

**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-009524**Date Inspected:** 07-Oct-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

<b>CWI Name:</b>	Steve Barnett		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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 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 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-6:**

a124-9 to a124-1

The QA Inspector was informed on 10-1-2009 by Caltrans Task Leader Joe Adame that Electro-Slag welding (ESW) activity at the Corrosion Resistant Overlay (CRO) would be paused due to the exhaustion of the ESW electrode supply. Mr. Adame indicated that a further supply had been ordered and was expected on site in approximately 1 to 1 1/2 weeks from that date.

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## WELDING INSPECTION REPORT

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South Lay Down Yard  
Fuse Assembly 120A-2  
a124-3 to a124-11

Day shift QA Inspector Sean Vance stated during turnover that Assembly 120A-2 had been marked up for pick-up at multiple locations for removal of spatter, breaking of edges, etc... prior to shipment to Vancouver, WA for blast and paint. Mr. Vance stated that he had clearly marked the areas of concern with yellow paint marker. The referenced areas had not been adequately addressed by the end of day shift. The QA Inspector discussed the situation with QC Inspector Steve Barnett and was informed that the work was to be completed on swing shift in order to facilitate an early AM shipping time on the following day. The QA Inspector intermittently monitored OIW welder Bounheune Savahn (WID S74) as he ground multiple locations within the assembly as directed and performed some additional pick-up that he and Mr. Barnett identified during the process. The QA Inspector subsequently performed Visual Inspection (VT) of the locations in question and found the assembly to be in general compliance with contract requirements for condition prior to blast/paint. The QA Inspector informed Mr. Vance of the above via e-mail.

#### 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 2 OIW production personnel and 2 Quality Control Inspectors present on this date during swing shift.

#### 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.

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

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