

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-019044**Date Inspected:** 18-Dec-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:** 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 randomly observed throughout the shift, that no activities were performed on the Fixed Stairs Section.

Lower Truss Section

On this date, the QA Inspector randomly observed throughout the shift, that no activities were performed on the Lower Truss Section.

E2/E3-EB Traveler.

On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) welding activities on the Frame Assembly identified as 9-A332, per the shop drawings. The QA Inspector observed throughout the shift, that the FCAW was being performed in various

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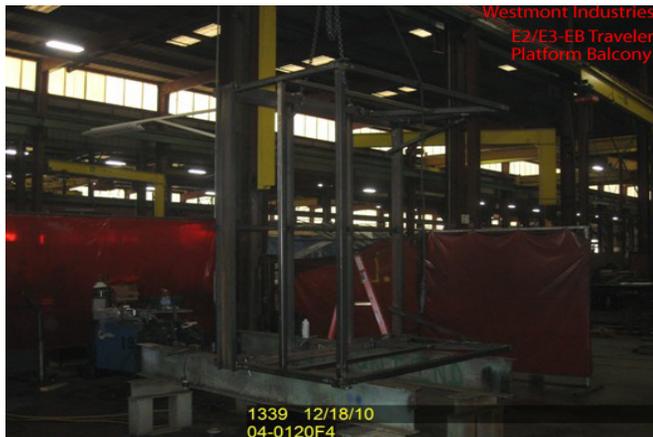
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positions on the connector plate and Tube Steel (TS) material fillet and flare groove welds. Additionally, the QA Inspector observed production fitter, Mr. Cesar Canales performing fitting activities on Tube Steel (TS) and connector plate material, for this Frame Assembly.

On this date, the QA Inspector observed Westmont industries (WMI) production welder, Mr. Charles Newton (WID # 3200) continuing to perform fitting and Flux Core Arc Welding (FCAW) activities on material, for the E2/E3-EB Traveler. The QA Inspector observed that the material appeared to be identified as Stair Risers to Stair Braces, for the Elevating Platform Assembly. The QA Inspector observed that Mr. Newton was performing the FCAW in various positions and the welds appeared to be designated as fillet and flare groove. In addition, the QA Inspector observed Mr. Raymundo Anaya (WID # 3196) performing fitting and tacking activities on tube steel (TS) material. The QA Inspector observed that the activities were being performed on the TS material, for the Platform Balcony Assembly.

See attached picture below.

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.



Summary of Conversations:

On this date, the QA Inspector was requested by WMI production shop supervisor Juan Mora to perform an inspection on Tube Steel (TS) material. Mr. Mora explained that the material had been previously received from Brown Strauss Steel and WMI will eventually cut and utilize the material for the fabrication of the E2/E3 EB Travelers. After explaining this, Mr. Mora then provided the QA Inspector with a Mill Test Report (MTR) and P. O. cut sheet. The QA Inspector then located the material and the material appeared to be identified with the size, material grade and heat # on each piece. The QA Inspector observed that the material appeared to match the MTR previously provided and appeared to be in compliance with the contract requirements. The QA Inspector then

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wrote “ OK to Cut” on each piece of material and is listed as follows:

2 each-4” x 4” x .25” x 360”-ASTM A500 Gr. B Square Tube Steel Heat # MO4665

1 each-4” x 4” x .25” x 360”-ASTM A500 Gr. B Square Tube Steel Heat # R37168

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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