

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-029055
Date Inspected: 31-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 fabrication shop, Mr. Genaro Ulloa was noted cutting C channel and formed channel for the elevator cab frame. Mr. Genaro Ulloa was noted using the Marvel Vertical Band Saw in cutting the various channels to the required length and then put the notches where they are required. The following items with mark part number of pieces and corresponding descriptions were cut and put the notches during the shift;

1. 916057 2 pieces channel C4 x 5.4 x 7 11/16" bottom center right channel
2. 916001 1 piece formed channel 3/16" x 3 5/8" x 4 x 70 5/8" side bottom door channel
3. 916002 1 piece formed channel 3/16" x 3 5/8" x 4 x 70 5/8" top side channel
4. 916004 1 piece formed channel 3/16" x 3 5/8" x 4 x 38 3/4" bottom right side channel
5. 916005 1 piece formed channel 3/16" x 3 5/8" x 4 x 38 3/4" bottom left side channel
6. 916015 1 piece formed channel 3/16" x 3 5/8" x 4 x 70 5/8" top door side channel
7. 916016 1 piece formed channel 3/16" x 3 5/8" x 4 x 38 5/8" top left side channel
8. 916017 1 piece formed channel 3/16" x 3 5/8" x 4 x 38 5/8" top right side channel
9. 916018 1 piece formed channel 3/16" x 3 5/8" x 4 x 70 5/8" top side panel channel

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 and then put the notches where they are

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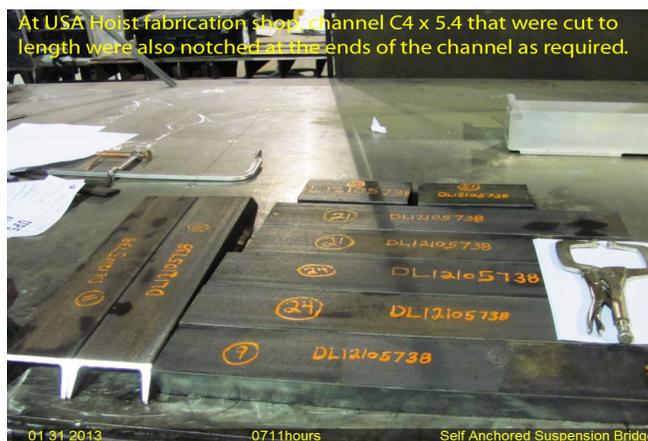
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required. The following items with mark part number of pieces and corresponding descriptions were cut and put the notches during the shift;

1. 916058 2 pieces channel C4 x 5.4 x 7 11/16" bottom center left channel
2. 916026 2 pieces channel C4 x 5.4 x 24 11/16" top door side angle brace
3. 916009 1 piece channel C4 x 5.4 x 21 31/32" bottom panel side left ch.
4. 916011 2 pieces channel C4 x 5.4 x 23 11/16" bottom door side center
5. 916012 2 pieces channel C4 x 5.4 x 23 9/16" bottom panel side center
6. 916010 1 piece channel C4 x 5.4 x 21 31/32" bottom panel right center
7. 916007 1 piece channel C4 x 5.4 x 20 19/32" bottom door side right
8. 916008 1 piece channel C4 x 5.4 x 20 19/32" bottom door side left
9. 916009 1 piece channel C4 x 5.4 x 21 31/32" bottom panel side left ch.
10. 916006 2 pieces channel C4 x 5.4 x 54 1/2" top and bottom mid

Above mentioned elevator cab frame part members were cut and notched as required during the shift. According to Mr. Genaro Ulloa, there are still many part members to be cut and that he is waiting for the shop drawing from Mr. Bob Overbeek USA Hoist Engineer.

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 reports for the following material: Two pieces C channel 4 x 5.4 ASTM A36/A36M-08, from Nucor Corporation with heat #DL-12105737. 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 B231-002-13 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.

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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
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Reviewed By:	Foerder, Mike	QA Reviewer
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