

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-016252**Date Inspected:** 05-Aug-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
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 Travelers. The QA Inspector arrived on site to randomly observe the WMI 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 E2/E3-EB

On this date, the QA Inspector observed Westmont Industries (WMI) production personnel Mr. Tim Hartnett, continuing to cut material for the E2/E3-EB Traveler.

The QA Inspector observed that Mr. Hartnett was continuing to utilize the Marvel Brand 15 A series horizontal band saw, to perform the cutting operations at production station # 1 and observed that the material being cut, is identified as 6" x 4" x .250" (152 mm x 101 mm x 6 mm), rectangular tube steel (TS).

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 Grayum, per the shop drawings. Mr. Harnett further explained that he was cutting the material to these specific lengths, which were provided and marking the TS material with a white paint stick marker, to identify the individual cut pieces of TS, per the shop drawing bill of material list. The QA Inspector observed that prior to identifying the tube steel with a paint marker, Mr. Harnett utilized acetone liquid cleaner, to prepare an area so that the identifying paint mark will stick.

Mr. Harnett explained that the TS will be utilized for the E2/E3-EB Traveler.

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The QA Inspector observed that Mr. Harnett continued cutting TS material throughout the shift and observed that the following material was cut and identified, for the E2/E3-EB Traveler:

2 each piece mark B261- 6" x 4" x .250" x 194.4375" (152 mm x 102 mm x 6 mm x 4939 mm) Rectangular TS
3 each piece mark H263- 3" x 2" x .1875" x 47.75" (76 mm x 51 mm x 5 mm x 1213 mm) Rectangular TS
8 each piece mark K263- 3" x 2" x .1875" x 47.5625" (76 mm x 51 mm x 5 mm x 1208 mm) Rectangular TS
2 each piece mark B263- 6" x 4" x .1875" x 12.125" (152 mm x 102 mm x 5 mm x 308 mm) Rectangular TS
2 each piece mark A263- 6" x 4" x .1875" x 12.125" (152 mm x 102 mm x 5 mm x 308 mm) Rectangular TS
4 each piece mark F262- 6" x 4" x .1875" x 12.125" (152 mm x 102 mm x 5 mm x 308 mm) Rectangular TS
4 each piece mark C261- 6" x 4" x .1875" x 221" (152 mm x 102 mm x 5 mm x 5613 mm) Rectangular TS
2 each piece mark A261- 6" x 4" x .1875" x 413.8125" (152 mm x 102 mm x 5 mm x 10511 mm) Rectangular TS

The QA Inspector verified the dimensions of the above mentioned, cut to length TS material, per the shop drawings and the material appeared to be in compliance. See attached picture below.

Test Rack

On this date, the QA Inspector observed WMI production personnel, Mr. Jose' Rodriguez, continuing to cut material for the Traveler Test Rack.

The QA Inspector observed that Mr. Rodriguez was utilizing a Hem Saw brand VT 130A-60 adjustable angle band saw, to perform the cutting operations, at production station # 3.

The QA Inspector observed that the material being cut is identified as Wide Flange Beam (WFB) and that Mr. Rodriguez was performing a square cut on the end of the WFB. Mr. Rodriguez 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 Grayum, per the shop drawings. Mr. Rodriguez further explained that he was cutting the material to these specific lengths and marking the material with a white paint stick marker, to identify the individual cut pieces of material, per the shop drawing bill of material list.

The QA Inspector observed that Mr. Rodriguez continued cutting WFB material throughout the shift and observed that the following WFB material was cut, for the Test Stand:

12 each piece mark A19-W12 x 86 x 94.5 WFB

The QA Inspector observed that by the end of the shift, Mr. Rodriguez had written identifying numbers, per the Bill of Material list, on the cut to length WFB material.

The QA Inspector observed that there was a total of 20 cut to length pieces of WFB, with the piece mark identified as A19.

The QA Inspector verified the dimensions of the cut to length WFB material, per the shop drawings and the material appeared to be in compliance.

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The QA Inspector observed that the above mentioned TS and WFB material, had been previously inspected, with the MTR's provided and the QA Inspector had previously informed WMI that the material was OK to Cut. See attached picture 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 Westmont Industries: 1 QC, 1 supervisor and 2 production personnel.



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.

Inspected By: Vance, Sean

Quality Assurance Inspector

Reviewed By: Edmondson, Fred

QA Reviewer