

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-012234**Date Inspected:** 17-Feb-2010**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:

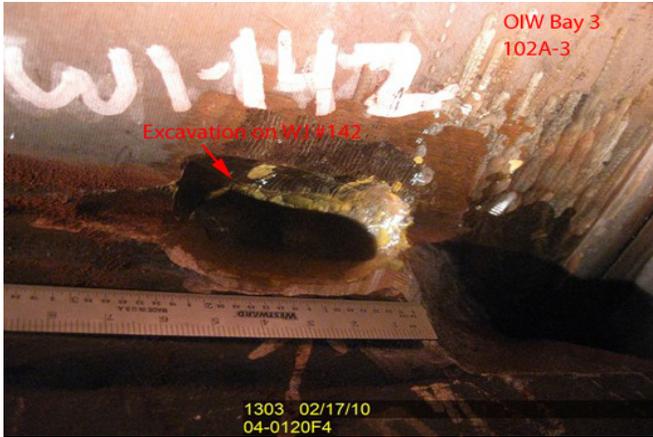
The QA Inspector was informed by OIW QC Inspector Jose Salazar that the Visual (VT) and Magnetic Particle testing (MT) was completed on the excavated areas, for the Critical Weld Repairs (CWR's). QC Inspector Salazar explained that these linear indications were excavated, that were discovered during the Final MT of CWR's #2244-016 and #2244-017. QC Inspector Salazar explained that the indications were discovered in different locations than the original repairs. QC Inspector Salazar explained that due to the locations in the weld joints, that 2 new CWR's will be submitted by OIW, detailing the locations, measurements and conditions of the linear indications. QC Inspector Salazar explained that the VT/MT was performed in accordance to OIW approved MT procedure QC-113, Rev. #3 and AWS D1.5. QC Inspector Salazar explained that no rejectable indications were found. The QA Inspector then performed 100% VT/MT on the completed excavations and found no rejectable indications. The QA Inspector measured the excavations and recorded the measurements as follows: Weld Joint #142 (c107 to a111-3), 60 mm L x 20 mm W x 15 mm D and Weld Joint #145 (a108 to a111-3), 280 mm L x 20 mm W x 15 mm D. The QA Inspector was informed by QC Inspector Salazar that no welding will be performed until OIW submits the applicable Critical Weld Repair Report (CWR) and receives State approval to continue. The QA 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.

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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: 2 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
