

**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-026662**Date Inspected:** 07-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

<b>CWI Name:</b>	Chris Concha		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

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, performing layout, fitting and tack welding on two (2) platform balconies for the SAS Traveler balcony modifications. This QA Inspector observed Mr. Fuentes and Mr. Rayas performing the FCAW in all positions randomly throughout the shift. 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

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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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 perform testing, pressure wash this morning and apply mist coat in the afternoon to section 3 and Caltrans test plate. Also, apply final top coat section 2 using the Sherwin Williams Polysiloxane XLE-80, today. Environmental readings taken by RPI at the time of top coating application are as follows respectively: Air Temperature 46/70 F, Relative Humidity 72/41%, Wet Bulb Temperature 42/56 F, Dew point 38/46 F and Surface Temperature 45/71 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 D4541 – Standard Test Method for Pull-Off Strength of Coating Using Portable Adhesion Tester, 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 3 and Caltrans test plate. Mr. Keen stated that he will be using a calibrated Elcometer Hydraulic Adhesion Tester Model 108 for the adhesion test and Sherman Williams R7 KIII High Solids compliant thinner #1 for the solvent rub test. Testing observed is as follows:

Prime coated on 11-01-11 (section 3), Adhesion Test – 850 psi and 1000 psi, Pencil Test (pass), Quarter Test (pass) and Rub test (pass).

Prime coated on 11-01-11 (Caltrans test plate), Adhesion Test – 1000 psi, Pencil Test (pass), Quarter Test (pass) and Rub test (pass).

### 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.

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