

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-009989**Date Inspected:** 03-Nov-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		
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 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-3: 11/3/09

a111-3 Forging to a110-3 Base Plate

QA Inspector noticed that the partial joint penetration and fillet welds were previously completed, on the HPS 485W stiffeners and OIW production personell were in-process of performing weld clean-up, on the above mentioned stiffeners. QA Inspector spoke with QC Inspector Jose Salazar and Mr. Salazar explained that OIW welders # O6, Mr. Tim O'Brian and #T23, Mr. John Tellone were blending the weld start/stops, removing weld spatter and grinding all areas, which were previously marked by OIW QC Inspectors. Mr. Salazar also explained that the completed fillet and PJP welds on above mentioned stiffeners, which were found to be visually acceptable per AWS D1.5 and contract requirements, will then be 100% magnetic particle tested by qualified OIW QC Inspectors. QA Inspector noted that the in-process visual testing by OIW QC Inspector Jose Salazar, appeared to be in compliance with AWS D1.5 and contract requirements. See attached picture below.

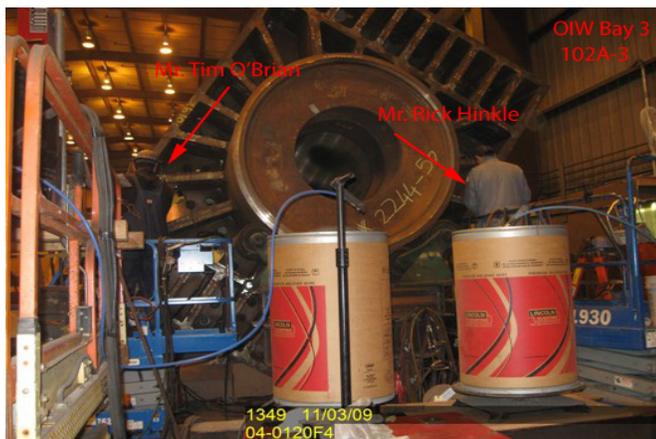
Note: QA Inspector spoke with lead QC Inspector Mike Gregson and Mr. Gregson explained that no welding was performed on the project, on this shift.

Material, Equipment, and Labor Tracking

WELDING INSPECTION REPORT

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QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project. The QA Inspector observed at Oregon Iron Works: 3 OIW production personnel and 2 QC Inspectors. The QA Inspector noted that the following were present at AG Machine shop: 1 Machinist and 1 Supervisor. The QA Inspector noted that the following were present OIW Vancouver paint shop: 1 Painter and 1 Supervisor.



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
