

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-026996**Date Inspected:** 05-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

<b>CWI Name:</b>	Chris Concha		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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 plate brackets 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.

This QA Inspector performed random shop observations and observed WMI installing horn, horn box and sump pump box on the E2/E3 EB Traveler.

## 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 top coating the end section on the fixed stair section, using the Sherwin Williams Polysiloxane XLE-80. Mr. Keen also stated that RPI will sand and pressure wash, and blow dry SAS balconies and anti twist beams in the morning and in the afternoon apply mist coat and final top coat using the Sherwin Williams Polysiloxane XLE-80. Mr. Keen informed QA Inspector that he will complete painting the SAS WB Traveler today.

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



## Summary of Conversations:

Per conversation with WMI Ida Goldenberg, WMI is going to get RPI Coating to blast prime and paint the piping brackets that WMI currently welding on the E2/E3 EB Traveler and the SAS EB, E2/E3 WB and SAS WB Travelers. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

## 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