

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027265**Date Inspected:** 01-Mar-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		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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's Mr. Juan Lopez (WID # 3126), Mr. Arturo Montes (WID # 3151) 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, 2B, 3A, & 3B. Mr. Lopez and Mr. Montes was observed welding using approved Flux Cored Arc Welding (FCAW) process, welding fillet and

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groove welds in all positions through the day.

SAS Travelers Supplementary Access Platforms

This QA Inspector randomly observed Westmont Industries (WMI) production fitter, Mr. Swanson (WID# 3058) continuing fitting and tack welding activities on the Supplementary Access Platform Assembly 5 – A272F 1 & 2 Riser Panel C. Mr. Swanson was observed tack welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F position. 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 today. Zemarc personnel informed this QA Inspector that Zemarc will continue installing various sizes of compressed air lines and console frames on the SAS-EB, E2/E3-EB, E2/E3 WB Maintenance Travelers today.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI arrive on site at approximately 1100 hour, here at WMI to start touch up painting on the Bike Path traveler components. QA Inspector was informed by RPI Coating Mr. Preston Keen that RPI will performing touchup coating on the Bike Path Traveler and setting up WMI paint booth in bay 6 to start abrasive blasting on Monday March 5th today.

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 January 9, 2012 through January 15, 2012, WWRs for January 16, 2012 through January 22, 2012, and January 30, 2012 through February 5, 2012. No corrections needed prior to submittal.

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.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer