

**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-026998**Date Inspected:** 09-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).

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 B208-003-12 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: Domestic/Foreign materials.

MATERIAL DESCRIPTION – plate- .375" x 60" x 120" – ASTM A36

HEAT No. / MFR – NT6555 / Evraz, Portland, OR

QUANTITY - 1 ea

MATERIAL DESCRIPTION – plate- .75" x 48" x 60" – ASTM A36

HEAT No. / MFR – 7247499 / Blues Scope Steel, Long Beach, CA

QUANTITY - 1 ea

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MATERIAL DESCRIPTION – plate- .875” x 24” x 24” – ASTM A36

HEAT No. / MFR – A1N0625 / Tuscaloosa, AL

QUANTITY - 1 ea

### SAS 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 SAS-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 Westmont Industries (WMI) production welder, Mr. Juan Jimenez (WID # 3059), performing welding activities on material, for the SAS Travelers Supplementary Platforms. Mr. Jimenez was observed 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 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.

### E2/E3-EB Traveler

This QA Inspector performed random shop observations and observed that Zemarc Corporation is on site at WMI today. Mr. Aguirre with Zemarc informed this QA Inspector that Zemarc will be here at WMI installing 2” compressed air line on the E2/E3-EB Traveler all week.

### RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI is on site at WMI today. QA Inspector was informed by RPI Coating Mr. Preston Keen that RPI will be removing spent abrasive blast material from Bay 6 today and will not be able to complete touch-up on the SAS WB Traveler until the end on the week.

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

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## 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