

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-026950**Date Inspected:** 23-Dec-2011**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Westmont Industries**OSM Arrival Time:** 500**OSM Departure Time:** 1000**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 B208-041-11 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: Foreign materials.

Materials Inspected & Approved (OK to Cut B208-041-11)

MATERIAL DESCRIPTION – tube- 4" x 3" x .188" x 20' – ASTM A500 Gr. B

HEAT No. / MFR – C050501 / Histeel CO., LTD. South Korea

QUANTITY - 1 ea

Materials Inspected & Approved (OK to Cut B208-041-11)

MATERIAL DESCRIPTION – angle- 1" x 1" x 3/16" x 20' – ASTM A36

HEAT No. / MFR – 480139 / Simec International, Blytheville, Mexico

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QUANTITY - 2 ea

In response to TL-38 request this QA verified SAS Maintenance Travelers Balconies Modification Folding Operation. This QA verified Balconies Modification per Caltrans Traveler Common Details NO.1A, sheet number 1083S1. QA noted that SAS Balconies Modification Folding Operation appear to comply with contract documents.

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.

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)

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Representative Mr. Preston Keen that RPI is going to reapply the Sherwin Williams Zinc Clad II prime coating on the fixed stair section today. Later in the morning this QA observed RPI Coating applying additional Zinc Clad II prime coating on the fixed stair due to overall average was not in compliance with the contract requirements of 90 microns to 150 microns.

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
