

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 #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015841**Date Inspected:** 21-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Rick Rodriguez**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:** Travelers**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, 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:

Traveler Rails E2/E3-EB

On this date, the QA Inspector observed Westmont Industries (WMI) production personnel Mr. Tim Hartnett, was currently cutting material for the E2/E3-EB traveler rails, at a production station, identified as station # 1.

The QA Inspector observed that Mr. Hartnett was utilizing a Marvel Brand 15 A series horizontal band saw, to perform the cutting operations and observed that the material being cut, was identified as 5" x 3" x .1875" rectangular tubing.

Mr. Harnett explained to the QA Inspector that he was provided a list of material to be cut to a specific length, by the WMI shop foreman, Mr. George Graham, per the shop drawings. Mr. Harnett explained that he was cutting the material to these specific lengths and then the rectangular tubing, will then be transferred to another production station. Mr. Harnett explained further that at this production station, the required angles will then be marked for cutting, on the end or ends of the rectangular tubing.

The QA Inspector then observed that at this production station, identified as station # 2, WMI production personnel Mr. Juan Mora was present and currently laying out the angles on the end or ends of the above

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mentioned rectangular tubing.

The QA Inspector observed that Mr. Mora was utilizing a mechanical tri-square and white soapstone to perform this task. Mr. Mora explained to the QA Inspector that once the applicable angles were laid out per the shop drawings, that the rectangular tubing, will then be transferred to another production station, for cutting of the angles.

The QA Inspector then observed that WMI production Mr. Jose' Rodriguez was cutting these angles at this production station, identified as station # 3 and that Mr. Rodriguez was utilizing a Hem Saw Brand VT 130A-60 adjustable angle band saw, to perform this task.

The QA Inspector observed that once the angles were cut on the rectangular tube, Mr. Rodriguez then placed the rectangular tube on a wooden pallet, nearby the work area.

The QA Inspector later observed that the final finished cut rectangular tubing, had been transferred to a laydown area in the production bay and strategically placed in piles, for future fit-up and tack welding, on the E2/E3-EB traveler rails.

The QA Inspector observed that by the end of the shift that 32 pieces of the above mentioned material had been cut and beveled and the material appeared to be in compliance with the contract requirements.

The QA Inspector also observed that the above mentioned rectangular tubing, had been previously inspected by WMI QC Inspector Rick Rodriguez and that the Mill Test Report's (MTR's) had been previously provided to the QA Inspector. See attached pictures below.



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 Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Vance,Sean	Quality Assurance Inspector
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Reviewed By:	Edmondson,Fred	QA Reviewer
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