

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-026657**Date Inspected:** 03-Nov-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:** 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)**

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 8-A427 bottom chord repair splice. Mr. Lopez completed welding at weld joints SR #1 and SR #2 on this date. For additional information on the above repair review contract document ABF-RFI-002619R00 dated October 27, 2011. Repair of Dented Truss Members on the E2/E3-WB Traveler (South end) appears to comply with contract documents. Welding completed on this date.

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

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

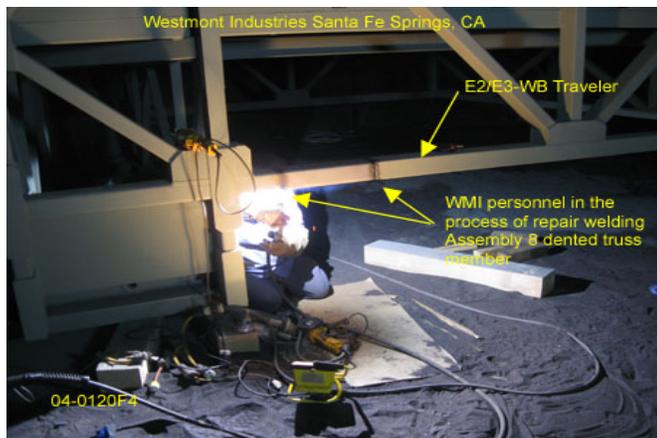
that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process 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 strip coat welded areas in section 1 in the morning and mist coat section in the afternoon using the Sherwin Williams Polysiloxane XLE-80, perform adhesion tests and pressure wash section 2 today. Mr. Keen also stated that RPI is going to touch up areas of low DFT's reading found by QA Inspectors on 11-02-11 on the E2/E3-EB Traveler, and touch some area's on the SAS-EB Traveler QA Inspector randomly observed that RPI personnel performing the above activities on the travelers. Environmental readings taken by RPI at the time of coating application are as follows respectively: Air Temperature 53/77 F, Relative Humidity 41/41%, Wet Bulb Temperature 42/61 F, Dew point 29/50 F and Surface Temperature 52/76 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 D4541 – Standard Test Method for Pull-Off Strength of Coating Using Portable Adhesion Tester, Mr. Keen stated that he will be using a calibrated Elcometer Hydraulic Adhesion Tester Model 108 for the adhesion test. Testing observed is as follows: Prime coated on 10-31-11 (section 2), Adhesion test 1000 psi and 725 psi. QA Inspector also, observed Mr. Keen documenting daily actives on RPI Coating QC Daily Inspection Report.

Note: Touch up of Final top on the SAS-EB Traveler not completed on this date.



---

---

# 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.

---

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

---