

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-019233**Date Inspected:** 05-Jan-2011**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 randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

E2/E3-EB Traveler

On this date, the QA Inspector observed SE QC Inspector Mr. Ruben Dominguez performing Ultrasonic Testing (UT) on the previously completed Complete Joint Penetration (CJP) weld joints. The QA Inspector observed that these CJP weld joints appeared to be designated as the cover plates for the Primary Suspension Arm Assemblies, Frame Assembly 8-B327. Initially, the QA Inspector observed Mr. Dominguez utilizing what appeared to be a .500" (12 mm) diameter, 2.25 MHz transducer, to perform a straight or longitudinal beam lamination scan, on the base metal areas in which the subsequent angle beam inspection will be performed. After performing the lamination scan, Mr. Dominguez then explained to the QA Inspector that no rejectable indications were found. The QA Inspector then observed Mr. Dominguez utilizing what appeared to be a 70 degree Lucite wedge coupled to a .500" (12 mm) diameter, 2.25 MHz transducer, to perform a shear wave inspection, on the above mentioned weld joints. During observation, the QA Inspector noted that the scanning pattern being performed by Mr. Dominguez appeared to be in compliance with AWS D1.1 2002, Figure 6.24 and that the testing appeared to be 100% coverage. Also, the QA Inspector observed that the testing appeared to be in compliance with AWS D1.1

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and the applicable procedure SE-UT-CT-D1.1-104 Rev. 5. After testing, Mr. Dominguez explained to the QA Inspector that no rejectable indications were found and an applicable form SE-UT-D1.1-CT-104, will be completed to document the acceptable testing results. Additionally, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) welding activities on the above mentioned Frame Assembly in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds, for this 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
