

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-026727**Date Inspected:** 16-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		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	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).

This QA Inspector observed a dent in the E2/E3 WB Traveler diagonal support 3"x3"x3/16" tube MK#46 on WMI-E2/E3-410 Revision A drawing. Dent appears to be 110mm in length, 55mm in width and 8mm in depth. QA Inspector informed and showed WMI Mrs. Ida Goldenberg of QA Inspectors findings. Mrs. Goldenberg informed this QA that WMI will submit and Request for Information (RFI) for repair of the dent. QA Inspector also, informed QA Inspector Mr. Joe Lanz of the above information.

WMI Mrs. Goldenberg informed this QA Inspector that WMI is going to caulk the E2/E3 Bike Path Traveler, four brake trolley suspensions and two hanger type 3 in the areas that WMI was unable to weld due to in accessible for welding. Mrs. Goldenberg stated that she is going to submit a Request for Information (RFI) to use Sikaflex 1A. QA Inspector informed QA Inspector Mr. Joe Lanz of the above information.

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 in the afternoon.

SAS WB Traveler

WELDING INSPECTION REPORT

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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.

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 Maintenance Travelers. QA Inspector was informed by RPI Coating Mr. Preston Keen that RPI and WMI will continue abrasive blasting on the SAS/E2-E3 Elevating Platforms and the E2/E3 Bike Path Traveler Assemblies today. Blasting not completed on this date.

Summary of Conversations:

QA Inspector Brannon was informed by QA Inspector Mr. Joe Lanz that WMI will be removing the coating application on the E2/E3 WB Traveler, Assembly 7 – B427 band aid repair and have Smith Emery to perform 100% magnetic particle Inspection on the seal weld.

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
