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

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-026693
Date Inspected: 10-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 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.

SAS-WB Traveler

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and Mr. Jesus Rayas WID#3197performing 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,

Ultracore 71A85, class E71T-1M. Welding parameters observed by QA Inspector Brannon appear to be in general compliance with the approved WPS.

Traveler Mechanical Assemblies

This QA Inspector randomly observed WMI qualified welder Mr. Daniel Grayum (WID # 3049) performing fitting, tack welding and welding activities on mechanical console box frames for the Maintenance Travelers.

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 abrasive blast the two (2) areas where WMI had repaired and apply the Sherwin Williams Zinc Clad II, and start touching up section 1, 2, & 3. After abrasive blasting was completed, QA Inspector then observed Mr. Keen performing what appeared to be random surface profile checks on the sweep blasted base metal surfaces. This QA Inspector observed Mr. Keen utilizing a Testex Press-O-Film and a micrometer to perform the testing. This QA Inspector then observed Mr. Keen utilize a micrometer to measure the surface profile on the clear film part of the strip, in which the rubbing was performed. Mr. Keen explained to this QA Inspector that the initial setting on the micrometer was set at 2mils over, due to the thickness of the X-Coarse Press-O-Film paper. During observation, this QA Inspector observed that the readings appeared to be 2.8 mils. This QA Inspector was then informed by Mr. Keen that primer application will soon start. Later in the shift, this QA Inspector randomly observed RPI Coating performing what appeared to be primer application activities within what appeared to be within and 8 hour time frame form the above mentioned blasting activities. Environmental readings taken by RPI at the time of top coating application are as follows respectively: Air Temperature 58 F, Relative Humidity 44%, Wet Bulb Temperature 43 F, Dew point 25 F and Surface Temperature 45 F. QA Inspector also, observed Mr. Keen documenting daily actives on RPI Coating QC Daily Inspection Report. RPI spent the later part of the day removing spent basting material from bay 6 in preparation for CSI to move the E2/E3 WB Traveler out of bay 6 to outside under the test rack.

QA Inspector performed measurement on dry film thickness with Type 2 (magnetic gage), DFT's thickness reading of the final top, coated on 11-09-11 Caltrans 2'x2' test plate are an average of three (3) thickness reading are as follows 8.2 mils, 11.1 mils, and 8.7 mils, average dry film thickness 9.3 mils.

WELDING INSPECTION REPORT

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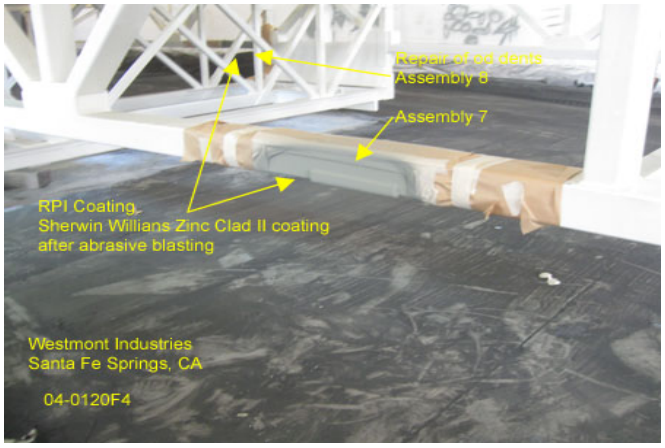

Summary of Conversations:

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