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

Bay Area Branch
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Contract #: 04-0120F4
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-026823
Date Inspected: 05-Dec-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).

Traveler Trolley Train Suspension System Assembly

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes and helpers assembling trolley train suspension system with revised brake mounts mock-up randomly throughout the shift.

Miscellaneous Traveler Modifications

This QA Inspector randomly observed WMI qualified welder Mr. Larry Swanson WID #3058, performing layout, fitting and tack welding on two (2) platform balconies for the SAS Traveler balcony modifications. 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 Smith Emery, CWI, QC Inspector Mr. Chris Concha performing visual inspection on the SAS WB traveler. Mr. Concha informed this QA Inspector that he had found several areas for in process grinding and welding. This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) grinding and welding areas found Mr. Concha using Flux Core Arc Welding (FCAW) process in all positions on tube steel and plate material, randomly throughout the shift. QC visual inspection and pick-up

welding not completed on this date.

RPI Coating (Blast and Paint)
This QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI will be abrasive blasting rusted areas on three (3) elevating platforms and (3) balconies that had been previously prime coated in April of 2011. Mr. Keen also stated that RPI will be abrasive blasting pick-up areas from WMI welding and grinding on (3) balconies that had been previously been prime coated in April of 2011. Mr. Keen informed this QA that for the prime application he will be using Sherman Williams Zinc Clad III HS 100 prime application on the repair and pick up areas. 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 activities. Environmental readings taken by RPI at the time of the coating application are as follows Air Temperature 66/69 F, Relative Humidity 44/40%, Wet Bulb Temperature 52/52 F, Dew point 39/34 F and Surface Temperature 67/69 F.

This QA Inspector performed measurement on dry film thickness with Type 2 (magnetic gage), DFT's thickness reading on the E2/E3 Bike Path Traveler Sherwin Williams Zinc Clad II Plus prime coating on the three (3) areas, reading are an average of three (3) thickness reading on the areas are as follows: 3.7 mils, 4.0 mils, 3.9 mils, and 4. 5 mils, average dry film thickness 4.0 mils.

Mr. Keen informed QA Inspector that on the interim coating of the Sherman Williams Zinc Clad II Plus, Inorganic Zinc Rich prime coating he would be performing ASTM D4541 – Standard Test Method for Pull-Off Strength of Coating Using Portable Adhesion Tester, ASTM D3363 - Film Hardness by Pencil Test, ASTM D4752 Measuring MEK Resistance to Ethyl Silicate (Inorganic) Zinc-Rich Primers by Solvent Rub and performing the Quarter test at section 3 and Caltrans test plate. Mr. Keen stated that he will be using a calibrated Elcometer Hydraulic Adhesion Tester Model 108 for the adhesion test and Sherman Williams R7 KIII High Solids compliant thinner #1 for the solvent rub test. Testing observed is as follows:
Prime coated on 11-28-11 – (Bike Path Assemblies), Adhesion Test – 625 psi, Pencil Test (pass), Quarter Test (pass) and Rub test (pass). Testing observed by QA Inspector appears to be in compliance with the contract requirements. After testing had been completed RPI sanded and pressure washed the remaining Bike Path Assemblies per contract documents.

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:	Levell,Bill	QA Reviewer