

**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-016409**Date Inspected:** 12-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.

<b>CWI Name:</b>	Rick Rodriguez		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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 Mr. David Mora was continuing to cut angles on rectangular and square Tube Steel (TS) for the E2/E3-EB Traveler, 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 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, depending on which cut angle is required. Mr. Mora explained that the TS had been previously cut to length and the angles on the TS 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 rectangular tube, Mr. Mora then placed the TS on a wooden pallet, nearby the work area and later observed that the TS, had been transferred to a laydown area in the

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production bay and strategically placed in piles, for future fit-up and tack welding, on the E2/E3-EB Traveler.

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

### Assembly A214

On this date, the QA Inspector observed production personnel, Mr. Juan Mora, piecing or fitting together rectangular TS for E2/E3-EB Traveler Assembly A214.

The QA Inspector observed that the TS material had been previously cut to specific lengths and the desired bevels had been previously cut, per the approved shop drawings.

The QA Inspector observed Mr. Mora placing the TS material on a flat steel fabrication table and arranging the material, according to the piece marks which were previously marked on the TS. The QA Inspector observed that the material is marked and is listed as follows:

A248 (2 each 2.5" x 2.5" x .1875") (64 mm x 64 mm x 5 mm)

B248 (2 each 2.5" x 2.5" x .1875") (64 mm x 64 mm x 5 mm)

C248 (2each 2.5" x 2.5" x .1875") (64 mm x 64 mm x 5 mm)

AE (1 each 4" x 3" x .1875") (102 x 76 mm x 5 mm)

AF (1 each 3" x 3" x .1875") (76 x 76 mm x 5 mm)

The QA Inspector observed that once the material was arranged per the individual piece marks, that Mr. Mora then placed pieces of previously cut 3" x 3" x 3" (76 mm x 76 mm x 76 mm) angle material, on the flat steel fabrication table.

The QA Inspector later observed that a total of 20 pieces of angle had been placed in strategically located positions around the TS material, to fit and hold the material in place. Once the angle material was placed, the QA Inspector observed that Mr. Mora then tack welding the angle material pieces to the flat steel fabrication table. The QA Inspector observed Mr. Mora performing this task, throughout the shift and Mr. Mora explained that each individual weld joint for this assembly, will eventually be tacked at a later date.

The QA Inspector observed that the fitting of the TS material for assembly A214, appeared to be in compliance with the approved shop drawings.

See attached pictures below.

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## 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
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<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer
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