

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-023097**Date Inspected:** 21-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**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 L & R**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item # 99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike path).

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/SKYWAY – Traveler Trolley Train

This QA Inspector observed WMI production welder Mr. Jose Rodriguez (WID # 3031) continuing to perform Flux Core Arc Welding (FCAW) activities on the Link Plates, B and BX assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW in all positions randomly throughout the shift.

SAS-WB Traveler – Fixed Stairs Frame Assembly

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler – Fixed Stairs Frame Assembly. This QA Inspector observed Mr. Grayum performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Charles Newton (WID # 3200) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler – Fixed Stairs Frame Assembly. This QA

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Inspector observed Mr. Newton performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

SAS-WB Traveler – Lower Truss Frame Assembly

This QA Inspector observed WMI production welder Mr. Jim Muetzel (WID # 3133) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Lower Truss frame assemblies. This QA Inspector observed Mr. Muetzel performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector observed WMI production personnel Mr. Cesar Canales and Mr. Raymundo Anaya performing layout and fitting activities for the SAS-WB Traveler Lower Truss frame assemblies.

This QA Inspector randomly observed that Smith Emery, CWI, 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.



Summary of Conversations:

As noted within this report.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

Reviewed By:	Lanz, Joe	QA Reviewer
---------------------	-----------	-------------