

**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-021124**Date Inspected:** 16-Feb-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:**

This 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**

This 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-South**

This QA Inspector performed random visual testing on the previously completed welds on the E2/E3 Traveler, South Side section. This QA Inspector noted that the welds had been previously visually tested by Smith Emery QC Inspector Mr. Ruben Dominguez and the areas which had been marked by Mr. Dominguez, had been previously fixed or repaired by WMI production personnel. During random visual testing, this QA Inspector marked areas on the completed welds which included excessive reinforcement and weld spatter, which appeared to be non-conforming to the requirements of AWS D1.1 2002, visual acceptance criteria. This QA Inspector noted that the areas which were marked by this QA Inspector appeared to be minimal areas which will need minor repair.

After testing, this QA Inspector notified shop supervisor Mr. Juan Mora and Mr. Mora explained that the areas which were marked, will be fixed. Later, this QA Inspector was informed by Mr. Mora that grinding activities had been performed on the areas and this QA Inspector then confirmed that the areas were fixed. This QA Inspector noted that the above mentioned welds, appeared to be in compliance with the requirements of AWS D1.1 visual testing criteria and the contract requirements.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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### E2/E3-EB Traveler-North

This QA Inspector observed WMI production welder Mr. Cesar Canales (WID # 3195) continuing to perform Flux Core Arc Welding (FCAW) tacking and fitting activities on Tube Steel (TS) and connector plate material. This 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. Additionally, this QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) activities on the above mentioned assemblies. This QA Inspector observed Mr. Jimenez performing the FCAW in all positions, throughout the shift. Additionally, this QA Inspector observed WMI production welder Mr. Eutimo Lopez (WID # 3035) performing Flux Core Arc Welding (FCAW) activities on the above mentioned assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions, throughout the shift.

### SAS-WB Traveler

This QA Inspector observed WMI production welder Mr. Larry Swanson (WID # 3058) performing Flux Core Arc Welding (FCAW) tacking and fitting activities on the Frame Assembly identified as 12 A141. This QA Inspector observed Mr. Swanson performing the tacking and fitting activities on previously cut to length Tube Steel (TS) material throughout the shift. Additionally, this QA Inspector observed WMI production welder Mr. Eutimo Lopez (WID # 3035) performing Flux Core Arc Welding (FCAW) activities on the above mentioned assembly. This QA Inspector observed Mr. Lopez performing the FCAW in all positions, throughout the shift.

This QA Inspector observed WMI production welder Mr. Charles Newton (WID # 3200) performing Flux Core Arc Welding (FCAW) activities on the frame assembly identified as 13 B141. This QA Inspector observed Mr. Newton performing the FCAW in all positions, throughout the shift.

This QA Inspector randomly observed that Smith Emery QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this 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. This 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. This 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.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

This QA Inspector continued to perform courtesy preliminary reviews of WMI Weekly Weld Reports, prior to WMI formally submitting to Caltrans for review.

### **Summary of Conversations:**

As noted above.

### **Comments**

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# WELDING INSPECTION REPORT

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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.

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<b>Inspected By:</b>	Vance,Sean	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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