

**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-026706**Date Inspected:** 11-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.

**SAS-WB Traveler**

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and Mr. Jesus Rayas WID#3197 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. 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 randomly observed CSI moving the E2/E3 WB Traveler out of bay 6 to outside under the test rack. This QA Inspector performed random shop observations and observed that RPI is on site and starting coating application on the Bike Path link assemblies. QA Inspector was informed by RPI Coating Mr. Silviano Hernandez that RPI is going abrasive blast bike path link assemblies and apply the Sherwin Williams Zinc Clad II. After abrasive blasting was completed, QA Inspector then observed Mr. Hernandez performing what appeared to be random surface profile checks on the abrasive blasted base metal surfaces. This QA Inspector observed Mr. Hernandez utilizing a Testex Press-O-Film and a micrometer to perform the testing. This QA Inspector then observed Mr. Hernandez utilize a micrometer to measure the surface profile on the clear film part of the strip, in which the rubbing was performed. During observation, this QA Inspector observed that the readings appeared to be 3.4 mils. This QA Inspector was then informed by Mr. Hernandez 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 from the above mentioned blasting activities. Environmental readings taken by RPI at the time of coating application are as follows: Air Temperature 77 F, Relative Humidity 40%, Wet Bulb Temperature 62 F, Dew point 50 F and Surface Temperature 83 F.



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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.

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

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