

**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-026986  
**Date Inspected:** 03-Jan-2012

**Project Name:** SAS Superstructure  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV  
**Contractor:** Westmont Industries

**OSM Arrival Time:** 600  
**OSM Departure Time:** 1430  
**Location:** Santa Fe Springs, CA

<b>CWI Name:</b>	Chris Concha	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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).

**SAS Travelers Supplementary Platforms**

This QA Inspector made random shop observations and observed no fit-up performed on the SAS Travelers Supplementary Platforms Assemblies on this date.

**Miscellaneous Traveler Modifications**

This QA Inspector randomly observed Westmont Industries (WMI) production personnel caulking inaccessible weld at hinge part of the foldable SAS traveler balcony rail per RFI-ABF-002684R00. See CCO 183 – Miscellaneous Traveler Modifications for additional information.

**E2/E3 EB Traveler**

This QA Inspector randomly observed WMI production welder Mr. Daniel Grayum (WID # 3049) grinding to remove paint and performing Flux Core Arc Welding (FCAW) activities on the E2/E3-EB Traveler piping supports. This QA Inspector observed Mr. Grayum tack welding and welding in all positions on angle plates to tube steel material, randomly throughout the shift.

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

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

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 is on site to continuing with the coating application on the SAS WB Traveler. QA Inspector was informed by RPI Coating Mr. Preston Keen that RPI is going to perform tests on the prime coating, sand prime coating, and pressure wash the end section of the lower truss, perform tests and apply mist coating and also apply top coating application to the fixed stair section using the Sherwin Williams Polysiloxane XLE-80, today. Environmental readings taken by RPI at the time of mist coat application are as follows respectively: Air Temperature 49/69 F, Relative Humidity 61/37%, Wet Bulb Temperature 43/55 F, Dew point 37/42 F and Surface Temperature 48/62 F. QA Inspector also, observed Mr. Keen documenting daily actives on RPI Coating QC Daily Inspection Report.

Mr. Keen informed QA Inspector that on the interim coating of the Sherman Williams Zinc Clad II Plus, Inorganic Zinc Rich prime coating he would be performing ASTM D4541 – Standard Test Method for Pull-Off Strength of Coating Using Portable Adhesion Tester, ASTM D3363 - Film Hardness by Pencil Test, ASTM D4752 Measuring MEK Resistance to Ethyl Silicate (Inorganic) Zinc-Rich Primers by Solvent Rub and performing the Quarter test at section 3 and Caltrans test plate. Mr. Keen stated that he will be using a calibrated Elcometer Hydraulic Adhesion Tester Model 108 for the adhesion test and Sherman Williams R7 KIII High Solids compliant thinner #1 for the solvent rub test. Testing observed is as follows:

Prime coated on 12-22-11 – middle section, Lower Truss – Adhesion Test – 800 psi and 1000) Pencil Test (pass), Quarter Test (pass) and Rub test (pass).

Prime coated on 12-27-11 – lower truss end section- Adhesion Test – 900 psi, Pencil Test (pass), Quarter Test (pass) and Rub test (pass).

Testing observed by QA Inspector appears to be in compliance with the contract requirements.

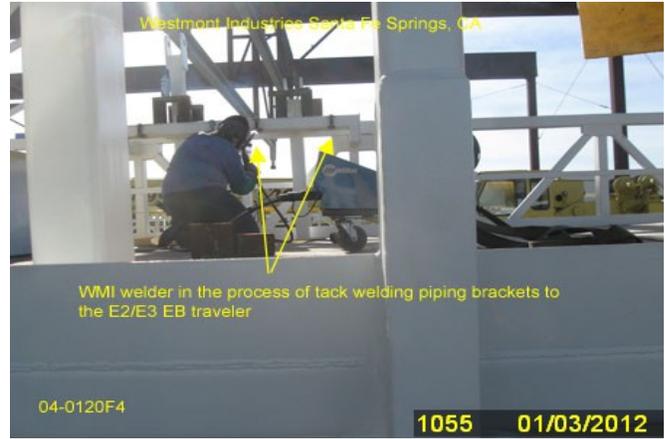
This QA noted above items observed appear to comply with contract documents.

---

# 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