

**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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029052**Date Inspected:** 30-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** USA Hoist, Crest Hill, IL

<b>CWI Name:</b>	Robert Zimny		
<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
<b>Weld Procedures Followed:</b>	Yes	No
<b>Verified Joint Fit-up:</b>	Yes	No
<b>Approved WPS:</b>	Yes	No
<b>Delayed / Cancelled:</b>	Yes	No

**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.

Today at USA Hoist fabrication shop, this QA met with Mr. Robert Zimny the Quality Control Inspector. Mr. Zimny was noted performing after the fact visual test (VT) on welded CJP T-joints between the C channels C200 x 20.5/C180 x 18.2 to angular 6.4 x 6.4 x 9.5 intended for elevator door enclosure frames stops 1 thru 6. But prior to the VT of the welded T-joints by Mr. Zimny, USA Hoist welder Matt Wasiqi performed flush grinding on one side of the joint then wire brushed the other side to all six door enclosure frames. Mr. Wasiqi flush ground one door enclosure frame at a time and let QAI Robert Zimny perform the VT of the joints as he finishes grinding. QAI Robert Zimny occasionally requested this QA to perform the VT verification on welded joints after finishing his VT. This was done to all six door enclosure frames. During the shift, QAI Robert Zimny also randomly performed Penetrant Testing (PT) on the flush ground surface of the welded joints which he found them acceptable. This QA found all six door enclosure frames for stops 1 thru 6 deemed visually acceptable to the requirements of the project.

At USA Hoist fabrication shop, Mr. Genaro Ulloa was noted cutting to size formed channel 3/16" x 3 5/8" x 4". Mr. Genaro Ulloa was noted using the Marvel Vertical Band Saw in cutting the formed channel to the required length. During the shift, Mr. Ulloa has completed cutting four (4) pieces of formed channel 3/16" x 3 5/8" x 4" x 70 5/8" long with mark part number of 916001 that are intended for side bottom door channel and four pieces of formed channel 3/16" x 3 5/8" x 4" x 38 3/4" long with mark part number of 916005 that are intended for bottom

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# WELDING INSPECTION REPORT

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left side channel of the elevator cab frame.

At the same shop, Mr. Matt Wasiqi was also noted cutting to size channel C4 x 5.4. Mr. Wasiqi was noted using the Marvel Vertical Band Saw in cutting the channel to the required length. During the shift, Mr. Wasiqi has completed cutting two (2) pieces of channel C4 x 5.4 x 54 1/2" long with mark part number 916006 that are intended for top and bottom channel and one (1) piece of channel C4 x 5.4 x 22 5/16" long with mark part number 916023 that is intended for top panel side angle brace of the elevator cab frame.

This QA received mill certification from Tim Moran of USA Hoist. After a review of the material and the supporting documentation the QA Inspector signed the mill certification report for the following material: Two pieces C channel 4 x 5.4 ASTM A36/A36M-08, from Nucor Corporation with heat #DL-12105738. After reviewing this provided documentation, this QA performed random visual identification of this material listed above to ensure it was acceptable for use. This QA observed the heat number on the MTR appeared to match the heat number tagged to the material. This QA observed the documentation and visual verification of the material appeared to be in general compliance with the approved project drawings listed material for the Cab Frame. This QA signed on the MTR "OK-TO-CUT" and assigned a Caltrans lot number B231-001-13 for tracking purposes. Material was properly staged inside the shop facility and heat number was transferred to the individual pieces using a marker.



### 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.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

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**Reviewed By:** Foerder, Mike

QA Reviewer