

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-026692**Date Inspected:** 09-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**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 performing layout, fitting and tack welding on two (2) platform balconies for the SAS Traveler balcony modifications. This QA Inspector observed Mr. Fuentes 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.

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and Mr. Jesus Rayas WID#3197, performing layout, fitting and tack welding activities at various locations for the SAS WB Traveler Assemblies. This QA Inspector observed Mr. Rayas performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

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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 final top coat section 3 and Caltrans Test Plate using the Sherwin Williams Polysiloxane XLE-80, today. Environmental readings taken by RPI at the time of coating application are as follows respectively: Air Temperature 47/71F, Relative Humidity 64/42%, Wet Bulb Temperature 41/57 F, Dew point 35/41 F and Surface Temperature 44/61 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.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer