DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

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

Report No: WIR-026660
Date Inspected: 04-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

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
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).

Miscellaneous Traveler Modifications

This QA Inspector randomly observed WMI qualified welder Mr. Richard Fuentes WID #3201 and helper Mr. Jesus Rayas WID#3197, disassembling two (2) previously build platform balcony's for the SAS Travelers in preparation for the balcony modifications. Note: The two balconies for the SAS Travelers had been completed previously. See CCO 183 – Miscellaneous Traveler Modifications for additional information. WMI is aware that they are proceeding at their own risk pending drawing approval.

SAS-WB Traveler

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 performing layout and fit-up to splice the lower truss section and fixed stair section for the SAS-WB Traveler Assemblies. No welding performed on the SAS-WB Traveler 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 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 top coat section1 and complete tests and mist coat section 2 using the Sherwin Williams Polysiloxane XLE-80, today. Environmental readings taken by RPI at the time of top coat application are as follows respectively: Air Temperature 60/62 F, Relative Humidity 74/83%, Wet Bulb Temperature 55/79 F, Dew point 52/57 F and Surface Temperature 59/71 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 2. 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 10-31-11 (section 1), Pencil Test (pass), Quarter Test (pass) and Rub test (pass).

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 on the six (6) areas that were found to be lower than required minimum thickness, reading are an average of three (3) thickness reading on the area that were touch up by RPI Coating on 11-03-11 are as follows 12.8 mils, 9.9 mils, 11.8 mils 10.2 mils, 10. 1 mils, and 8.9 mils, average dry film thickness 10.6 mils.

Mr. Keen informed QA Inspector that RPI will start using a new shipment of the Sherwin Williams Polysiloxane XLE-80 Coating today. QA inspector informed Mr. Keen that samples will need to be taken on the new paint. QA Inspector informed Mr. Keen that RPI will be proceeding at their own risk pending sample acceptance tests. Mr. Keen stated that he is aware that RPI is proceeding at their own risk. QA Inspector sampled of part A, and part B, of Sherwin Williams Polysiloxane XLE-80 Coating. QA Inspector assigned Caltrans Lot #B208-021-11 and TL-101 # 711700.

WELDING INSPECTION REPORT

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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