

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-017883**Date Inspected:** 03-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben 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 and 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 Test Rack

On this date, the QA Inspector observed production welder Mr. Michael Ruiz (WID # 3151) continuing to perform Flux Core Arc welding (FCAW) welding activities on the vertical post to base support columns and connector plates, for the Traveler Test Rack. The QA Inspector observed that the assembly appeared to be identified as Column B4, Assembly 17-K7. Reference shop drawing WMI -TTR-7. The QA Inspector observed Mr. Ruiz performing the FCAW in various positions, throughout the shift and the weld joints appeared to be designated as fillet and flare groove welds, per the shop drawings.

On this date, the QA Inspector observed production welder Mr. Alberto Cortes (WID # 3141) continuing to perform Flux Core Arc welding (FCAW) welding activities on the vertical post to base support columns and connector plates, for the Traveler Test Rack. The QA Inspector observed that the assembly appeared to be identified as Column A4, Assembly 12-D7. Reference shop drawing WMI -TTR-7. The QA Inspector observed Mr. Cortes performing the FCAW in various positions, throughout the shift and the weld joints appeared to be designated as fillet and flare groove welds, per the shop drawings.

On this date, the QA Inspector observed production welder Mr. Jose Lucho (WID # 61) continuing to perform

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Flux Core Arc welding (FCAW) welding activities on the vertical post to base support columns and connector plates, for the Traveler Test Rack. The QA Inspector observed that the assembly appeared to be identified as Column B5, Assembly 18-M7. Reference shop drawing WMI –TTR-7. The QA Inspector observed Mr. Lucho performing the FCAW in various positions, throughout the shift and the weld joints appeared to be designated as fillet and flare groove welds, per the shop drawings.

SAS-EB Traveler

Fixed Stairs Section

On this date, the QA Inspector observed Westmont Industries (WMI) production fitter, Mr. Cesar Canales, continuing to perform fitting and dimensional layout activities. The QA Inspector observed Mr. Canales occasionally reference the shop drawings to verify dimensions of Tube Steel (TS) material. Once the dimensions were verified, the QA Inspector observed Mr. Canales then appeared to perform dimensional layout on the TS material, utilizing soapstone marker and a tri-square.

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 fillet and flare groove welds.

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Eutimo Lopez (WID # 3035), 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 fillet and flare groove welds.

Lower Truss Section

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Daniel Grayum (WID # 3049), continuing to perform Flux Core Arc Welding (FCAW) activities on the previously fit Frame assemblies, identified as 12-A240, 13-B240, 7-A225, 8-A226 and 9-A230. 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 fillet and flare groove welds.

On this date, the QA Inspector observed WMI production welder Mr. Raymundo Anaya (WID # 3196), performing fitting and tacking activities on the various connector plates to Tube Steel (TS) material, for the SAS-EB Lower Truss Section assembly. The QA Inspector observed that the plate material had been previously cut to specific dimensions and the material appeared to have been previously identified, per the shop drawing Bill of Material List. The QA Inspector observed Mr. Anaya occasionally reference the nearby shop drawings and then fit and tack weld the connector plate material to previously fit TS material. The QA Inspector observed Mr. Anaya randomly perform these activities throughout the shift in addition to what appeared to be the in-process creation of weld maps, for the purpose of identifying and tracking the in process and completed welds, for the project. The QA Inspector observed that Mr. Anaya appeared to be performing the above mentioned activities with the assistance of a WMI production helper.

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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 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:

On this date, METS QA Inspector Fred Edmonson arrived at WMI and the QA Inspector spoke with Mr. Edmonson. During conversation, Mr. Edmonson requested a copy of the bootleg Ultrasonic Testing Procedure, which had been utilized to perform the testing on the 5 mm thick, Complete Joint Penetration tube steel splices. As requested, the QA Inspector then provided Mr. Edmonson a copy of the testing procedure.

Later, the QA Inspector and Mr. Edmonson spoke with WMI Director of Quality Assurance Mr. Curtis Bell regarding the status of submittal of the above mentioned testing procedure. Mr. Bell explained that at this time, he was not sure if this has been submitted, but will check on this.

Near the end of shift, the QA Inspector then escorted Mr. Edmonson around the WMI fabrication facilities. During the escort, the QA Inspector updated Mr. Edmonson on the current fabrication status of the Travelers, Traveler Test Rack and Trolley Test Stand.

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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