

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-026854**Date Inspected:** 09-Dec-2011**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Westmont Industries**OSM Arrival Time:** 500**OSM Departure Time:** 1330**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).

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.

Traveler Trolley Train Suspension System Assembly

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes and helpers assembling bike path trolley train suspension system for testing on the 5 meter curved radius.

SAS WB Traveler

This QA Inspector randomly observed WMI production welders Mr. Daniel Grayum (WID # 3049) and Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Assemblies Console box frame supports. This QA Inspector observed Mr. Grayum tack welding and Mr. Lopez performing the FCAW in all positions on angle plates to tube steel 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.

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 morning shift. QC Mr. Chris Concha informed this QA that he had pick-up welding and visual inspection has been completed. This QA performed random visual and magnetic particle testing on the SAS WB Traveler. See Caltrans Magnetic Particle Testing report TL-6028 for additional information.

SAS WB Traveler

This QA Inspector observed WMI representative Mr. Cesar Canales performing random dimensional verification on the SAS-WB Traveler. QA Inspector noted that at this time all of the welding of the assemblies for SAS-WB Traveler appeared to be complete. During the activities, this QA Inspector noted that these locations included random sections of various frame assemblies, random sections of the primary and secondary suspension lift plates, and random dimensional measurements which include overall length, width and height of the completed traveler assembly. QA noted that random dimensional measurement appeared to be within approved tolerances in relation to shop drawings dimensions.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI Coating is not on site to continuing with the coating application on this date.



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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
