

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-015027**Date Inspected:** 18-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 Darren Dozier, performing backgouging on the weld joint, designated as # W4-01. The QA Inspector noted that this weld joint was the 120A-3 Fuse to 102A-3 Forging and designated as an AWS D1.5 B-U7-S, Complete Joint Penetration (CJP). The QA Inspector observed Mr. Dozier performing the backgouge in the vertical position, utilizing the Carbon Arc process and that pre-heat was intermittently applied, utilizing a previously set-up stationary torch or rosebud. The QA Inspector observed that the backgouge was being performed on the non-critical weld repair, which was previously ultrasonically tested and rejected by OIW QC Inspectors. The QA Inspector observed that Mr. Dozier was currently performing this backgouge on "indication #4", as recorded on OIW's Ultrasonic Examination Report (# 2244-10-UT-08) and that Mr. Shepherd was performing this, from the exterior of the weld joint. Mr. Dozier explained that at this time, no defect was visually discovered.

The QA Inspector observed that QC Inspector Jose´ Salazar was present and QC Inspector Salazar explained that the pre-heat was verified, prior to starting the Carbon Arcing on this non-critical weld repair.

The QA Inspector observed that the backgouging continued throughout the entire shift. The QA Inspector was informed by Lead QC Inspector Mike Gregson that the backgouging will continue on swing shift and will possibly start the Flux Core Arc Welding (FCAW), on the repairs.

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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 Clackamas: 3 OIW production personnel and 2 QC Inspectors.



Summary of Conversations:

On this date, the QA Inspector spoke with AG Machine Works machinist Terry Schmale. Mr. Schmale explained that OIW has not arrived to perform the grinding flush of the completed weld repairs. Mr. Schmale explained that OIW had transported the 2 Fuse shroud coverings earlier in the day. The QA Inspector noted that these shrouds will be used to cover and protect the Fuse during transport.

The QA Inspector then spoke with Lead QC Inspector Mike Gregson and Mr. Gregson explained that he did not know when OIW will send production personnel to AG Machine Works, to perform the grinding. The QA Inspector also spoke with production Lead Troy Smith and Mr. Smith explained that he did not know when the grinding will be performed.

The QA Inspector noted that the Fuse still has the grinding of the repairs, final FARO's, final Penetrant Testing and profile check pending, prior to the shrouds being placed and transport to OIW Vancouver facility for paint.

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
