

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-016551**Date Inspected:** 19-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. Mr. Grayum had previously informed the QA Inspector that the shear is capable of cutting plate material, up to .500" (12 mm) in thickness.

The QA Inspector then 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 identical piece of plate material, of the identical thickness. Mr. Villasenor had previously 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

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shop bay crane and that 3/8" (10 mm) thick plate material will be placed in the shear, later in the shift and cutting will continue on the material for the E2/E3-EB Traveler (WMI Job # 11200).

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

2 each plate-Reference drawing # WMI-SAS-219-Piece mark # bp
1 each plate-Reference drawing # WMI-SAS-226-Piece mark # dh
1 each plate-Reference drawing # WMI-SAS-210-Piece mark # ab
2 each plate-Reference drawing # WMI-SAS-219-Piece mark # bn
1 each plate-Reference drawing # WMI-SAS-217-Piece mark # az
1 each plate-Reference drawing # WMI-SAS-216-Piece mark # aw
4 each plate-Reference drawing # WMI-SAS-214-Piece mark # ak
1 each plate-Reference drawing # WMI-SAS-224-Piece mark # cf
4 each plate-Reference drawing # WMI-SAS-216-Piece mark # av

Traveler Test Rack

On this date, the QA Inspector observed WMI production personnel, Mr. David Mora, cutting material for the Traveler Test Track, at production station identified as # 3.

The QA Inspector observed Mr. Mora utilizing a Hem Saw brand VT 130A-60 adjustable angle band saw to perform this task and observed that the material being cut was identified as 16" (406 mm) x 16" (406 mm) x .50" (13mm) square Tube Steel (TS) material. Mr. Mora explained that he was instructed by Shop Superintendent George Grayum to cut the material to length, per the shop drawings (Reference drawing # WMI -TTR-7-piece mark b).

The QA Inspector 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.

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.

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

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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.

Inspected By:	Vance, Sean	Quality Assurance Inspector
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Reviewed By:	Edmondson, Fred	QA Reviewer
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