

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-027144**Date Inspected:** 03-Feb-2012**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Westmont Industries**OSM Arrival Time:** 500**OSM Departure Time:** 1330**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 Parking Tether Anchor Clamp

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID #3035) performing Flux Core Arc Welding (FCAW) activities on the E2/E3 Parking Tether Anchor Clamp Assemblies. This QA Inspector observed Mr. Lopez tack welding and welding in the 2F horizontal positions on Parking Tether Anchor Clamp Assemblies, randomly throughout the morning shift. Mr. Lopez was also, observed performing Shielded Metal Arc Welding (SMAW) activities on the E2/E3 Parking Tether Anchor Clamp Assemblies. QA Inspected noted that WMI has submitted an addendum to their Welding Quality Control Plan (WQCP) Section S, Prequalified Welding Procedure Specification to American Bridge/Fluor Enterprises for approval. Mr. Lopez has been verbally approved by METS representative Mr. Robert Mertz to perform SMAW welding. Also, METS representative Mr. Robert Mertz has reviewed and given verbal approval on WMI, Welding Quality Control Plan (WQCP) addendum to Section S, Prequalified Welding Procedure Specification prequalified SMAW fillet welding procedure (ID#W136). QA Inspector informed SMR Mr. Nicolai Hvass of the above information. Welding completed on this date.

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

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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.

SAS Travelers Supplementary Access Platforms

This QA Inspector made random shop observations and was informed by (WMI) production fitter Mr. Larry Swanson (WID #3058) that welding on the SAS Travelers Supplementary Access Platforms is still on hold pending RFI request to change the fit at hinge location.

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



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.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
