

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-026963**Date Inspected:** 27-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).

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 position.

This QA Inspector randomly observed Westmont Industries (WMI) production welder, Mr. Juan Jimenez (WID # 3059), welding activities on material, for the Traveler Navigation Light Mounts A950 & B950. Mr. Jimenez was observed welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F positions.

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,

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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 to the last section of the lower truss today. Later in the morning this QA Inspector randomly observed that RPI personnel performing sweep/spot blasting activities on the SAS WB Traveler lower truss section.

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 3.4 mils, 3.5 mils, and 3.5 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 an 8 hour time frame from the above mentioned sweep blasting activities. Environmental readings taken by RPI at the time of the coating application are as follows Air Temperature 42/72 F, Relative Humidity 61/41%, Wet Bulb Temperature 37/53 F, Dew Point 30/34 F and Surface Temperature 42/64 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.

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Inspected By:	Brannon, Sherri	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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