

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 #: 1.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029050
Date Inspected: 28-Jan-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530

Location: USA Hoist, Crest Hill, IL

CWI Name:	Robert Zimny	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:	SAS Tower Elevator	

Summary of Items Observed:

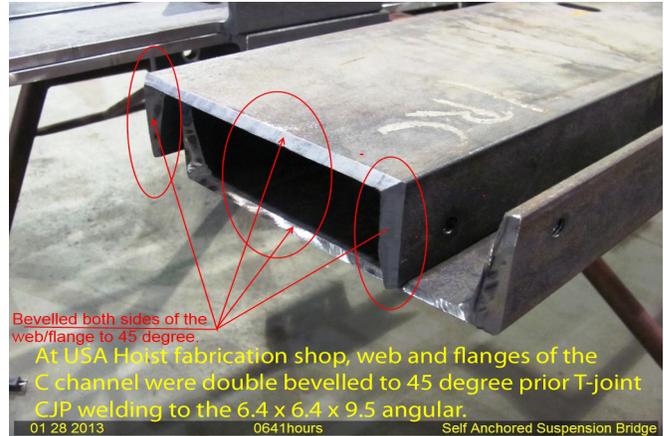
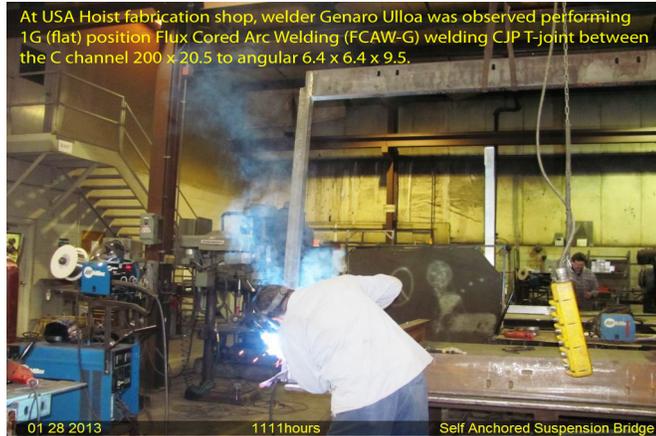
Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at USA Hoist, Crest Hill, IL as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At USA Hoist assembly shop, this QA randomly observed USA certified welder Genaro Ulloa perform 1G (flat) position gas shielded Flux Cored Arc Welding (FCAW-G) welding Complete Joint Penetration (CJP) T-joint between C-channels C200 x 20.5/C180 x 18.2 x 2106mm long part numbers 914930/914911 and angular 6.4 x 6.4 x 9.5 x 1800mm long part number 914900-02. Mr. Genaro Ulloa took over from welder Matt Wasiqi who went on leave for two days. Mr. Matt Wasiqi is expected to be backed Wednesday, January 30, 2013. The C200 x 20.5 channel is being welded on the left side of the 6.4 x 6.4 angular while the C180 x 18.2 channel is being welded on the right side. These channels to angle connections are intended for door enclosure frame for elevator stops at 1 (elevation 15 meter), stop 4 (elevation 127.85 meter) and stop 5 (elevation 139.85 meter). These three enclosure frames have the same shape and materials used in elevator stops 2, 3 and 6. The only difference noted was in length of the two C channels wherein the measurement was 2106mm long.

The welder was noted using gas shielded FCAW-G with 1.1mm E71T-1C Familiarc DW-50 wire electrode implementing USA Hoist Welding Procedure Specification FCAW 2916. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 35 CFH. During the shift, the working welding parameters was measured 28 volts and 225 amperes which deemed in compliance to the project requirements. At the end of the shift, one (1) of the three (3) identical frames for the three stops was completed and one was still in progress.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

There is no significant conversation occurred today.

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 SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer