

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-015026**Date Inspected:** 17-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:

AG Machining (Boring, OR)

On this date, the QA Inspector arrived at AG Machine to observe OIW perform the weld repairs, on the finished overlay surface, on this Fuse 120A-8. Upon arrival, the QA Inspector met with OIW QC Inspector Jose Salazar, OIW welder (WID# C34) Mark Craig and AG Machinist, Terry Schmale.

QC Inspector Salazar explained that WID #C34 will be performing the Gas Tungsten Arc Welding (GTAW), on the previously excavated areas, on the finished overlay. QC Inspector Salazar explained that WID #C34 is currently qualified to perform these repairs and will be utilizing welding procedure specification (WPS 8022). The QA Inspector then witnessed WID #C34 performing the pre-heat required, utilizing a torch and then observed QC Inspector Salazar perform a pre-heat check, utilizing a digital thermometer, of approximately 200 degrees Fahrenheit, after the pre-heat was complete. The QA Inspector noted that 125 degrees Fahrenheit minimum was required, per WPS 8022. The QA Inspector then witnessed AG Machinist, Terry Schmale, rotating the fuse assembly in the horizontal lathe, to access the weld repair areas in the flat position. The QA Inspector then observed WID #C34 continue to perform the GTAW on the previously excavated repair areas and observed QC Inspector Jose Salazar, recording in-process welding parameters of 123 amps and 16 volts. The QA Inspector also verified these welding parameters.

At approximately 1400, QC Inspector Salazar explained that the GTAW was complete and that the areas which

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were repaired, will require grinding flush to the overlay surface. QC Inspector Salazar explained that he wasn't sure when the grinding will be performed.

On this date, the QA Inspector noted that the above mentioned grinding, the final FARO testing (cylindricity and diameter), final PT and surface finish checks by OIW, was still pending. 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 Clackamas: 3 OIW production personnel and 2 QC Inspectors.

The QA Inspector observed at AG Machine Works: 1 machinist and 1 supervisor.



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.

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Inspected By: Vance,Sean

Quality Assurance Inspector

Reviewed By: Adame,Joe

QA Reviewer