

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-011899**Date Inspected:** 10-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR

CWI Name:	M. Gregson, J. Salazar, G. Mundt	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

The QA Inspector was informed by OIW QC Inspector Jose Salazar that the Visual (VT) and Magnetic Particle testing (MT) was previously completed on the Critical Weld Repairs (CWR's) #2244-011 and #2244-020. QC Inspector Salazar explained that the VT/ MT was performed after the minimum 48 hrs. cooling time, per AWS D1.5 and no rejectable indications were found. QC Inspector Salazar explained that the VT/MT was performed in accordance to AWS D1.5 and the OIW approved MT procedure QC-113, Rev. #3. The QA Inspector reviewed QC Inspector Salazar's MT reports for the completed CWR's and noted that the testing had been performed on 2/8/10 (CWR #011) and 2/10/10 (CWR# 020). The QA Inspector noted that the Flux-core Arc Welding (FCAW) had been previously completed on 2/2/10 and the testing performed by QC Inspector appeared to be in compliance with the minimum 48 hrs. cooling time. The QA Inspector reviewed the contract drawings and CWR Reports and noted that the CWR #011 was submitted for linear indications discovered during MT testing on the completed WJ #127, piece mark e108 to a111-3. These indications appeared in the weld toe and termination, of the weld joint. The QA Inspector then reviewed the contract drawings and CWR Reports and noted that the CWR #020 was submitted for linear indications discovered during MT testing on the completed WJ #126, piece mark a111-3. These indications appeared in the forging material, behind the weld joint. The QA Inspector performed 100% Visual and magnetic particle testing on the above mentioned CWR's and found no rejectable indications. The QA

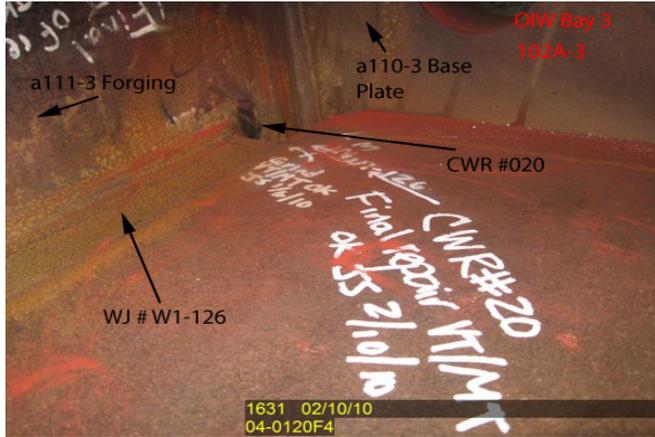
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Inspector then notified OIW Lead QC Inspector Mike Gregson of the testing results and completed an applicable Magnetic Testing Report (TL 6028), on this date. See attached pictures below.

Material, Equipment, and Labor Tracking (MELT)

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.



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
