

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-021502**Date Inspected:** 18-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 observed WMI production personnel Mr. Cesar Canales continuing to fabricate and set up what appeared to be stands for the E2/E3-EB South side section. This QA Inspector observed that the stands appeared to be strategically placed nearby the E2/E3-EB North side section. This QA Inspector noted that the stands were being placed for the future fit up of the E2/E3-EB North and South side sections. During the shift, this QA Inspector observed that the above mentioned assembly had been placed on the stands and WMI personnel appeared to be in process of fitting this assembly to the E2/E3-EB North side section.

See attached picture below.

E2/E3-EB Traveler-North

This QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-EB North side section. This QA Inspector observed Mr.

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Jimenez performing the FCAW in all positions on plate and tube steel material, throughout the shift.

SAS-EB Traveler

This QA Inspector observed WMI production welder Mr. Charles Newton (WID # 3200) continuing to perform Flux Core Arc Welding (FCAW) activities, on the SAS-EB Fixed Stairs and Lower Truss assemblies. This QA Inspector noted that the FCAW was being performed on the tube steel connection weld joints for the mentioned assemblies. This QA Inspector noted that the sections had been previously cut out and the FCAW was being performed on the newly fabricated section (RFI-002361R00). This QA Inspector observed Mr. Newton 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 assembly. This QA Inspector observed Mr. Lopez 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.

See attached picture below.

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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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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| Inspected By: | Vance,Sean | Quality Assurance Inspector |
| Reviewed By: | Edmondson,Fred | QA Reviewer |
