

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-023426**Date Inspected:** 29-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 observed no WMI production personnel performing fitting, welding or cutting activities on assemblies for the Traveler Test Rack.

Traveler's Trolley Train Assembly

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

This QA Inspector randomly observed WMI production welder Mr. Juan Lopez (WID # 3126) continuing to perform Flux Core Arc Welding (FCAW) activities on the trolley train assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in 2F horizontal position 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 trolley train assemblies. This QA Inspector observed Mr. Newton performing the FCAW in 2F horizontal position randomly throughout the shift.

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This QA Inspector observed WMI production welder Mr. Arturo Montes (WID # 3151) continuing to perform Flux Core Arc Welding (FCAW) activities on the trolley train assemblies. This QA Inspector observed Mr. Montes performing the FCAW in 2F horizontal position randomly throughout the shift.

SAS-WB Traveler – Lower Truss Frame Assembly

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

This QA Inspector observed WMI production personnel Mr. Cesar Canales and Mr. Raymundo Anaya performing layout and fitting activities at various locations for the SAS-WB Traveler 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.

Paint: E2/E3-EB Travelers

QA Inspector was informed by RPI Coating QC Representative Mr. Andrew Gonzales that RPI did not complete the prime coat application on Thursday 4-28-11 as predicted. Mr. Gonzales stated that RPI will be sweep blasting the remainder areas of the E2/E3-EB Traveler. Mr. Gonzales also, stated that as soon as RPI completed the sweep blast that RPI will continue and complete prime coating on the E2/E3-EB Traveler today. QA Inspector randomly observed RPI during the sweep blast and prime coat applications. QA noted that the prime coat for the E2/E3-EB Traveler was completed on this date.

E2/E3 BIKE PATH TRAVELER

This QA Inspector randomly observed WMI personnel cutting material to be used in the Bike Path Traveler.

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.

QA NDT

QA Inspector performed Ultrasonic Testing on the Traveler Suspension Arm Assembly - E2/E3-EB/WB Skyway,

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Assembly 2, 7, 10, 11, 12 and 13. See Caltrans Ultrasonic Test Report TL-6027 dated April 29, 2011 for more detailed information.



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.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer
