

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-009272**Date Inspected:** 25-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**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 Base Assembly 102A-2:**

a111-2 forging to a110-2 base plate

The QA Inspector intermittently monitored OIW welders Phuong Huynh (WID H4) and Yuriy Bannikov (WID B61) as they engaged in grinding at interior weld terminations in an attempt to achieve a 2:1 transition at these locations. Welders H4 & B61 were engaged in this activity for the duration of the shift.

OIW Fabrication Shop-Bay 6**Hinge-K Pipe Beam Fuse Assembly 120A-6:**

a124-9 to a124-1

The QA Inspector intermittently observed OIW qualified welder Vincent Vu (WID V7) during in-process welding of Soudotape 316L stainless steel overlay to hinge k pipe beam fuse sub-assembly 120A-6. The weld joint is identified as 316L 2nd layer. Mr. Vu was observed welding in the flat position utilizing automatic electro slag welding (ESW) overlay process with a .5mm x 60mm Soudotape 316L stainless electrode, filler metal brand Soudotape class EQ316L automatic. An OIW helper was observed assisting welder S74 during ESW activity. The QA Inspector observed OIW QC Inspector Steve Barnett regularly monitoring and recording the in process ESW

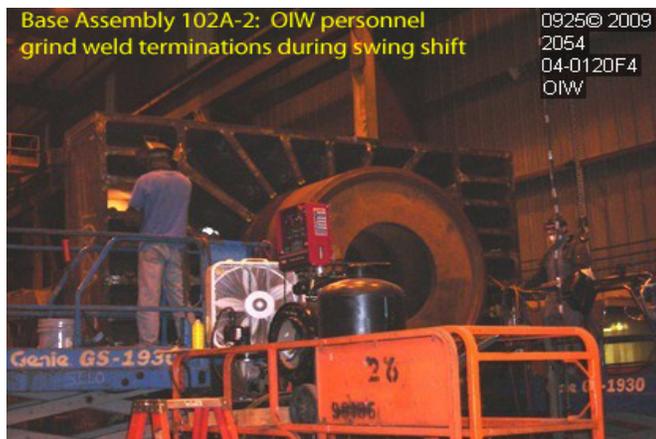
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parameters. The QA Inspector also intermittently observed in process welding parameters and determined that the ESW parameters (1200 amps, 25.4 volts, 267mm/min travel speed) and minimum preheat temperature of 225° F appeared to be in general compliance with the contract requirements and approved OIW Welding Procedure Specification (WPS) 7003.

Material, Equipment, and Labor Tracking:

The QA Inspector performed verification of personnel involved with this project and equipment in use. The QA Inspector accounted for 5 OIW production personnel and 2 Quality Control Inspectors present on this date during swing shift.



Summary of Conversations:

The QA Inspector was asked by OIW QC Inspector Mr. Steve Barnett if there was any record of a Carlos Rodriguez (WID C33) being qualified to weld on the contract. After reviewing the most current revision of the approved welders list (Rev. 12, 9-18-2009) the QA Inspector informed Mr. Barnett that there was no record of Mr. Rodriguez' approval. Mr. Barnett stated that welder C33 had been welding on graveyard shift and further stated that he would ensure that this would not continue on Sunday 9-27/28 graveyard shift or at all until the question of Mr. Rodriguez' certification status was clarified. The QA Inspector informed Caltrans Task Leader Joe Adame of the above via voicemail and email.

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
