

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-026220**Date Inspected:** 25-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 This QA 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 randomly 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. This QA Inspector observed Mr. Ruiz performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

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.

SAS-WB Traveler - Fixed Stair Section

This QA Inspector made random shop observations and observed no fit-up performed on the SAS-WB Traveler - Fixed Stair Section on this date.

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E2/E3-WB Traveler (South) & (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 WMI production personnel Mr. Jose Rodriguez (WID # 3031) performing layout, fitting and tack welding activities at various locations for the E2/E3 WB Traveler Assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW all positions on tube steel and plate material, randomly throughout the shift.

Motorized Trolley Lubricator Bracket – Assembly

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform Flux Core Arc Welding (FCAW) activities on the Motorized Trolley Lubricator Bracket Assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions randomly throughout morning shift.

SAS EB Traveler

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes WID #3201, performing layout, fitting and tack welding activities at various locations for the SAS EB Traveler (frame) for control panels. This QA Inspector observed Mr. Fuentes performing the FCAW in all positions 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.

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 and final coating using the Sherman Williams Polysiloxane XLE-80 Epoxy Siloxane to trolley links and suspension arms today. QA Inspector randomly observed RPI Coating in the process of applying mist and final coat throughout the day on the above mentioned assemblies. Environmental readings taken by RPI at the time of the mist and final coating applications are as follows: Air Temperature 70 F/74 F,

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Relative Humidity 60%/53%, Wet Bulb Temperature 61 F/63 F, Dew point 56 F/56 F and Surface Temperature 70 F/76 F.

This QA Inspector performed measurement on dry film thickness (DFT) with Type 2 (magnetic gage), DFT's thickness reading of the top coat on trolley link assemblies top coated using the Sherman Williams Polysiloxane XLE-80 Epoxy Siloxane on 08-24-11 are an average of three (3) thickness reading are as follows 11.3 mils, 11.2 mils, 12.1 mils, 9.7 mils, 10.1 mils, 11.6 mils, and 9.2 mils. QA Inspector was informed by Mr. Nunez that RPI will be touching up areas that have dry film thickness reading lower than 8.5 mils using a paint roller. Note: RPI Coating completed top coating on the Traveler Trolley Links and Suspension Arms on this date. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

Note: RPI Coating Quality Control (QC) Representative Mr. Miguel Nunez informed QA Inspector that after today he will no longer be doing the coat application here at WMI and that QC Mr. Preston Keen will be taking over the project. Later in the afternoon Mr. Nunez introduced QA Inspector to Mr. Keen. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

Note: Commercial Scaffolding of Ca, Inc (CSI) is on-site and erecting scaffolding to enclose paint booth in Bay 6 for RPI Coating.

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 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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Inspected By:	Brannon, Sherri	Quality Assurance Inspector
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Reviewed By:	Lanz, Joe	QA Reviewer
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