

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: 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-026875**Date Inspected:** 12-Dec-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).

This QA Inspector was informed by WMI Mr. George Grayum that WMI had received some miscellaneous materials for the Travelers. Mr. Grayum presented QA with material test report. QA Inspector reviewed Material Test Reports (MTR's) and checked physical condition of the components to be used for this project, verifying heat number and quantity. Materials inspected contained heat numbers as well as dimensions and material type. Details of materials inspected and approved for use on this project are listed below. QA Inspector issued Caltrans lot number B208-034-11 for OK to cut components and on the MTR as authorization and materials traceability purposes. The test results and conclusions indicated herein were based on random inspections and observations as described in this report. These documents are included as part of this report. Note: Domestic materials.

Materials Inspected &amp; Approved (OK to Cut B208-034-11)

MATERIAL DESCRIPTION – tube- 6" x 6" x 1/4" x 48' – ASTM A500 Gr. B

HEAT No. / MFR – F6778 / Maruichi American Corporation, Santa Fe Springs, CA

QUANTITY - 1 ea

In response to TL-38 request this QA verified Shew System Stainless Steel Indicator Painted Plates. QA verified eight (8) Shew System Stainless Steel Indicator Painted Plates dimensions and colors per Caltrans Skew Sensor and Control – 04, sheet number 1161S4R1. This QA verified material to be 316 stainless steel material and

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dimension are as follows: length 872mm x width 175mm and thickness of 3mm and color pattern red, yellow, green, green, yellow and red. QA noted that Shew System Stainless Steel Indicator Painted Plates appear to comply with contract documents.

## Miscellaneous Traveler Modifications

This QA Inspector randomly observed Westmont Industries (WMI) production fitter, Mr. Larry Swanson (WID #3058), performing fitting and lay out activities on material, 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.

## Miscellaneous Mechanical

This QA Inspector randomly observed Westmont Industries (WMI) production fitter, Mr. Larry Swanson (WID #3058), performing fitting and tack welding activities on material, for the Lubricators supports Bracket Assembly – A920-A. Mr. Swanson was observed tack welding using approved Flux Cored Arc Welding (FCAW) process, welding in all positions.

## Miscellaneous Mechanical

This QA Inspector randomly observed Westmont Industries (WMI) production welder, Mr. Daniel Grayum (WID # 3049), performing fitting and lay out activities on material, for the Maintenance Traveler Navigation Light Mount Assembly. Note: See CCO 183 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.

## RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI Coating is on site to start abrasive blasting on the SAS WB Traveler. This QA randomly observed RPI Coating in the process of abrasive blasting.

This QA noted above items observed appear to comply with contract documents.



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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>	Levell, Bill	QA Reviewer

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