

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017688**Date Inspected:** 28-Oct-2010**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Westmont Industries**OSM Arrival Time:** 700**OSM Departure Time:** 1530**Location:** Santa Fe Springs, CA.

<b>CWI Name:</b>	R. Rodriguez, R. Dominguez	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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:

**Trolley Test Stand**

On this date, the QA Inspector observed WMI production welder, Mr. Juan Jimenez (WID # 3059), utilizing a mechanical grinder to perform grinding activities on the previously completed web to bottom flange, 8mm fillet weld on the Rail Y Assembly 2-A4. The QA Inspector observed that the grinding was being performed on the weld start/stops, transition and termination areas to smooth and blend. The QA Inspector randomly observed Mr. Jimenez perform these activities throughout the shift.

**Traveler Test Rack**

On this date, the QA Inspector observed that the pouring of the cement for two each of the Test Rack footings, appeared to be in process.

See attached picture below.

On this date, the QA Inspector observed production welder Mr. Daniel Grayum (WID # 3049) performing Flux Core Arc welding (FCAW) on the vertical post to base support columns, for the Traveler Test Rack. The QA Inspector observed that the FCAW was being performed in the vertical (3F) position and the joint appeared to be

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

designated as an 10mm fillet weld and the assembly appeared to be identified as Column A4.

See attached picture below.

On this date, the QA Inspector observed WMI production personnel Mr. Jerry Smith, continuing to utilize the flame cutting table, to cut plate material. The QA Inspector then spoke with Mr. Smith and he explained that the material currently being cut, will be utilized for the fabrication of the Traveler Test Rack. The QA Inspector observed that the cutting operations were being performed, utilizing two oxygen acetylene cutting torches and that the plate material was stationary on the cutting table. The QA Inspector observed that the two torches were mobile and cutting specific dimensional shapes in the material, which Mr. Smith had previously programmed into the computer software. Once the material was cut, the QA Inspector observed Mr. Smith utilize a paint stick marker to identify the material with the Job #, Dwg. # and piece mark, per the applicable drawing Bill of Material list. The QA Inspector 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.

### SAS-EB Traveler

#### Fixed Stairs Section

On this date, the QA Inspector observed Westmont Industries (WMI), production welder, Mr. Jose Rodriguez (WID # 3031), continuing to perform Flux Core Arc Welding (FCAW) activities on the previously fit Frame assemblies, identified as 10-A237, 11-B237, 3-A217, 4-A218, 5-A223 and 6-A224. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material. The QA Inspector observed that a WMI production helper appeared to be continuing the grinding activities on the completed fillet and flare groove welds. The QA Inspector observed that the continual grinding was being performed on areas of the welds, which appeared to be excessive reinforcement and removal of weld spatter.

#### Lower Truss Section

On this date, the QA Inspector observed Westmont Industries (WMI) production personnel Mr. Eutimo Lopez, Mr. Raymundo Anaya, Mr. Cesar Canales and a helper fitting the previously completed Frame assemblies, for the SAS-EB Lower Truss Section. The QA Inspector observed that the overhead Bay 4 was being utilized by the above mentioned personnel to lift and place the frames on the previously placed Wide Flange Beam (WFB) material, placed for the purpose of fabrication the Lower Truss Section. The QA Inspector observed that the Frame assemblies being lifted and placed appeared to be identified as A240, B240, A225 and A230, per the assembly #, which appeared to have been previously written on the Frame assemblies. Once the above mentioned assemblies were lifted and placed, the QA Inspector observed the above mentioned personnel fit and tack weld various temporary supports, including angle iron, to support the frames in an upright fashion. Once the frames were supported, the QA Inspector observed that fitting and Flux Core Arc Welding (FCAW) tacking activities were then performed on the above mentioned Frame assemblies, for this section, throughout the shift.

See attached picture below.

The QA Inspector observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and tacking activities and QC Inspector Dominguez explained that approved Welding Procedure Specifications (WPS's) were being utilized. The QA Inspector randomly observed that the applicable

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

WPS's and copies of the shop drawings, were located near each work station, where the above mentioned FCAW and fitting activities were being performed. The QA Inspector randomly verified that the consumable material, utilized during the welding was in compliance to the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. The QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.



## Summary of Conversations:

At the end of the shift, the QA Inspector was informed by WMI Director of Quality Assurance, Mr. Curtis Bell that Quality Control Manager Mr. Rick Rodriguez is no longer employed by WMI. Mr. Bell explained that production personnel Mr. Raymundo Anaya will be instructed to perform the duties of creating weld maps, for the purpose of tracking the in process and completed welds, for the project. The QA Inspector noted that Mr. Rodriguez has been performing this task, as of this date. Mr. Bell further explained that Mr. Anaya has a current AWS CWI Certificate and is best suited for this activity. The QA Inspector reminded Mr. Bell that all final visual weld inspections are to be performed by SE QC Inspector Ruben Dominguez, per the project requirements.

## 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.

---

<b>Inspected By:</b>	Vance, Sean	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson, Fred	QA Reviewer

---