

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026292**Date Inspected:** 13-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**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 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) performing 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.

SAS-WB Traveler – Lower Truss Frame Assembly

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

SAS-WB Traveler - Fixed Stair Section

This QA Inspector randomly observed WMI production personnel Mr. Jose Rodriguez (WID # 3031) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW in all positions on tube steel and plate material, randomly

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throughout the shift.

E2/E3-WB Traveler (South) & (North)

This QA Inspector randomly observed WMI CWI production personnel 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. Rayas 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. 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 afternoon shift.

E2/E3 EB Traveler

This QA Inspector randomly observed WMI production personnel Mr. Charles Newton WID#3200, performing layout, fitting and tack welding activities at various locations for the E2/E3 EB Traveler Assemblies. This QA Inspector observed Mr. Newton performing the FCAW in all positions randomly throughout the morning 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-EB Traveler Assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions on tube steel and plate material, randomly throughout the morning shift.

Traveler Trolley Train Suspension System Assembly

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes and one helper assembling trolley train suspension system 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 Coating is on site to continue sweep blast and apply the prime coat application on the SAS EB Traveler. QA Inspector was informed by RPI

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Coating Quality Control (QC) Representative Mr. Preston Keen that RPI is going to sweep blast a another section and apply the Sherman Williams Zinc Clad II prime coat to the today. Later in the morning this QA Inspector randomly observed that RPI personnel performing sweep blasting activities on the SAS EB Traveler. After sweep blasting was completed, QA Inspector then observed Mr. Keen performing random surface profile checks on the sweep blasted base metal surfaces. This QA Inspector observed Mr. Keen utilizing a Testex Press-O-Film and a micrometer to perform the testing. During observation, this QA Inspector observed that the readings appeared to be 2.3 mils, 3.6 mils, and 3.4 mils. Testing observed by QA Inspector appears to be in compliance with the contract requirements. After testing was completed this QA observed RPI Coating personnel masking areas to prevent overspray.

Later in the shift, this QA Inspector randomly observed RPI Coating performing what appeared to be primer application activities within what appeared to be within and 8 hour time frame form the above mentioned sweep blasting activities. Environmental readings taken by RPI at the time of primer application are as follows Air Temperature 65/82 F, Relative Humidity 72/57%, Wet Bulb Temperature 59/70 F, Dew point 56/66 F and Surface Temperature 65/74 F.

QA Inspector performed measurement on dry coating thickness with Type 2 (magnetic gage), DFT's thickness reading of the prime coated section coated on 09-12-11 are an average of three (3) thickness reading are as follows 5.0 mils, 6.7 mils, 6.1 mils 6.9 mils, 5.4 mils, 4.7 mils, 3.8 mils, and 4.4 mils. QA Inspector also, observed Mr. Keen documenting daily actives on RPI Coating QC Daily Inspection Report.

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:

QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

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
Reviewed By:	Lanz, Joe	QA Reviewer
