

**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-010722**Date Inspected:** 08-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR**CWI Name:** M. Gregson, J. 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: 12/8/09

a111-3 Forging to a110-3 Base Plate

QA Inspector noticed that the partial joint penetration and fillet welds, designated as weld joints #W1-01 thru W1-163, were previously completed 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 welder # O6, Mr. Tim O'Brian was continuing to blend the weld start/stops, removing weld spatter and grinding all areas, which were previously marked by OIW QC Inspectors. Mr. Salazar explained that the visual clean-up that was being performed by Mr. O'Brian, was intermittently monitored by Mr. Salazar and areas that were previously marked up and completed, were then visually re-inspected, per AWS D1.5 and contract requirements. 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.

Hinge-K Pipe Beam Assembly 102A-1: 12/8/09

a111-1 Forging to a110-1 Base Plate

QA Inspector noted that welder #T23 Mr. John Tellone, had previously completed the submerged arc welding root pass, designated as weld joint #W2-23, in the flat (1G) position, utilizing OIW approved welding procedure

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specification (WPS 4020). QA Inspector spoke with QC Inspector Jose Salazar and Mr. Salazar explained that the above mentioned weld joint had previously cooled to ambient temperature and 100% visual and magnetic particle testing was to be performed on the root pass. QA Inspector witnessed Mr. Salazar performing the magnetic particle testing and noted that no rejectable indications were found. QA Inspector noted that Mr. Salazar signed off next to the weld joint as VT/MT ok, on this AWS D1.5 TC-P4-S, root pass. QA Inspector then performed approximately 25% magnetic particle testing and 100% visual testing on this SAW root pass and found no rejectable indications, per AWS D1.5 and contract requirements. See attached pictures below and completed TL 6028, for additional details.

## 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 1 QC Inspector. The QA Inspector noted that the following personell were present at AG Machine shop: 1AG machinist and 1 supervisor.

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



## 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

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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>	Vance,Sean	Quality Assurance Inspector
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<b>Reviewed By:</b>	Adame,Joe	QA Reviewer
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