

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-010467**Date Inspected:** 25-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**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:

Hinge-K Pipe Beam Assembly 102A-3: 11/25/09

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.

AG Machining

Hinge-K Pipe Beam Fuse Assembly 120A-1: 11/25/09

a124-6 Half Fuse to a124-7 Half Fuse

QA Inspector arrived at AG at approximately 0930, this morning and noted that AG was currently in-process on

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the third and final machining cut pass, approximately 40% complete. QA Inspector spoke with AG machinist and AG explained that this final cut pass will machine the outer diameter to the upper end (1921mm), measured tolerance. AG explained that approximately 30+ visual indications were present, at this time, on the exterior overlay, that will require weld repairs or machining out. AG explained that this 3rd cut pass should be completed by Mon. (11/30) morning and that OIW was previously notified of the visual indications that were present and AG explained that OIW management is meeting today, to discuss this and decide how to proceed. See attached pictures below.

Note: QA Inspector noted that these visible surface indications were similar in length/depths as the previous indications that were discovered at AG, during the final machining of fuse assembly 120A-2. The indications on 120A-2, previously appeared during the second machining cut pass (as in this case) and OIW performed the TIG weld repairs at AG.

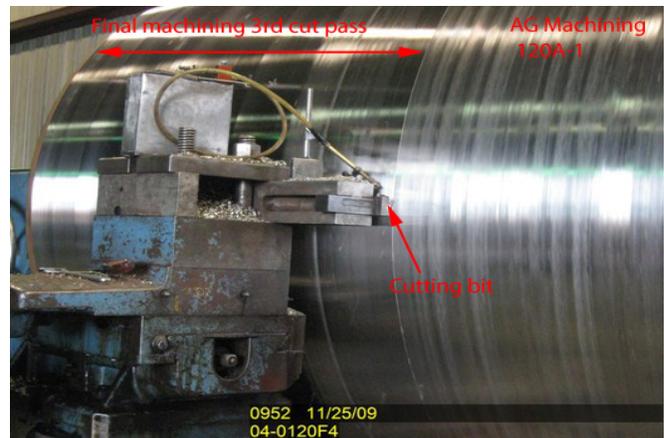
Material, Equipment, and Labor Tracking

QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project.

The QA Inspector observed at Oregon Iron Works: 2 OIW production personnel and 2 QC Inspectors.

The QA Inspector observed at AG Machine shop: 1 machinist and 1 supervisor.

The QA Inspector noted that no work was performed at OIW Vancouver paint shop:



Summary of Conversations:

As noted above.

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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
