

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-026223**Date Inspected:** 30-Aug-2011**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Westmont Industries**OSM Arrival Time:** 600**OSM Departure Time:** 1430**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 welding 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.

SAS-WB Traveler - Fixed Stair Section

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

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

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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 welder Mr. Charles Newton (WID # 3200) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Newton performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector randomly 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 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.

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.

Component Material Inspection

The QA Inspector met with WMI (QCM) Mr. Curt Bell and was requested to release lubricator & pipe support brackets ASTM A36 material for bid item 99 & 100 to Cal West Galvanizing. The QA Inspector reviewed the Certificate of Compliance (C.O.C). The QA Inspector noted that the material and documentation appeared to be in general compliance with the contract requirements. Note: Pending final approval of shop drawings. The QA Inspector issued a green tag with lot number B208-012-11. The QA Inspector was informed that the material will be shipped to Cal West Galvanizing in Long Beach, California, for hot dip galvanizing. See the accompanying TL-6011 report for specific information. Note: Pending shop drawing approval.

RPI Coating (Blast and Paint)

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

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Note: Commercial Scaffolding of Ca, Inc (CSI) is on-site and continuing to 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.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer