

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016522**Date Inspected:** 18-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 plate material is currently being cut, for the E2/E3-EB Traveler. Mr. Grayum informed the QA Inspector that the Pearson brand cutting shear, located in Bay # 4, is being utilized for the cutting operations and explained that the shear is capable of cutting plate material, up to .500" (12 mm) in thickness.

The QA Inspector later observed WMI production personnel Mr. Ruiz Villasenor, utilizing the Pearson shear to cut plate material. Mr. Villasenor explained that he was currently cutting .250" (6 mm) material, to be utilized for the fabrication of the E2/E3-EB Traveler. Mr. Villasenor also explained that he had previously and is currently reviewing the approved shop drawings, to generate a list of .250" (6 mm) thick plate material, per the Bill of Material list, to be cut from each sheet of plate material, with this thickness. Mr. Villasenor explained that this method is more efficient than having to remove each sheet of plate material and cut, with varying degrees of thicknesses. Mr. Villasenor explained that each sheet of plate material is placed in the shear for cutting, utilizing the overhead shop bay crane.

The QA Inspector observed that the above mentioned plate material had been previously inspected and the MTR's

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had been provided. The QA Inspector had previously written "OK to Cut", on the plate material.

The QA Inspector observed that the shearing or cutting of the plate material, continued throughout the shift and observed that by the end of shift, the following material was cut and identified on each piece, by Mr. Villasenor:

16 each-3" x 3" x .250"-Reference drawing # WMI-SAA-206-Piece mark # b
4 each-7.875" x 4" x .250"-Reference drawing # WMI-SAS-216-Piece mark # av
4 each-7.875" x 4" x .250"-Reference drawing # WMI-SAS-217-Piece mark # ay
4 each-7.875" x 4" x .250"-Reference drawing # WMI-SAS-223-Piece mark # ca
4 each-7.875" x 4" x .250"-Reference drawing # WMI-SAS-224-Piece mark # ce
2 each-1.5625" x 4" x .250"-Reference drawing # WMI-SAS-225-Piece mark # cp
2 each-2" x 3" x .250"-Reference drawing # WMI-SAS-246-Piece mark # gb

On this date, the QA Inspector observed WMI production personnel, Mr. Juan Mora, cutting Tube Steel (TS) material for the E2/E3-EB Traveler. The QA Inspector observed that Mr. Mora was cutting angles on the end or ends of the previously cut to length TS. The QA Inspector observed that Mr. Mora was utilizing a hand held oxygen/acetylene cutting torch to perform the cutting operations. Mr. Mora explained that he was cutting angles on the TS which were too difficult to cut on the Hem Saw vertical bandsaw. Mr. Mora explained that he was cutting the angles per the approved shop drawings. Mr. Mora explained that once the angles were cut, that finish grinding will be performed at a later date on the cut ends, prior to fit-up and tack welding.

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 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 and that the TS Material being cut, is per a cut list provided by Shop Superintendent George Grayum

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

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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 3 production personnel.



Summary of Conversations:

WMI QCM Rick Rodriguez explained that material had previously been delivered for the fabrication of the E2/E3-EB Traveler and Test Track. Mr. Rodriguez explained that he has inspected the material and requested that the QA Inspector perform an inspection on the material. 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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| Inspected By: | Vance, Sean | Quality Assurance Inspector |
| Reviewed By: | Edmondson, Fred | QA Reviewer |
