

**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-016407**Date Inspected:** 11-Aug-2010**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Westmont Industries**OSM Arrival Time:** 500**OSM Departure Time:** 1330**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 that WMI production personnel, Mr. David Mora, was cutting angles on rectangular and square Tube Steel (TS) material, at production station identified as # 3.

The QA Inspector observed that a Hem Saw brand VT 130A-60 adjustable angle band saw, was being utilized to perform this task.

The QA Inspector observed that Mr. Mora had placed a square wooden 4" x 4" wooden block on one end of the TS material to lift, so that the required angle could then be cut with the band saw.

Mr. Mora explained to the QA Inspector that various sizes of wooden blocks were previously cut and will be utilized to lift the end of the TS material, depending on which cut angle is required. Mr. Mora explained that the TS material had been previously cut to length and the angles on the material had been previously marked for cutting, per the shop drawing Bill of Material list.

The QA Inspector observed that once the angles were cut on the TS material, Mr. Mora then placed the material on

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a wooden pallet, nearby the work area and later observed that the material, had been transferred to a laydown area in the production bay and strategically placed in piles, for future fit-up and tack welding, for the E2/E3-EB Traveler.

The QA Inspector also observed that the TS material, 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.

The QA Inspector observed that the above mentioned TS material had been previously inspected by the QA Inspector and appeared to be in compliance with the contract requirements.

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:**

On this date, WMI QCM Rick Rodriguez explained that WMI had previously received material for the fabrication of the Travelers and Mr. Rodriguez explained that WMI will eventually cut the material.

Mr. Rodriguez explained that the material was located in production Bay # 4 and requested that the QA Inspector perform an inspection on the material, after providing the applicable MTR's .

The QA Inspector later performed an inspection on the material and the material appeared to be in compliance with the contract requirements.

See completed TL6034, on this date, for additional details.

**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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<b>Inspected By:</b>	Vance,Sean	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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