

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-014540**Date Inspected:** 04-Jun-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-3:

The QA Inspector observed OIW WID #B62 (Marcus Belgarde) performing Flux Core Arc Welding (FCAW) tacking on the Complete Joint Penetration (CJP), weld joint designated as an AWS D1. 5 B-U7-S. The QA Inspector observed that this was the 120A-4 Fuse to Forging 102A-4 weld joint.

The QA Inspector observed WID #B62 was performing the tacking in the vertical position and was currently qualified to perform this. The QA Inspector observed that OIW QC Inspector Jose Salazar was present on this shift and QC Inspector Salazar explained that he had previously recorded average in-process welding parameters of 240 amps, 25 volts and a pre-heat temperature of 350 degrees Fahrenheit. QC Inspector Salazar explained that the travel speed was previously recorded at 22 inches per minute and the Welding Procedure Specification (WPS) 3048 was being utilized for the tacking. The QA Inspector verified these welding parameters to be in compliance with the applicable WPS and randomly performed a pre-heat check, utilizing a 350 degree Fahrenheit Tempilstick temperature indicator. The QA Inspector observed that the FCAW appeared to be in compliance with the applicable WPS.

The QA Inspector observed that by the end of shift the tacks were complete and the Submerged Arc Welding on the weld joint was currently pending the FARO measurement, QC acceptance of fit-up, set-up of the interior scaffold, stationary torches and related SAW equipment. See attached pictures below.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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 Clackamas: 3 OIW production personnel and 2 QC Inspectors.



Summary of Conversations:

The QA Inspector was previously informed by AG Machine Works that no machining will be performed on the Fuse 120A-8, on this date.

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
