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-019372
Date Inspected: 06-Jan-2011

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

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Santa Fe Springs, CA.

CWI Name: Ruben Dominguez

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ 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.

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 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 WMI production welder Mr. Cesar Canales (WID # 3195) performing fitting activities on the connector plate and TS material, for the above mentioned 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, identified as 95 A364C. The QA Inspector observed that Mr. Newton

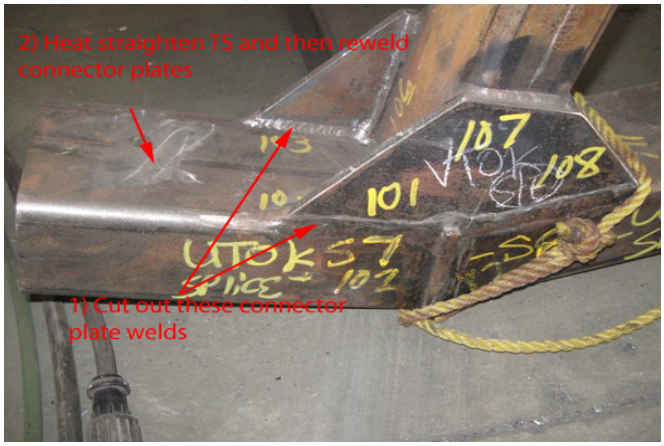
was performing the FCAW in various positions and the welds appeared to be designated as fillet and flare groove. In addition, the QA Inspector observed Mr. Cesar Canales (WID # 3195) performing fitting and FCAW tacking activities on the above mentioned assembly.

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:

On this date, the QA Inspector was informed by WMI Production Shop Supervisor, Mr. Juan Mora, that 4 each previously completed fillet and flare groove welds need to be cut out, due to excessive shrinkage caused during the Flux Core Arc Welding (FCAW) process. Mr. Mora further explained that the location of the welds were on the connector plate to Tube Steel (TS) material, on the Frame Assembly identified as 10-A237, SAS-EB Fixed Stairs section. Mr. Mora then explained these activities need to be performed, to achieve proper fit-up of the Fixed Stairs to Elevating Platform sections. Mr. Mora additionally explained that once these welds are cut, that the TS material will then require heat application, to straighten the TS material, approximately 2 degrees. Mr. Mora further explained that once the material is straightened, that the previously cut welds, will then be re-welded, utilizing the FCAW process. The QA Inspector then informed Mr. Mora that per AWS D1.1 that prior to cutting welded members, the engineer shall be notified. Mr. Mora then explained that WMI QC Manager, Mr. Jim Bowers has been notified and WMI has been given a verbal OK to proceed with the above mentioned activities. The QA Inspector noted that at this time, WMI does have a heat straightening procedure. Near the end of the shift, the QA Inspector observed that the above mentioned welds had been cut and at this time, no heat straightening has been performed on the TS material.

See attached picture below.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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