

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029099**Date Inspected:** 08-Feb-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL

CWI Name:	Robert Zimny		
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:** 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.

After the welding completion of the stiffener plates and holding brackets for the door lock on all six (6) elevator door stops 1 thru 6, USA Hoist welder Manolo Luna started perform drilling on six (6) 5" long x 1 1/4" wide x 1/2" plates intended for door latch adjustment plate for all 6 elevator door locks. The welder was noted drilling two (2) 3/16" diameter bolt holes on the plates then tapped them with 1/4"-20 UNC. After the completion of 1/4" tapping on all six (6) adjustment plates, the welder has drilled two slotted holes on the same six plates. The welder was seen drilling two 5/16" x 1" slotted holes and two tapped bolt holes on each adjustment plates following USA Hoist shop drawing 914910-05. During the shift, two tapped bolt holes and two slotted holes were drilled on all six door latch adjustment plates intended for the six elevator door locks have been completed.

At USA Hoist fabrication shop, welding foreman Genaro Ulloa was noted erecting the temporary frame for the trial fit up of six (6) elevator door stops enclosure frame assembly before sending them for hot dipped galvanizing. During the conversation with the foreman, he mentioned that USA Hoist wants to make sure that the assembly will fit correct accordingly and the installed camber will be noted. The welder has tack welded one beam on left and right sides of the work table then bolted the hinged frame and fixed frame to the beams. This procedure was done during the shift but was not able to trial fit the whole assembly due to limited time. Mr. Genaro informed this QA that they will continue on Monday.

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Summary of Conversations:

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