

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-026892**Date Inspected:** 15-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		
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).

Traveler Trolley Train Suspension System Assembly (Bike Path)

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes and helpers continuing to assemble bike path trolley train suspension system randomly throughout the morning shift. QA noted that Caltrans Structures Representative, Mr. Thuc Tran, and Mr. Mike Gulli, Caltrans SMR Mr. Nicolai Hvass, ABF Mr. Chris Bausone, Ty Lin Mr. Andrew Baumberger, WMI Mr. Ray Meier, Mrs. Ida Goldenberg, QC Mr. Manuel Macias, QC Ray Anaya, on site at Westmont Industries to witness Bike Path Trolley 5 meter curved radius testing today. Testing completed on the trolley assembly inner rail (East & West) trolley and trolley assembly outer rail (East & West). Caltrans Structures Representative, Mr. Thuc Tran and this QA observed Ingersoll Rand representatives change spinals in trolley motor numbers T015517 and T015516 and connect motor to WMI shop air to show that the motors were working properly. Ingersoll Rand representatives also, remove excess grease from trolley wheel and replace the cap on trolley motor T015301.

Miscellaneous Traveler Modifications

This QA Inspector randomly observed Westmont Industries (WMI) production welder, Mr. Jose Rodriguez (WID #3031), performing welding activities on material, for the Traveler Modifications. Mr. Rodriguez was observed welding using approved Flux Cored Arc Welding (FCAW) process, welding in the horizontal (2F) position. Note: The two balconies for the SAS Travelers had been completed previously. See CCO 183 – Miscellaneous Traveler

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Modifications for additional information.

Miscellaneous Traveler Modifications

This QA Inspector randomly observed Westmont Industries (WMI) production fitter, Mr. Larry Swanson (WID #3058), and observed fitting and lay out activities on material, for the SAS Travelers Supplementary Platforms.

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.

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.



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