

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-022403**Date Inspected:** 17-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, non-destructive testing and painting 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.

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

This QA Inspector observed WMI production welder Mr. Juan Jimenez (WID #3059) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler frame assemblies. This QA Inspector observed Mr. Jimenez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

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.

Paint: SAS and E2/E3-EB Travelers

This QA Inspector observed that blasting activities were being performed on the SAS and E2/E3-EB Travelers. RPI Coating informed this QA Inspector that the blast will not be completed, on this date.

See attached picture below.

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.

Paint

This QA Inspector was requested by Westmont Industries (WMI) representative Mr. Brad Petrie to witness RPI Coating Inc. prepare a paint sample to be sent to Caltrans lab for testing. This QA Inspector was informed by Mr. Petrie that RPI Coating representative Mr. Carlos Torres had just arrived at WMI. This QA Inspector noted that RPI Coating had previously staged a medium sized shipping type container on WMI property and the primer, with other miscellaneous primer components, had been previously stored in this container. Upon meeting with Mr. Torres, this QA Inspector explained to Mr. Torres that 1 each quart size is needed for testing on each component of the primer, which will be utilized for mixing purposes. Mr. Torres explained to this QA Inspector that 3 components are required for the mix which includes Zinc Clad II Plus Coating, Zinc Clad Dust Ultrapure and Zinc Clad II Accelerator. This QA Inspector observed that the Zinc Clad II Plus Coating appeared to be unopened and in the original manufacturers container and per the original label, appeared to contain a volume of 2.21 Gallons. This QA Inspector observed that the Zinc Clad Dust Ultrapure appeared to be unopened and in the original manufacturers container and per the original label, appeared to weigh 73 lbs. This QA Inspector observed that the Zinc Clad II Accelerator appeared to be unopened and in the original manufacturers container and per the original label, appeared to contain volume of 25.6 fl oz. This QA Inspector noted that all of the above mentioned components appeared to have the same batch numbers as the rest of the containers and the manufacturer appeared to be Sherwin Williams. This QA Inspector then explained to Mr. Torres that 1 each unopened container of the accelerator with the Zinc Clad Dust/Coating transferred to 1 each separate quart size containers, can be sent to Translab for testing. This QA Inspector further explained to Mr. Torres that once the dust/coating is transferred, that the separate quart size containers can then be labeled with all of the manufacturers information, batch number, etc. After explaining this, Mr. Torres informed this QA Inspector that it would probably be more convenient to send 1 each of the above mentioned components to Translab in the original unopened containers rather than transferring and labeling quart size containers. Mr. Torres further explained that when RPI mixes the primer, it is

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

usually mixed as a full kit containing the above mentioned quantities for each kit. Mr. Torres further explained that if one of the containers with the dust/coating components was opened and material was removed for sampling purposes, that RPI Coating would have an incomplete kit.

After conversation with Mr. Torres, this QA Inspector then completed an applicable TL-0101 Sample Identification Card (C658778) and assigned the samples with a QA Lot # B251-002-11. This QA Inspector then placed the TL-0101 with the manufacturers information and Material Safety Data (MSDA) sheets, which had been provided to this QA Inspector, in an envelope. This QA Inspector then placed one green tag on each of the containers. This QA Inspector was later informed by Mr. Petrie that the samples will be sent to Translab for testing, tomorrow morning.

This QA Inspector then informed METS Representative Mr. Joe Lanz that Translab will be shortly receiving the samples, which appear to include a 2.21 gallon and 73 lb bucket of material. Mr. Lanz explained that Translab will be notified of this shipment.

See attached picture below.



Summary of Conversations:

As noted above.



Comments

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
