

**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-027249**Date Inspected:** 27-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**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).

**Modified Brake Mounts Traveler Trolley Train Links (CCO232)**

This QA Inspector made random shop observations and observed WMI personnel prepping 46 brake mount brackets by beveling (10mm x 10mm prep 45 degree bevel) and (6mm x 6mm prep 45 degree bevel) on the ASTM A572 Grade 50 angle 8" x 8" x 7/8" x 1-3-1/4" angle material brake mount brackets for trolley link suspension plate 2A, 2B 3A & 3B in process.

**Modified Brake Mounts Traveler Trolley Train Links (CCO232)**

This QA Inspector randomly observed Westmont Industries (WMI) production fitter, Mr. Richard Fuentes (WID #3201), and observed fitting and tack welding activities on material, for the modified brake mounts links plates. Mr. Fuentes was observed tack welding using approved Flux Cored Arc Welding (FCAW) process, welding in all positions.

**Modified Brake Mounts Traveler Trolley Train Links (CCO232)**

This QA Inspector randomly observed WMI production welder Mr. Juan Lopez (WID # 3126) performing welding activities on material ASTM A572 Grade 50 angle 8" x 8" x 7/8" x 1-3-1/4" angle material joining angle plates to link suspension plates 2A in the afternoon. Mr. Lopez was observed welding using approved Flux Cored Arc Welding (FCAW) process, welding fillet and groove welds in all positions.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

## 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 WMI in deciding whether to modify Assembly 5 – A272F 1 & 2 per approved sketch SK-2735R)-01 or scrap and remake the above mentioned assembly. Reference documents ABF-RFI-002735R0, sketch – SK2735R0-01 and CCO 183.

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 /SAS-EB Travelers

This QA Inspector performed random shop observations and observed that WMI personnel installing various components on the E2/E3-EB & WB /SAS-EB Travelers on this date.

## Maintenance Travelers

This QA Inspector performed random shop observations and observed that Zemarc Corporation is on site at WMI on this date.

This QA Inspector received and performed informal review of WMI Weekly Weld Reports WWRs, prior to WMI formally submitting to Caltrans for review. This QA reviewed WWRs for December 27, 2011 through January 1, 2012, and January 2, 2012 through January 8, 2012. No corrections needed prior to submittal.

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



---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

**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.

---

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

---