

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-026987**Date Inspected:** 04-Jan-2012**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).

E2/E3 EB Traveler

This QA Inspector randomly observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing 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.

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.

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

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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 touch up top coating on the fixed stair section, apply a mist coat to the end section of the lower truss and apply top coating application to the fixed stair section, apply top coating on the middle section lower truss and mist coat the end section of the lower truss 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 49/70 F, Relative Humidity 67/38%, Wet Bulb Temperature 43/58 F, Dew point 38/43 F and Surface Temperature 48/64 F. QA Inspector also, observed Mr. Keen documenting daily activities 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 12-29-11 – SAS Balcony and Anti twist Beams – Adhesion Test – 720 psi and 1200) 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.



Summary of Conversations:

As stated within this report.

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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
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Reviewed By:	Levell, Bill	QA Reviewer
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