

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-016305**Date Inspected:** 06-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 3" x .3125" (152 mm x 76 mm x 8 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 CS- 6" x 3" x .3125" x 201.75" (152 mm x 76 mm x 8 mm x 5124 mm) Rectangular TS
- 4 each-piece mark CW- 6" x 3" x .3125" x 16.875" (152 mm x 76 mm x 8 mm x 429 mm) Rectangular TS
- 2 each-piece mark B249- 6" x 3" x .3125" x 19.750" (152 mm x 76 mm x 8 mm x 502 mm) Rectangular TS
- 2 each-piece mark G250- 6" x 3" x .3125" x 9.8125" (152 mm x 76 mm x 8 mm x 249 mm) Rectangular TS
- 2 each-piece mark B251- 6" x 3" x .3125" x 68.250" (152 mm x 76 mm x 8 mm x 1734 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.

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 1 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.

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