

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-018797**Date Inspected:** 08-Dec-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, QC inspection and non-destructive testing of the Travelers.

Upon the arrival of the QA Inspector, the following observations were made:

Traveler Test Rack

On this date, the QA Inspector observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

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 welding was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds. Additionally, the QA Inspector observed M. Rodriguez performing grinding activities on the previously completed fillet and flare groove welds. The QA Inspector observed that the grinding being performed appeared to be on the areas which were previously marked by SE QC Inspector Ruben Dominguez. These areas appeared to be excessive weld reinforcement and weld spatter, which appeared to be non conforming to the requirements of AWS D1.1 2002 Structural welding Code-Steel. During observation, the QA Inspector observed that Production Shop Supervisor Juan Mora was present. The QA Inspector explained to Mr. Mora that per SSPC-SP 10 requirements, that all edges be broken on the Assembly.

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The QA Inspector further explained to Mr. Mora that the edges could be broken utilizing a hand held grinder, possibly with one pass with the grinder, to break the edges.

Mr. Mora explained that shop helpers will probably be performing this task today, or in the near future.

Lower Truss Section

On this date, the QA Inspector observed Westmont industries (WMI) production welder, Mr. Charles Newton (WID # 3200) continuing to perform FCAW activities on material, for the Lower Truss Section assemblies. The QA Inspector observed that the material appeared to be identified as piece marks C270G, D270G and E270G, per the shop drawings. The QA Inspector observed that the material appeared to be 3 mm x 38 mm x 38mm and 5 mm x 51 mm x 51 mm, square Tube Steel (TS) material. The QA Inspector observed that the material was being fit, tacked and FCAW activities were being performed on the material which appeared to be the fabrication of the handrails for the Elevating Platform Assembly.

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Eutimo Lopez (WID # 3035), continuing to perform 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 welding was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

See attached pictures below.

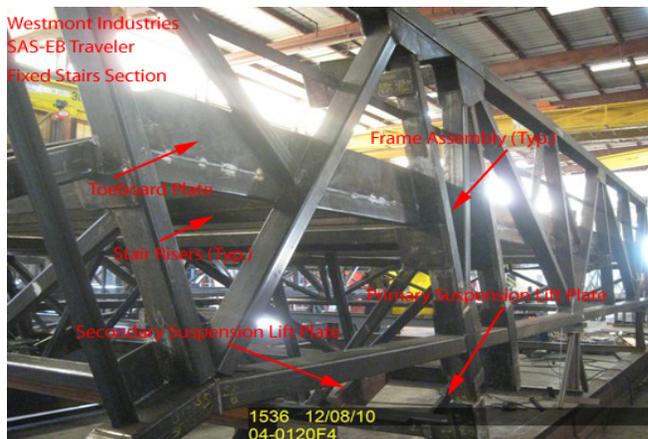
E2/E3-EB Traveler.

On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform FCAW welding activities on the Frame Assemblies identified as 9-A332 and 10-B332, per the shop drawings. The QA Inspector observed throughout the shift, that the welding was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

The QA Inspector randomly observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, the QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. The QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with 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.

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Summary of Conversations:

On this date, the QA Inspector was requested by Production Shop Supervisor Mr. Juan Mora to perform an inspection on material, which had been previously received by WMI and will be utilized for the fabrication of the Travelers.

The QA Inspector was then provided a copy of what appeared to be a single Mill Test Report (MTR). Mr. Mora then explained that the material was located in production Bay # 3 and had been placed separate from the other material, located in Bay # 3.

The QA Inspector then located the material and the material appeared to be marked with the Grade, Heat # and dimensions and appeared to be in compliance with the contract requirements.

The QA Inspector then wrote OK to Cut on the material and the material is listed as follows:

1 each-4" (102mm) x 3" (76 mm) x .188" (5 mm) x 240" (6096 mm)-A500 Gr. B Rectangular Tube Steel

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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