

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-019902**Date Inspected:** 22-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 continuing to 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 the Elevated Truss, Fixed Stairs and Lower Truss Sections. During observation, the QA Inspector observed that various come alongs and chain falls were being utilized, during the fit-up process.

Near the end of the shift, the QA Inspector observed that the fit-up on the above mentioned three sections, appeared to still be in process, at this time.

E2/E3-EB Traveler

On this date, the QA Inspector observed WMI production welder Mr. Jose Rodriguez (WID # 3031) performing Flux Core Arc Welding (FCAW) in various positions on Tube Steel (TS) and connector plate material. The QA Inspector observed that the FCAW was being performed on the frame assemblies identified as A316, A324, A325

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

A332 and B332, South Side section of the E2/E3-EB Traveler.

Additionally, the QA Inspector observed WMI production welder Mr. Jesus Rayes (WID # 3197) performing fitting and FCAW tacking activities on the above mentioned assemblies.

On this date, the QA Inspector observed WMI production welder Mr. Cesar Canales (WID # 3195) performing Flux Core Arc Welding (FCAW) tacking and fitting activities on Tube Steel (TS) and connector plate material. The QA Inspector observed that the activities were being performed on the frame assemblies identified as A323, A316, A317, A314, A312, A327 AND B327, North Side section of the E2/E3-EB Traveler.

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:

The QA Inspector randomly spoke with WMI Certified Welding Inspector (CWI) Raymundo Anaya, throughout the shift, regarding random issues with the weekly weld report submittals.

The QA Inspector noted that Mr. Anaya had been previously designated to collect these on a daily basis to report the production and Quality Control (QC) activities being performed on the project.

During random conversation, the QA Inspector informed Mr. Anaya that many of the previously submitted and Returned for Correction weekly weld reports appeared not to match the production and Quality Control (QC) activities, which had been previously performed.

Throughout the shift, the QA Inspector and Mr. Anaya discussed various options to eliminate this problem in future submittals and correct the previous one's.

At this time, Mr. Anaya appeared to understand some of the problems associated with the weekly weld report submittals.

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
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Reviewed By:	Edmondson,Fred	QA Reviewer
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