

**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-016408**Date Inspected:** 10-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 was informed by WMI Shop Superintendent George Grayum that no cutting operations will be performed on material for the E2/E3-EB Traveler. Mr. Grayum explained that no WMI production personnel will be performing any activities, related to the fabrication of the E2/E3-EB Traveler, due to other projects which WMI will be working on. Mr. Grayum further explained that cutting and fabrication activities on E2/E3-EB material, will possibly resume on the following day, 8/11/10.

The QA Inspector observed throughout the shift, that WMI production personnel had performed no cutting or fabrication of the E2/E3-EB material.

**Test Rack**

On this date, the QA Inspector was informed by WMI Shop Superintendent George Grayum, that cutting operations will be performed on Tube Steel (TS) material for the Test Rack. Mr. Grayum explained that the cutting will be performed in WMI Bay # 6 and will continue throughout the shift.

The QA Inspector later observed WMI production personnel, Sasan Maghame', present in WMI Bay # 6 and Mr.

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Maghame´ explained to the QA Inspector that he was provided a list of TS material, to be cut to specific lengths, by Superintendent George Grayum. Mr. Maghame´ further explained that the list of TS material to be cut included 7 each 16” x 16” x .50” x 109.25” square TS, identified as piece mark “b”, per the shop drawing bill of material list (# WMI-TTR-7). The QA Inspector observed that the TS material had been previously inspected by a Caltrans inspector and that 4 each of the 7 pieces had been cut on the previous date.

The QA Inspector observed Mr. Maghame´ measuring the above mentioned TS to length and marking, utilizing a framing square and soapstone, around the four sides of the TS. The QA Inspector then observed Mr. Maghame´ begin cutting the TS, utilizing a hand held oxygen acetylene cutting torch on the previously placed marks.

Once the first cut was complete, the QA Inspector observed Mr. Maghame´ utilize the overhead bay crane, chain and hook to rotate the TS, to begin cutting the second side of the TS. The QA Inspector observed that the TS material was rotated, in this fashion, to cut all four sides of the TS.

Mr. Maghame´ explained to the QA Inspector that finish grinding will be performed at a later date, to clean the flame cut edges of the TS, prior to fit-up and tack welding.

The QA Inspector later observed that 3 each pieces, of the above mentioned TS material, had been cut to length and the QA Inspector verified the cut to length material and the material appeared to be in compliance with the shop drawings.

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

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