

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-026661
Date Inspected: 05-Nov-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 500
OSM Departure Time: 1330
Location: Santa Fe Springs, CA

CWI Name:	Chris Concha, Ruben Gonzaez	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	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 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.

Traveler Balconies

This QA Inspector randomly observed WMI qualified welder Mr. Eutimo Lopez (WID # 3035) fillet welding joining end cap plates to diagonal brace tube. Mr. Lopez was observed welding in the 2F(horizontal) position utilizing flux cored arc welding (FCAW) process with a 1.1mm diameter electrode, filler metal brand Lincoln Electric, Ultracore 71A85, class E71T-1M. QA Inspector observed the CWI Inspector Mr. Chris Concha verifying that the pre-heat and welding parameters were in accordance with the Welding Procedure Specification (WPS). Welding parameters observed by QA Inspector Brannon appear to be in general compliance with the approved WPS. Note: The three balconies for the E2/E3 Travelers had been completed previously, end caps added after WMI realized they had failed to weld end caps when the balconies were fabricated in December 2010. Note: Welding completed on 3 of 5 balconies on this date.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha was present,

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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.

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

This QA Inspector witnessed Smith Emery, CWI, QC Inspector Mr. Ruben Dominguez perform Visual Inspection (VT) and 100% Ultrasonic Inspection (UT) on Assembly 8-A427 bottom chord (South End) splice repair, weld joints SR#1 and SR#2. Mr. Dominguez informed QA that he found no relevant indications in either of the two (2) splice welds. Upon completion of the QC Inspectors inspection this QA Inspector performed 100% VT and 25% (UT). See Caltrans Ultrasonic Test Report, TL-6027 dated November 5, 2011 for additional information. Also, see contract document ABF-RFI-002619R00 dated October 27, 2011.



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