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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-019045
Date Inspected: 21-Dec-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 500
OSM Departure Time: 1530
Location: Santa Fe Springs, CA.

CWI Name: Ruben Dominguez

Inspected CWI report:	☐	**Yes**	☑	**No**	☐	**N/A**
Electrode to specification:	☑	**Yes**	☐	**No**	☐	**N/A**
Qualified Welders:	☑	**Yes**	☐	**No**	☐	**N/A**
Approved Drawings:	☑	**Yes**	☐	**No**	☐	**N/A**

CWI Present:	☑	**Yes**	☐	**No**		
Rod Oven in Use:	☐	**Yes**	☐	**No**	☑	**N/A**
Weld Procedures Followed:	☑	**Yes**	☐	**No**	☐	**N/A**
Verified Joint Fit-up:	☑	**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 randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack. Additionally, the QA Inspector observed production personnel performing assembly activities, on the Trolleys and Trolley Link Plates.

SAS-EB Traveler

Fixed Stairs Section

On this date, the QA Inspector performed random Visual Testing (VT) on the previously completed fillet and flare groove welds, for the Fixed Stairs Section. The QA Inspector noted that SE QC Inspector Mr. Ruben Dominguez had previously performed VT and had accepted the welds. During testing, the QA Inspector observed that some of the welds appeared to be non-conforming to the requirements of AWS D1.1 2002, Visual Testing and the contract Special Provisions. The QA Inspector observed areas of excessive weld undercut, reinforcement and a missing 3 mm seal weld. Additionally, the QA Inspector observed that excessive weld spatter was present on random areas, nearby the weld reinforcement. The QA Inspector also observed numerous flame cut and plate edges, were present on plate material. The QA Inspector noted that per SSPC-10, that all sharp edges should be smoothed, prior to primer and or paint application. The QA Inspector then marked these above mentioned areas, utilizing a paint stick marker and then notified Shop Supervisor Juan Mora. Mr. Mora then explained to the QA Inspector that

the areas which were marked by the QA Inspector will be fixed. Additionally, the QA Inspector performed 100% Magnetic Particle Testing (MT) on the previously completed fillet welds, for the primary and secondary suspension lift plates. The QA Inspector noted that SE QC Inspector Mr. Ruben Dominguez had previously performed 100% MT and had found no rejectable indications. After testing, the QA Inspector found no rejectable indications. Later in the shift, the QA Inspector observed production welder Mr. Jose Rodriguez (WID # 3031) utilizing a mechanical grinder and performing FCAW activities, to fix the areas.

See completed TL6028 and attached pictures below, for additional details.

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

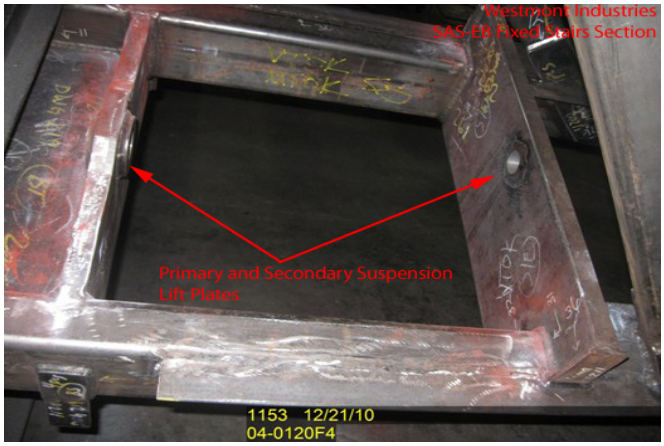
E2/E3-EB Traveler.
On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) welding activities on the Frame Assembly identified as 9-A332, per the shop drawings.
The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

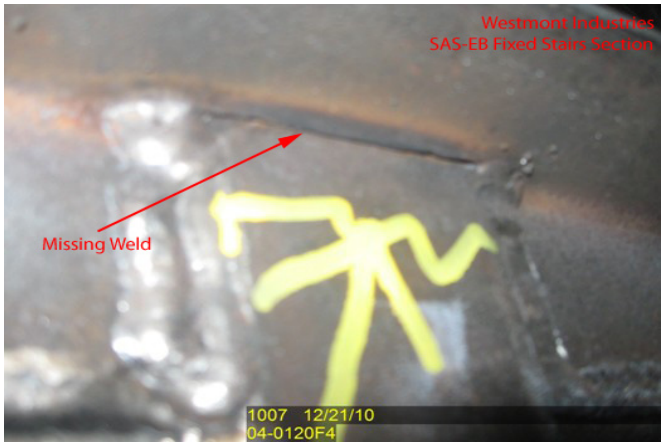
On this date, the QA Inspector observed WMI production welder Mr. Jose Rodriguez (WID # 3031) performing Flux Core Arc Welding (FCAW) welding activities on the Frame Assembly identified as 8-B327, per the shop drawings. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds. Additionally, the QA Inspector observed production fitter, Mr. Cesar Canales performing fitting activities on Tube Steel (TS) and connector plate material, for these Frame Assemblies.

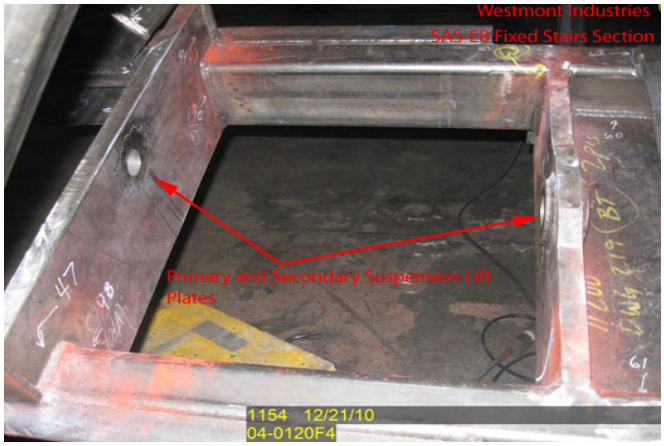
On this date, the QA Inspector observed Westmont industries (WMI) production welder, Mr. Charles Newton (WID # 3200) continuing to perform fitting and Flux Core Arc Welding (FCAW) activities on material, for the E2/E3-EB Traveler. The QA Inspector observed that the material appeared to be identified 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. Additionally, 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.

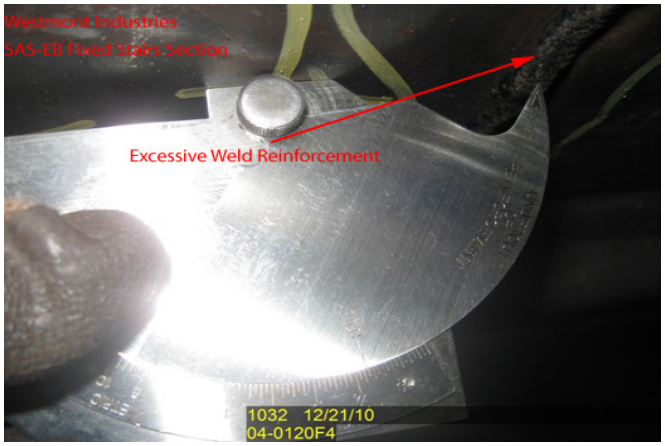
The QA Inspector randomly observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, the QA Inspector observed that the applicable WPS's and copies of the shop drawings,appeared to be located near each work 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:

As noted above.

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
Reviewed By:	Edmondson,Fred	QA Reviewer