

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-016406**Date Inspected:** 04-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, cutting material for the E2/E3-EB Traveler.

The QA Inspector observed that Mr. Hartnett was utilizing a 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 3 1/2" x 2 1/2" x .1875" rectangular tube steel.

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 supervisor, Mr. George Grayum, per the shop drawings. Mr. Harnett 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 prior to identifying the tube steel with a paint marker, Mr. Harnett utilized acetone solvent, to prepare an area, so that the identifying paint mark will adhere to the material.

The QA Inspector observed that Mr. Harnett continued cutting TS material throughout the shift and observed that

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the following material was cut and identified, for the E2/E3-EB Traveler:

2 each E256-3 1/2" x 2 1/2" x .1875" x 181 1/8" Rectangular Tube Steel
2 each F256-3 1/2" x 2 1/2" x .1875" x 181 1/8" Rectangular Tube Steel
2 each C256-3 1/2" x 2 1/2" x .1875" x 181 1/8" Rectangular Tube Steel
2 each FP-4" x 4" x .250" x 28 7/16" Square Tube Steel
2 each FW-4" x 4" x .250" x 28 1/2" Square Tube Steel
1 each D254-4" x 4" x .250" x 29 1/16" Square Tube Steel
1 each E254-4" x 4" x .250" x 29 1/16" Square Tube Steel

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

Testing Rack

On this date, the QA Inspector observed that WMI production personnel, Mr. Jose' Rodriguez, cutting material for the Traveler Testing 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 supervisor, 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 Testing Rack:

8 each-A19-W12 x 86 x 94 1/2 WFB

The QA Inspector observed that by the end of the shift, Mr. Rodriguez had not put identifying numbers, per the Bill of Material list, on the cut to length WFB material. Mr. Rodriguez explained that he will put identifying # A19 on the flange side of the WFB, once all 20 pieces of material are cut to length.

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

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 pictures below.

Material, Equipment, and Labor Tracking (MELT)

QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project.

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The QA Inspector observed at Westmont Industries: 1 QC, 1 supervisor and 2 production personnel.



Summary of Conversations:

On this date, WMI QCM Rick Rodriguez explained that WMI had previously received plate material, for the fabrication of the Travelers, from Steel Unlimited Inc., located in Rialto Ca.

Mr. Rodriguez explained that Steel Unlimited had completed a TL38 Caltrans Inspection Request form, for an inspection on the material, prior to releasing to WMI and the QA Inspector observed the material was strategically stacked in a banded pile, idle in WMI fabrication Bay # 4. The QA Inspector observed that the material had been cut at Steel Unlimited, in Rialto CA.

On this date, the QA Inspector observed that the plate material had been previously released by METS, has a green tag dated 8/2/10 and an assigned Lot # L15-137-10.

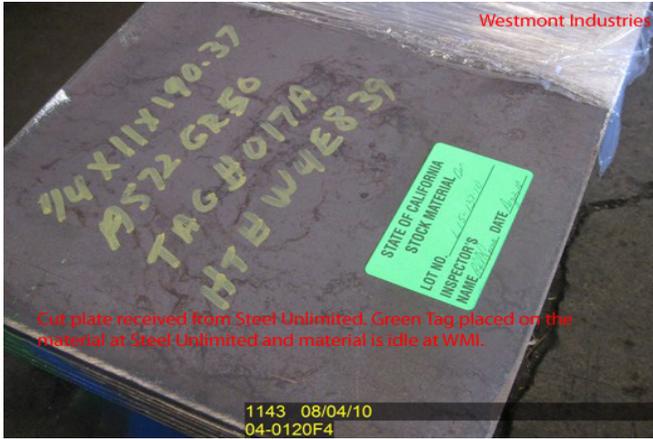
The material is identified as follows:

27 each-A572 Gr. 50 .250" x 11" x 190.37" plate-Heat # W4E849.

See attached picture below.

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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 |
