

**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-026146**Date Inspected:** 11-Aug-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).

**E2/E3 Bike Path Traveler**

This QA Inspector made random shop observations and observed no fit-up performed on the E2/E3 Bike Path Traveler Assemblies on this date.

**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. Grinding not completed on this date.

**E2/E3-WB Traveler (South)**

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes WID #3201 and one helper, performing layout, fitting and tack welding activities at various locations for the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Fuentes performing the FCAW in all positions randomly throughout the shift.

**SAS-WB Traveler - Fixed Stair Section**

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform

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Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions 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 Assemblies. This QA Inspector observed Mr. Newton performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production personnel Mr. Jose Rodriguez (WID # 3031) performing layout, fitting and tack welding activities at various locations for the SAS-WB Traveler Assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW in all positions randomly through the shift.

### E2/E3-WB Traveler (North)

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and helper Mr. Jesus Rayas WID#3197, performing layout, fitting and tack welding activities at various locations for the E2/E3 WB Traveler Assemblies. This QA Inspector observed Mr. Canales 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 the shift.

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 Mr. 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 Paint)

This QA Inspector performed random shop observations and observed that RPI is on site to continue with painting activities. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Miguel Nunez that RPI will be applying a mist coat using the Sherman Williams Polysiloxane XLE-80 Epoxy Siloxane to approximately forty five (45) of the Trolley Links today. QA Inspector randomly observed RPI Coating in the process of applying a mist coat to the forty five trolley links. Trolley links were mist coated on one side and later in the shift flipped over and mist coated on the other side and in the afternoon RPI applied final top coat on side only. Environmental readings taken by RPI at the time of the mist application are as follows: Air Temperature 71 F/71 F, Relative Humidity 55%/61%, Wet Bulb Temperature 61 F/62 F, Dew point 54 F/56 F and Surface

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Temperature 67 F/69 F. QA also observed RPI personnel sanding prime coated links using 100grit sandpaper and pressure washing links use 6000 psi pressure washer.

Mr. Nunez informed QA Inspector Brannon that on the interim coating inspection of the Sherman Williams Zinc Clad II, Inorganic Zinc Rich prime coating he would be performing adhesion testing on the Trolley Links that had been prime coated on 7-14-11, 7-18-11, and 7-19-11, using an calibrated Elcometer Hydraulic Adhesion Tester Model 108 which is in conformance with ASTM D4541 – Standard Test Method for Pull-Off Strength of Coating Using Portable Adhesion Tester. Mr. Nunez stated that he had glued one (1) dolly for retest on the links coated on 7-14-11 and 2 dollies on prime coated surface for 7-18-11 and 7-19-11 this morning using super glue quick set epoxy. QA Inspector Brannon observed Mr. Nunez performing the above mentioned tests. Adhesion test for primed coated links retest on 7-14-11 – retest - 700psi/4.8MPa, links primed coated on 7-18-11 – first test 700psi/4.8MPa, second test 900psi/6.2Mpa, and links primed coated on 7-19-11 – first 800psi/5.5Mpa and second test 650psi/4.5Mpa. Testing observed by QA Inspector appeared to comply with contract documents.

Later in the morning this QA Inspector randomly observed that RPI personnel performing sweep abrasive blasting activities on the seven (7) trolley link assemblies to apply the International Interzinc 22HS prime coat application. Onsite to observed the International Interzinc 22HS prime coat application, International Paint Representative Mr. Marc Dyer, RPI Coating Representatives Mr. Carlos Torres, Mr. Miguel Nunez, and Mr. Gary McDonald. Mr. Torres informed QA Inspector that RPI is going to add 10% of the International GTA 138 thinner prime coating to the mixture and apply to 2 of the 7 test pieces. Mr. Torres informed QA Inspector that RPI will perform adhesion test and pressure wash the seven (7) link plates on Monday 8-15-11 and apply the mist and final coat using the International Interfine 979 on Tuesday 8-16-11. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.



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## Summary of Conversations:

As stated 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.

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<b>Inspected By:</b>	Brannon, Sherri	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz, Joe	QA Reviewer

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