

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-027050**Date Inspected:** 13-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).

SAS-EB_E2/E3-EB/WB Traveler

This QA Inspector randomly observed WMI production welder Mr. Daniel Grayum (WID # 3049) and Eutimo Lopez (WID #3035), grinding to remove paint and performing Flux Core Arc Welding (FCAW) activities on the SAS-EB, E2/E3-EB, & E2/E3-WB Travelers, piping brackets, sump pump angle brackets and console panel angle brackets. This QA Inspector observed Mr. Grayum and Mr. Lopez tack welding and welding in all positions on brackets to tube steel material, randomly throughout the shift. Reference document ABF-RFI-002498R0.

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.

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Elevating Platforms

This QA Inspector randomly observed WMI shop personnel Mr. Richard Fuentes WID #3201 and helper Mr. Jesus Rayas WID#3197, attaching grading to the steps on the SAS-EB/WB, E2/E3-EB/WB Maintenance Travelers elevating platforms.

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. Aquirre with Zemarc informed this QA Inspector that Zemarc will be here at WMI installing 2" compressed air line on the E2/E3-EB Traveler today. Installation of the 2" piping system completed on this date.

RPI Coating (Blast and Paint)

This QA Inspector made random observations of the paint shop area in Bay 6 and observed no activates on this date.

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



Summary of Conversations:

QA Inspector was informed by WMI Mr. George Grayum that WMI will be welding on Saturday January 14, 2011 to complete fillet welding of piping brackets on SAS-EB, E2/E3-EB, & E2/E3-WB Travelers. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

Comments

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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
