

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-016768**Date Inspected:** 01-Sep-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:** R. Rodriguez, R. Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** 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.

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. Mr. Villasenor explained that he was currently cutting .1875" (5 mm) thick plate, with the shear.

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-Reference drawing # WMI-SAS-252-Piece mark D252

4 each-Reference drawing # WMI-SAS-210-Piece mark S

2 each-Reference drawing # WMI-SAS-226-Piece mark CX

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2 each-Reference drawing # WMI-SAS-247-Piece mark GK

The QA Inspector also observed that the plate material had been previously inspected with the MTR's provided and the QA Inspector had previously written "OK to Cut" on the material.

See attached picture below.

Trolley Test Stand

On this date, the QA Inspector observed Westmont Industries (WMI), production welder Larry Swanson, (WID # 3048), performing tack welding, for the fabrication of the Trolley Test Rack. The QA Inspector observed Mr. Swanson utilizing the Flux Core Arc Welding (FCAW) process and that Mr. Swanson was currently qualified to perform the FCAW tacking. The QA Inspector observed that Mr. Swanson was utilizing a Miller brand machine and wire feeder, to perform the tack welding and that Ultracore 71A85 (.045") diameter wire was being utilized.

The QA Inspector observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the FCAW tacking and Mr. Dominguez explained that the approved Welding Procedure Specification (WPS) W114, was being utilized to perform the tack welding. The QA Inspector observed that WID # 3048 had the approved WPS nearby the work area and continued tack welding throughout the shift.

The QA Inspector observed that the tack welding was being performed on the Rail Support Beam Assemblies (Reference Drawing # TTC-5) and the tack welding appeared to be in compliance with the applicable WPS.

See attached picture below.



Summary of Conversations:

On this date, the QA Inspector spoke with WMI QCM Rick Rodriguez, regarding the assignment of weld joint numbers, for identification and tracking of each weld and Non Destructive Testing (NDT), which is to be performed. Mr. Rodriguez explained that he was currently working on a system to track this and will be assigning weld joint numbers after the tack welding is complete and fit-up is QC checked and verified to be in compliance. Mr. Rodriguez explained that once the weld joint numbers are assigned, then production personnel will then be notified that the weld joint fit-up has been QC verified. Mr. Rodriguez explained that QC and Production supervision will have a meeting to address, so there is a clear understanding of this method.

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

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your project.

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