

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-026945**Date Inspected:** 22-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

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes and 3 helpers continuing disassembling bike path trolley train links suspension system links in preparation for welding revised brake mounts to links plates.

SAS Travelers Supplementary Platforms

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 Traveler Navigation Light Mounts A950 & B950. Mr. Grayum was observed fitting and tack welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F positions. WMI is aware that they are proceeding at their own risk pending drawing approval.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector randomly observed Westmont Industries (WMI) production welder's, Mr. Eutimo Lopez (WID # 3035) and Mr. Juan Lopez (WID #3126), welding activities on material, for the Traveler Navigation Light Mounts A950 & B950. Mr. Lopez and Mr. Lopez were observed welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F positions. 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 plus 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 bottom side of steps and rails. After 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 3.5 mils, 3.5 mils, and 3.0 mils. Testing observed by QA Inspector appears to be in compliance with the contract requirements. Mr. Keen informed QA Inspector's Mr. Fintan Shanley and this QA that RPI Coating is will be applying additional Sherwin Williams Zinc Clad II plus prime coating to the fixed stair section on Friday 12-23-11.

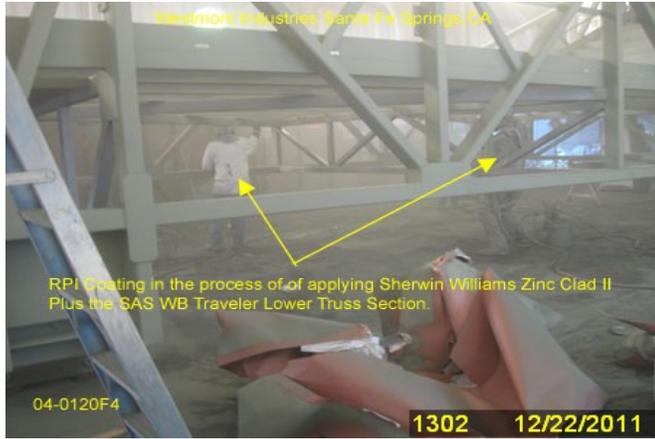
QA Inspectors Mr. Fintan Shanley and this QA performed a DFT (dry film thickness) survey of the E2/E3 Bike Path traveler on the Sherwin Williams, Polysiloxane XLE-80 topcoat. The Sherwin Williams, Polysiloxane XLE-80 had been spray applied by RPI Coating. A total of seventeen measurements on the E2/E3 Bike Path Traveler, were taken randomly throughout the structure in accordance with SSPC PA2 criteria. The overall average was in compliance with the contract requirements of 200 microns to 325 microns. Measurements that were found to be below the minimum requirement and were tagged with masking tape for the painters to perform touch up. The topcoat was found to be well cured and to generally meet the contract requirements.

QA Inspector sampled of parts A, part B, and part F, of Sherwin Williams Zinc Clad II Plus Inorganic Zinc-Rich Coating representing 7 gallons. QA Inspector assigned Caltrans Lot #B208-038-11 and TL-101 # 712429.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
