

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-009470**Date Inspected:** 02-Oct-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: 10/2/09

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.

Note: QA Inspector later spoke with QC Inspector Jose Salazar and Mr. Salazar explained that the following weld joints had previously been completed and 100% visual and magnetic particle testing had been performed and no rejectable indications were found: WJ #W2-21, W2-22, W1-93, W1-101, W1-155 and W1-110. QA Inspector noted that visual/magnetic particle testing, performed by Mr. Salazar, appeared to be in compliance with AWS D1.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

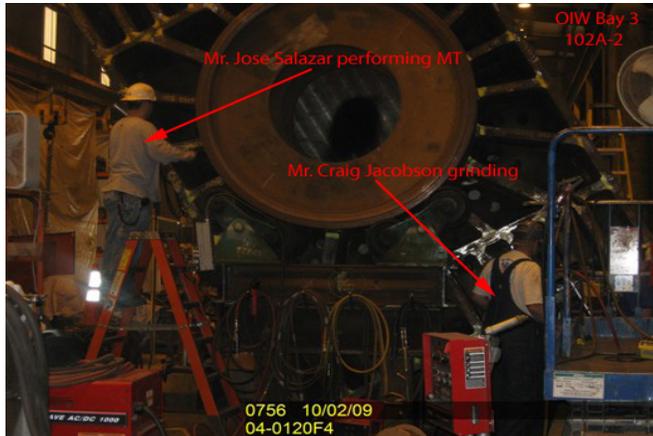
---

---

5 and contract requirements. Mr. Salazar also explained that the final grinding/weld-clean-up and magnetic particle testing was complete, on these radial stiffeners and this assembly 102A-2, would be removed from the positioner on 10/3/09. Mr. Salazar explained that the assembly 102A-3, would eventually be placed in the positioner, for the SAW on the previously tack welded stiffeners.

## 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.



## 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.

---

<b>Inspected By:</b>	Vance,Sean	Quality Assurance Inspector
----------------------	------------	-----------------------------

---

<b>Reviewed By:</b>	Adame,Joe	QA Reviewer
---------------------	-----------	-------------

---