

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-022376**Date Inspected:** 15-Mar-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

This QA Inspector observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-EB Traveler assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on plate and tube steel material, randomly throughout the shift.

SAS-WB Traveler

This QA Inspector observed WMI production welder Mr. Jose Rodriguez (WID # 3031) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler frame assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW in all positions on tube steel and plate material, randomly 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

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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.

Summary of Conversations:

This QA Inspector met with METS representative Mr. Fintan Shanley and had general conversation regarding the painting activities on the Traveler and Traveler assemblies.

This QA Inspector and Mr. Shanley noted that Westmont Industries (WMI) had previously chosen RPI Coating Inc. to perform the painting activities and had previously submitted a Paint Quality Control Plan (PQCP) to Caltrans for review. This QA Inspector and Mr. Shanley noted that the PQCP had been previously "Approved as Noted". During conversation, this QA Inspector and Mr. Shanley discussed the painting requirements, per the contract Special Provisions which included sandblast, primer and top coat requirements. This QA Inspector and Mr. Shanley noted that the contract painting requirements for the Travelers, reference Special Provisions section 10-1.69, "Clean and Paint Structural Steel".

During conversation, this QA Inspector and Mr. Shanley noted that per the Special Provisions, the in-process testing is required to be performed by RPI Coating Quality Control (QC) personnel after sandblast, primer and top coat application. This QA Inspector and Mr. Shanley noted that the testing includes anchor profile and chloride testing after blast, (near white). Additionally, this QA Inspector and Mr. Shanley noted that the testing includes dry film thickness, adhesion, hardness and chloride testing after primer application. Also, additional testing is required after top coat application, which includes dry film thickness testing. This QA Inspector and Mr. Shanley also noted that 100% Visual testing (VT) is required after blast, primer and top coat applications to insure compliance with SSPC-10.

After conversation, this QA Inspector and Mr. Shanley then met with Westmont Industries (WMI) representative Mr. Brad Petrie and RPI Coating representatives, Mr. Carlos Torres and Mr. Gary McDonald. During conversation, WMI and RPI representatives appeared to understand the contract requirements, for painting of the Travelers and Traveler assemblies. Mr. Torres explained that RPI will continue to set up equipment for blast and painting purposes and blast will probably start tomorrow. Near the end of the shift, this QA Inspector observed that WMI personnel had placed what appeared to be Traveler assemblies, on stands in a previously tarp inclosed area, as shown in attached picture.

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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
