

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: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026656
Date Inspected: 02-Nov-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:	Chris Concha	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

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 performing layout and fitting at various locations for the SAS-WB Traveler Assemblies. No welding performed on the SAS-WB Traveler on this date.

Repair of Dented Truss Members on the E2/E3-WB Traveler (South end)

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes WID#3201 and Mr. Jesus Rayas WID#3197 removing dented section from Assembly 8, A427 bottom chord TSS using a hack saw and a saber saw. Later in the shift QA Inspector randomly observed WMI personnel Mr. Fuentes and Mr. Rayas performing fit-up and tack welding on Assembly 8-A427 bottom chord splice (TSS 6"x4"x3/16") and Assembly 7-B427 bottom chord "Band-Aid" (10"x8-1/4"x10 GA, ASTM A572 GR. 50) for seal welding WJ# AR1, using approved FCAW process. Later in the day QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) performing Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler, Assembly 7-B427, bottom chord "Band-Aid" repair seal welding. Welding completed on this date on Assembly 7-B427. Mr. Lopez then moved to Assembly 8-A427 bottom chord splice. Mr. Lopez completed welding the root pass at weld joint FSR #1 and FSR #2 only on this date. Welding not completed on this date and will continue tomorrow 11-3-11. For additional information on the above repair review contract document

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ABF-RFI-002619R00 dated October 27, 2011.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha 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. Concha 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 continuing with the coating application on the E2/E3 WB Traveler. QA Inspector was informed by RPI Coating Mr. Preston Keen that RPI is going to sand sections 1, 2 & 3 using 100 grit sand paper, pressure wash section 1 this morning and in the afternoon completed testing and apply a mist coat on section 1 using Sherwin Williams Polysiloxane XLE-80 today,. QA Inspector randomly observed that RPI personnel performing sanding, pressure washing activities on the E2/E3 WB Traveler. Environmental readings taken by RPI at the time of coating application are as follows respectively: Air Temperature 53/76 F, Relative Humidity 71/48%, Wet Bulb Temperature 48/64 F, Dew point 43/57 F and Surface Temperature 51/78 F. QA Inspector also, observed Mr. Keen documenting daily actives on RPI Coating QC Daily Inspection Report.

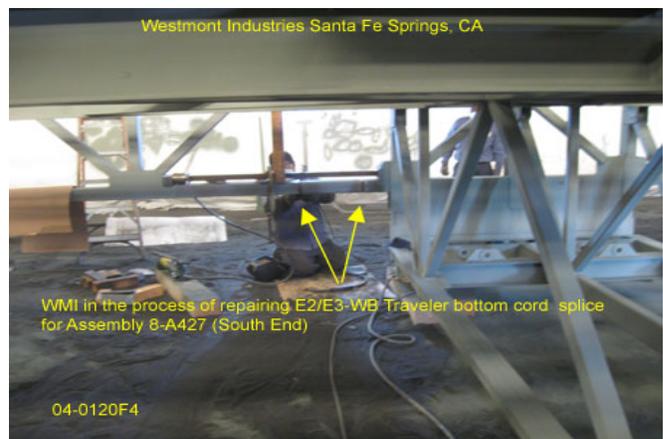
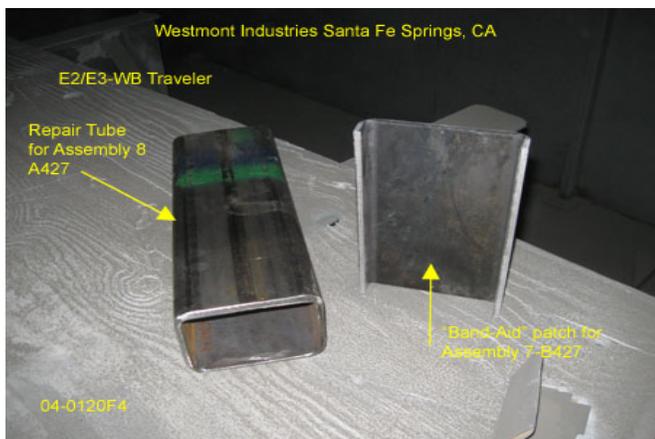
Mr. Keen informed QA Inspector that on the interim coating of the Sherman Williams Zinc Clad II, Inorganic Zinc Rich prime coating he would be performing ASTM D3363 - Film Hardness by Pencil Test, ASTM D4752 Measuring MEK Resistance to Ethyl Silicate (Inorganic) Zinc-Rich Primers by Solvent Rub and performing the Quarter test at section 1. Mr. Keen stated that he will be using Sherman Williams R7 KIII High Solids compliant thinner #1 for the solvent rub test. Testing observed is as follows:
Prime coated on 10-28-11 (section 1), Pencil Test (pass), Quarter Test (pass) and Rub test (pass).

QA Inspector performed measurement on dry film thickness with Type 2 (magnetic gage), DFT's thickness reading of the prime coated section 3 coated on 11-01-11 and Caltrans 2'x2' test plate are an average of three (3) thickness reading are as follows 3.6 mils, 3.7 mils, 3.6 mils 3.8 mils, 4.1 mils, 4.0 mils, 5.4 mils, 5.2 mils, 5.2 mils, and 5.9 mils, average dry film thickness 4.5 mils and dry film thickness on test plate 4.9 mils.

QA Inspector Fintan Shanley and this QA Inspector performed measurement on dry film thickness with Type 2 (magnetic gage), DFT's thickness reading on the E2/E3-EB Traveler Sherwin Williams Polysiloxane XLE-80 Finish coat reading are an average of three (3) thickness reading are as follows 6.4 mils, 12.1 mils, 13.8 mils 13.5 mils, 8.1 mils, 9.0 mils, 10.9 mils, 5.6 mils, 9.3 mils, 13.3 mils, 9.8 mils, 9.1 mils, 9.0 mils, 10.3 mils, 9.2 mils, 8.5, mils, 3.8 mils, 8.9 mils, 11.4, mils, 13.1 mils, 12.7 mils, 9.6 mils, 12.8 mils, 5.4, mils, 8.5 mils, 5.4 mils, 9.4 mils, 14.4, mils, 7.4, mils, and 12.3 mils, average dry film thickness 9.7 mils. QA Inspectors informed RPI Coating that areas found with low DFT's thickness reading are marked with blue tape. Mr. Keen stated that he will apply additional top coating to the areas found and marked by Caltrans tomorrow.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer
