

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-022404**Date Inspected:** 18-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 3 )

---

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 was informed by RPI Coating representative Mr. Carlos Torres that the sandblasting activities were complete on the SAS and E2/E3-EB Traveler assemblies. This QA Inspector noted that the assemblies appeared to be identified as A504-1, A504-2, A364A, A364C and A270A, per the shop drawings. This QA Inspector noted that the assemblies appeared to be identified as elevating and platform balconies, per the shop drawings.

This QA Inspector then performed random visual testing on the above mentioned assemblies. During testing, this QA Inspector utilized white chalk to mark up minor areas of base metal mill scale which appeared to have been missed during sandblasting. This QA Inspector marked up minor areas of the base metal at or nearby completed welds, which appeared to be weld spatter deposited during the previous welding activities. Additionally, this QA Inspector marked up minor areas of sharp edges, which appeared to have not been broken. After marking up the areas, this QA Inspector informed RPI Representative Mr. Carlos Torres of the areas marked and Mr. Torres explained that once the weld spatter was removed and the edges broken, that a sweep blast will be performed on all of the marked areas. This QA Inspector then informed shop superintendent Mr. George Grayum of the minor weld spatter and edges. Mr. Grayum explained that a shop helper will be instructed to fix the areas. Later, this QA Inspector was informed by Mr. Torres that the sweep blast was complete. This QA Inspector then performed visual testing on the areas which were marked and the testing appeared to be in compliance with SSPC-10. This QA Inspector then observed RPI Coating Quality Control Representative Mr. Andrew Gonzales performing what appeared to be random surface profile checks on the blasted base metal surfaces. This QA Inspector observed Mr. Gonzales utilizing what appeared to be Testex Press-O-Film and a micrometer to perform the testing. Initially, this QA Inspector observed Mr. Gonzales applying the film to the blasted surface then utilize one end of a pen to perform rubbing activities on the clear portion of the test strip. This QA Inspector then observed Mr. Gonzales utilize a micrometer to measure the surface profile on the clear film part of the strip in which the rubbing was performed. Mr. Gonzales explained to this QA Inspector that the initial setting on the micrometer was set at 2mils over, due to the thickness of the Press-O-Film paper. During observation, this QA Inspector observed that the readings appeared to be 2.9mils, 2.9mils, 3.0mils, 3.0mils and 3.0mils. This QA Inspector observed that all of the random readings appeared to be within a range of 2.8mils - 3.1mils. This QA Inspector noted that the contract requires a surface profile of 1.57mils (40um) - 3.15mils (80um) and the above mentioned tested profile, appears to be in compliance with the contract requirements. After surface profile testing, this QA Inspector then observed Mr. Torres perform a test for soluble salts on the previously blasted base metal areas. This QA Inspector observed the testing being performed at random areas which appeared to meet or exceed one test per 200 square meters, per the contract requirements. After testing, this QA Inspector observed that the soluble salt content appeared to be 0

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

Parts Per Million (PPM). This QA Inspector was then informed by Mr. Torres that primer application will soon start. Later, this QA Inspector observed RPI Coating performing what appeared to be primer application activities, within what appeared to be an 8 hr. time frame from the above mentioned sweep blasting activities.

See attached pictures 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.



## Summary of Conversations:

As noted above.

## 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.

---

<b>Inspected By:</b>	Vance,Sean	Quality Assurance Inspector
----------------------	------------	-----------------------------

---

<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer
---------------------	----------------	-------------