

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016655**Date Inspected:** 25-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 had previously explained that the shear is capable of cutting plate material, up to .500" (13 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 material, to be utilized for the fabrication of the E2/E3-EB Traveler. Mr. Villasenor explained that he has generated a material cut list, from the shop drawing Bill of Material list and is utilizing this list to cut the plate material to specific sizes, per 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.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

On this date, the QA Inspector was informed by Westmont Industries (WMI) Quality Control Manager (QCM) Rick Rodriguez, that Ryerson Steel in Vernon, CA. has received plate material and requested the QA Inspector perform an inspection on the material. The QA Inspector arrived at Ryerson Steel, as requested. See completed TL-6034, 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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