

**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-026673**Date Inspected:** 08-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**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, 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, fit-up and tack welding to splice the lower truss section and fixed stair section for the SAS-WB Traveler Assemblies. This QA Inspector observed Mr. Canales performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI qualified welder Mr. Eutimo Lopez (WID # 3035) splice welding joining lower truss section to the fixed stair section. Mr. Lopez was observed welding in the all positions, utilizing flux cored arc welding (FCAW) process with a 1.1mm diameter electrode, filler metal brand Lincoln Electric,

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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.

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 section 3 out gassing areas and later in the day apply final top coat, and pressure wash in the morning and mist coat to the Caltrans test plate in the afternoon using the Sherwin Williams Polysiloxane XLE-80, today. Mr. Keen later in the shift informed QA Inspector that RPI will not complete the mist coat application on section 3 today. Environmental readings taken by RPI at the time of top coating application are as follows respectively: Air Temperature 45/76 F, Relative Humidity 70/40%, Wet Bulb Temperature 41/56 F, Dew point 36/39 F and Surface Temperature 44/72 F. QA Inspector also, observed Mr. Keen documenting daily actives on RPI Coating QC Daily Inspection Report.



## 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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