to be in compliance with AWS D1.5 and contract requirements. See attached picture below.

Hinge-K Pipe Beam Assembly 102A-3: 9/28/09

a111-3 Forging to a110-3 Base Plate

QA Inspector witnessed OIW QC Inspector Jose Salazar performing 100% visual and magnetic particle testing on

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## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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the completed weld repair (WRR #2244-28). QA Inspector later spoke with QC Inspector Jose Salazar and Mr. Salazar explained that no rejectable indications were found, per AWS D1.5 and the applicable welding procedure specification (WPS 3048). QA Inspector noted that the magnetic particle testing had been performed after the minimum 48hrs. cooling time. QA Inspector performed 100% visual and magnetic particle testing on the completed weld repair (WRR #2244-28), and found no rejectable indications, per AWS D1.5 and the applicable welding procedure specification (WPS 3048). QA Inspector notified Lead QC Inspector Mike Gregson of the testing results and completed the applicable magnetic testing report (TL6028). See attached pictures below. Note: QA Inspector previously noted that this non-critical weld repair was submitted by OIW after QC Inspector Jose Salazar had found multiple linear indications, utilizing magnetic particle testing, on the full length FCAW tacks and into the a111-3 forging base metal, on the following stiffeners: e108 (WJ #126, 127), f108 (WJ #138, 139), c107 (WJ #142, 143), e108 (WJ #146, 147) and d108 (WJ #148, 149). QA Inspector previously spoke with QC Inspector Jose Salazar and Mr. Salazar explained that the FCAW on weld joints, on the above mentioned weld joints, had been completed by OIW welder #J6, Mr. Craig Jacobson, post heat had previously been applied to the completed weld repair areas, with a recorded temperature of approximately 450 degrees Fahrenheit (232 C) and the welds were previously ground flush.

OIW Fabrication Shop-Bay 6 (ESW Overlay Process)

Hinge-K Pipe Beam Fuse Assembly 120A-6: 9/28/09

a124-14 Half Fuse to a124-2 Half Fuse

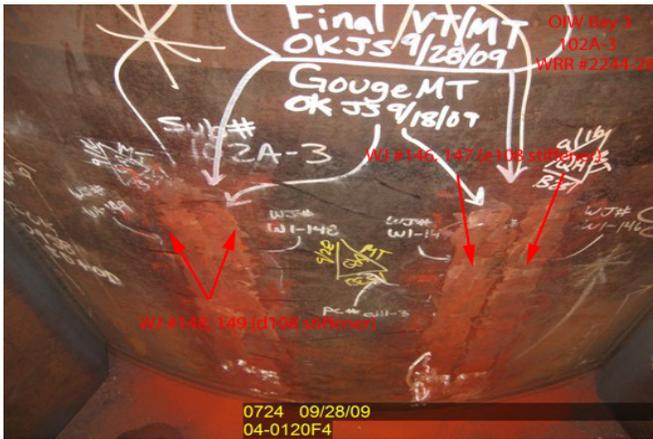
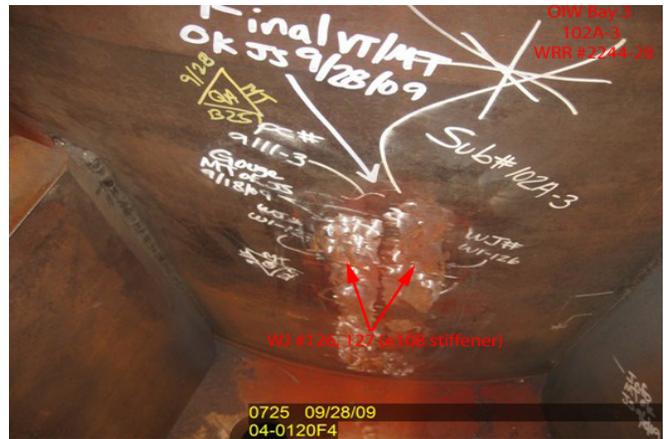
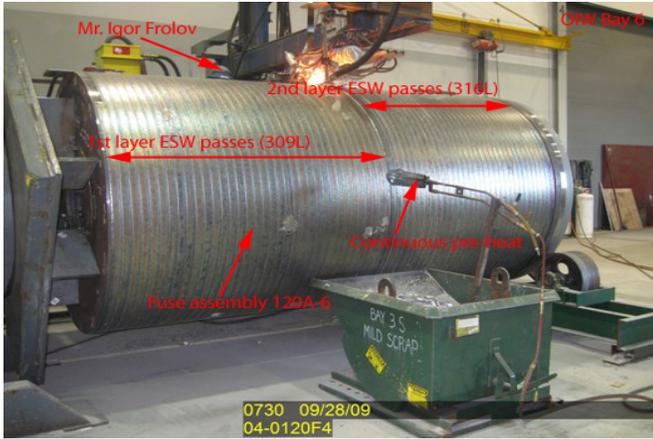
QA Inspector noticed that the second ESW stainless steel overlay passes were in-process, on this fuse assembly 120A-6. QA Inspector witnessed welder #F17, Mr. Igor Frolov performing electro slag welding (ESW) on the second layer welding passes, (approximately 50% complete), in the flat position, utilizing Soudokay brand Soudotape 316L stainless steel consumable strip. QA Inspector noted the first layer passes had previously been completed utilizing the 309L consumable strip and the remaining second (in-process) & third layer passes would be completed utilizing Soudokay brand Soudotape 316L stainless steel 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/25.2 volts, travel speed at 269mm/min. and a pre-heat temperature recorded at 70 degrees Fahrenheit (21 C). QA Inspector verified in-process welding parameters of 1200 amps/25.2 volts and recorded pre-heat temperatures of approximately 70 degrees Fahrenheit (21 C). QA Inspector verified Mr. Igor Frolov was currently qualified for this welding process/position and noted that Mr. Igor Frolov appeared to be in compliance with the applicable approved welding procedure specification (WPS 7003). 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: 5 OIW production personnel and 2 QC Inspectors.

# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )



## 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.

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# WELDING INSPECTION REPORT

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