

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-019374**Date Inspected:** 08-Jan-2011**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 randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

SAS-EB Traveler

On this date, the QA Inspector observed 2 WMI Production personnel perform fitting activities on the previously completed sections of the SAS-EB Traveler. The QA Inspector observed that the sections had been previously relocated to the outside fabrication Bay # 6 and the sections appeared to be identified as Elevated Truss, Fixed Stairs and Lower Truss. During observation, the QA Inspector observed that the overhead shop bay crane, chains and hooks were intermittently utilized to pick up the three sections and strategically placed in a fashion which appeared to be the correct placement in which the sections will be fit-up and welded. Near the end of the shift, the QA Inspector observed that the above mentioned three sections had been placed on previously fabricated stands and the fit-up appeared to still be in process, at this time.

See attached picture below.

E2/E3-EB Traveler

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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 7-A327, 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. Cesar Canales (WID # 3195) performing fitting and Flux Core Arc Welding (FCAW) tacking activities on the Frame Assembly identified as 8-B327, per the shop drawings. The QA Inspector observed that the material appeared to be identified as diagonal and intermediate Tube Steel (TS) material. Additionally, the QA Inspector observed Mr. Canales performing fitting activities on the previously completed Frame Assemblies identified as 9-A332 and 10-B332. During observation the QA Inspector observed Mr. Canales utilize the overhead shop bay crane, chain and hook to lift the above mentioned assemblies. Once lifted, the QA Inspector observed Mr. Canales then place the assemblies on previously fabricated stands, in an upright fashion. The QA Inspector then observed Mr. Canales and a helper utilize various lengths of angle material, to temporarily stabilize the upright assemblies. The QA Inspector noted that this appears to be designated as the South Side section, per the Shop Drawings.

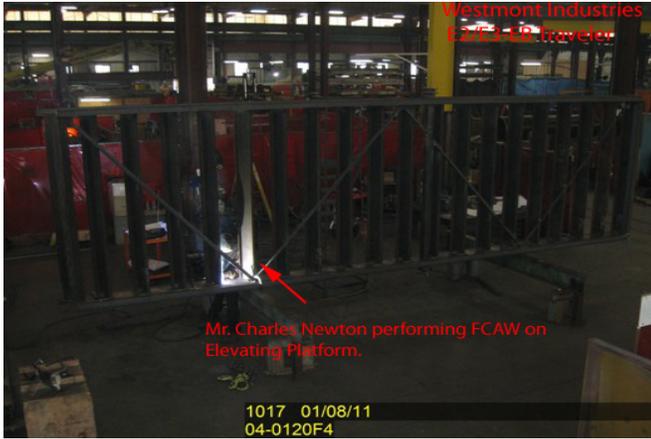
See attached picture below.

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 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. 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
