

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-026940**Date Inspected:** 20-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 B208-037-11 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 & Approved (OK to Cut B208-037-11)

MATERIAL DESCRIPTION – angle- 8” x 8” x 7/8” x 20’ – ASTM A572 Gr. 50

HEAT No. / MFR – 369873 & 369887 / Nucor-Yamato Steel Co, Blytheville, AR

QUANTITY - 4 ea

Traveler Trolley Train Suspension System Assembly

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes and 5 helpers continuing disassembling bike path trolley train links suspension system links in preparation for welding revised brake

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

mounts to links plates.

Miscellaneous Traveler Modifications

This QA Inspector randomly observed Westmont Industries (WMI) production welder's, Mr. Jose Rodriguez (WID #3031) and Mr. Juan Jimenez (WID#3059), performing welding activities on material, for the Traveler balcony modifications. Mr. Rodriguez and Mr. Jimenez were observed welding using approved Flux Cored Arc Welding (FCAW) process, welding in all positions. Note: The two balconies for the SAS EB/WB Travelers had been completed previously. See CCO 183 – Miscellaneous Traveler Balcony Modifications for additional information. Welding completed on this date. QC Inspector Mr. Chris Concha and this QA Inspector performed visual inspection (VT) on the above mentioned balconies. Items observed appear to comply with contract documents. QA Inspector also, performed Magnetic Particle Testing on the above, see Caltrans Magnetic Particle Test Report TL-6028 for additional information. Note: WMI Mrs. Ida Goldenberg informed this QA Inspector that WMI will submit a Request for Information (RFI) to caulk inaccessible weld areas on the back side of each hinge on the two (2) balconies.

Miscellaneous Traveler Modifications

This QA Inspector randomly observed Westmont Industries (WMI) production fitter, Mr. Larry Swanson (WID #3058), and observed fitting and welding activities on material, for the SAS Travelers Supplementary Platforms. Mr. Swanson was observed tack welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F position. 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 welder, Mr. Daniel Grayum (WID # 3049), performing fitting and welding activities on material, for the FRL Unit Support Bracket Assemblies. Mr. Grayum was observed welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F positions. Welding completed on this date. WMI is aware that they are proceeding at their own risk pending drawing approval.

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 Coating is on site to continue coat applications on the SAS WB Traveler. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI is going to sweep/spot blast and apply the Sherwin Williams Zinc Clad II prime coating today. Later in the morning this QA Inspector randomly observed that RPI personnel performing sweep/spot blasting activities on the SAS WB Traveler fixed stair top side of steps and side rails. After

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

sweep/spot blasting was completed, QA Inspector then observed Mr. Keen performing random surface profile checks on the sweep blasted base metal surfaces. This QA Inspector observed Mr. Keen utilizing a Testex Press-O-Film and a micrometer to perform the testing. During observation, this QA Inspector observed that the readings appeared to be 3.2 mils, 3.1 mils, and 3.2 mils. QA Inspector then observed Mr. Keen perform a test for soluble salts on the previously blasted base metal surface. Testing observed by QA Inspector appears to be in compliance with the contract requirements.

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 sweep blasting activities. Environmental readings taken by RPI at the time of the coating application are as follows Air Temperature 47/70 F, Relative Humidity 70/51%, Wet Bulb Temperature 43/61 F, Dew point 38/54 F and Surface Temperature 45/57 F.

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