

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-013403**Date Inspected:** 22-Apr-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, 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 101A-2:

The QA Inspector was informed by OIW QC Inspector Jose' Salazar that the final Visual and Magnetic Particle Testing (VT/MT) was now complete, on the Weld Joint #W4-01. The QA Inspector noted that this is a Complete Joint Penetration (CJP), AWS D1.5 B-U7-S, piece mark Fuse 120A-5 to Forging 102A-2. QC Inspector Salazar explained that the outside portion of the weld joint was previously tested by Graveyard shift QC Inspector Jon Nickolich and no rejectable indications were found. QC Inspector Salazar explained that he had tested the interior portion of the weld joint and no rejectable indications were found. QC Inspector Salazar explained that the testing was performed in accordance to OIW approved procedure QC-113 Rev. #3. QC Inspector Salazar explained that he was in process of completing a testing report, on the above mentioned inspection. QC Inspector Salazar then explained that OIW production will possibly remove this assembly from the welding positioner, on this date. The QA Inspector then performed approximately 10% random Magnetic Particle Testing and found no rejectable indications, on both the exterior and interior portion of the weld joint. The QA Inspector then completed an applicable Magnetic Particle Testing report, on this date. The QA Inspector noted that the VT/MT testing performed by OIW QC Personell, appeared to be in compliance with AWS D1.5 and the applicable testing procedure.

The QA Inspector later witnessed OIW Production Lead Troy Smith and WID #B62 (Marcus Belgarde) attaching

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

4 slings and shackles around the Fuse section of the assembly. The QA Inspector then witnessed the slings being attached to the overhead crane and lifted up from the positioner and placed on the South end of the production Bay 3. The QA Inspector then witnessed OIW Production placing a previously fabricated carbon steel end piece, into the Fuse end section for support, after the slings are removed. Production Lead Troy Smith explained to the QA Inspector that the outer shrouds will eventually be removed, for an inspection on the stainless steel overlay, after welding of the CJP. Lead Troy Smith explained that this will probably be performed on the following day and an OIW QC Inspector, will be notified to perform the inspection. 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: 4 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Vance,Sean	Quality Assurance Inspector
----------------------	------------	-----------------------------

Reviewed By:	Adame,Joe	QA Reviewer
---------------------	-----------	-------------
