

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-019050**Date Inspected:** 23-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**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 randomly 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 WMI production welder Mr. Jose Rodriguez (WID # 3031) performing grinding and Flux Core Arc Welding (FCAW) activities, on the Fixed Stairs section. The QA Inspector observed Mr. Rodriguez performing these activities on the previously marked areas of the fillet and flare groove welds. The QA Inspector had previously marked these areas which appeared to be non conforming to the requirements of AWS D1.1 2002, Visual Testing criteria. These areas appeared to be weld undercut, excessive weld reinforcement, weld spatter and a missing weld. The QA Inspector observed Mr. Rodriguez performing these activities, near the end of the scheduled shift.

Lower Truss Section

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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. Eutimo Lopez (WID # 3035) continuing to perform 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.

See attached picture below.

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, stair braces and hand rail material, 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.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

On this date, the QA Inspector was informed by SE QC Inspector Mr. Ruben Dominguez that due to the joint configuration on plate "a" and plate "b" to Link "B" T-Plate-C714 that the 8 mm fillet will be welded as an 6 mm Partial Joint Penetration (PJP) and the 6 mm PJP will be welded as an 8 mm fillet. The QA Inspector noted that per AWS D1.1 Sect. 2.3.3.3 and Fig. 3.11, that these appear to be prequalified skewed T-Joints and the above mentioned weld reinforcement appears to be in compliance with these 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.

Inspected By:	Vance,Sean	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
