

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-024319**Date Inspected:** 06-Jun-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).

SAS-WB Traveler – Lower Truss Frame Assembly

Welding Completed on the SAS-WB Traveler – Lower Truss Frame Assembly on Thursday 5-12-11. Quality Control Mr. Dominguez informed QA Inspector that Smith Emery did complete visual inspection and waiting on WMI to weld and grind on some area's found by visual inspection this date.

E2/E3 Bike Path Traveler

This QA Inspector randomly observed WMI production personnel Mr. Larry Swanson ID#3058, performing layout, fitting and tack welding activities at various locations for the E2/E3 Bike Path Traveler Assemblies. This QA Inspector observed Mr. Swanson performing the FCAW in all positions randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Mike Ruiz (WID # 3155) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3 Bike Path Traveler Assemblies. This QA Inspector observed Mr. Ruiz performing the FCAW in all positions randomly throughout the shift.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

the am shift.

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions randomly throughout the shift.

Traveler Test Rack

This QA Inspector observed randomly observed WMI production personnel performing fitting activities on assemblies for the Traveler Test Rack.

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.

RPI Coating (Blast and Prime Coat)

This QA Inspector made random observations of the paint shop area in Bay 6 and observed no sandblasting or painting activities on this date.

Summary of Conversations:

(1) WMI Mrs. Ida Goldenberg informed QA Inspector that on the E2/E3 WB Traveler Assembly Frame 9 & 10 that the tubing that WMI ordered was approximately 3 inches to short and that WMI would like to add a one foot splice to the frame assemblies. QA Inspector informed QA Lead Inspector Mr. Joe Lanz of the above information. Mr. Lanz informed QA Inspector that WMI could add the one foot splice as long as the drawing were updated and submitted for approval and that WMI will be proceeding with welding at their own risk. QA Inspector Brannon relayed this information to Mrs. Goldenberg. Mrs. Goldenberg stated that she will be updating drawing WMI-E2/E3-432 to revision (D) and WMI-E2/E30434 to revision (C) and will submit to Caltrans for approval. (2) QA Inspector was informed by WMI Shop Superintendent Mr. George Grayum that the 96 trolley link assemblies will be sent to Alameda Paint, in Fontana, CA for blasting to remove the prime coat.

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
---------------------	-----------	-------------