

**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-027070**Date Inspected:** 18-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).

**SAS-EB Traveler**

This QA Inspector performed random shop observations and observed that Zemarc Corporation is on site at WMI today. Mr. Acuirre with Zemarc informed this QA Inspector that Zemarc will be here at WMI installing 2" compressed air line on the SAS-EB Traveler today.

**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, E2/E3-EB/WB Maintenance Travelers elevating platforms.

**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,

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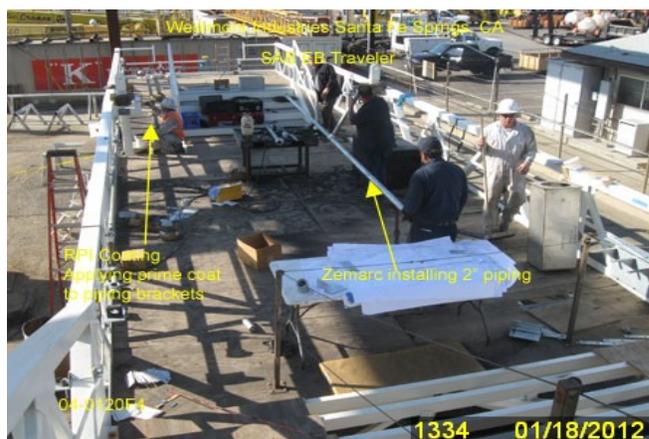
during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This 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.

## 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 Maintenance Travelers. QA Inspector was informed by RPI Coating Mr. Manuel Barraza that RPI will be abrasive blasting piping & swing arm brackets, and console and sump pump supports on the SAS/E2-E3 Maintenance Travelers today. RPI completed blasting and prime application of the above. Mr. Barraza informed this QA that RPI would be using a new batch of the Sherwin Williams Zinc Clad II Plus. QA stated that samples will need to be taken from the new batch. QA Inspector also, informed to Mr. Barraza that RPI will be proceeding at their own risk pending acceptance of the sample test results. Mr. Barraza stated that he is aware the RPI is proceeding at their own risk. After blasting was completed, QA Inspector then observed Mr. Barraza performing random surface profile checks on the blasted base metal surfaces. This QA Inspector observed Mr. Barraza utilizing a Testex Press-O-Film and a micrometer to perform the testing. During observation, this QA Inspector observed that the readings appeared to be 3.7 mils, 3.0 mils, and 3.4 mils. QA Inspector then observed Mr. Barraza perform a test for soluble salts on the previously blasted base metal surface. Testing observed by QA Inspector appears to be in compliance with the contract requirements.

QA Inspector sampled part A, part B, and part F, of Sherwin Williams Zinc Clad II Plus, Inorganic Zinc-Rich Coating representing 1 kit. QA Inspector assigned Caltrans Lot #B208-009-12 and TL-101 # 712431.

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.

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<b>Inspected By:</b>	Brannon, Sherri	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill	QA Reviewer
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