

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-029146**Date Inspected:** 12-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.

At USA Hoist fabrication shop, welding foreman Genaro Ulloa together with another welder Matt Wasaqi were noted bolting and trial fitting the elevator door assembly for stops 1, 4 and 5. After bolting the enclosure frame to the temporary beam, another welder Manolo Luna performed the tack welding of the three (3) weld-on hinge to the enclosure frame. The welder was noted using the gas shielded Flux Cored Arc Welding (FCAW-G) during the tack welding. After tack welding the three weld-on hinges, Mr. Genaro took the measurements from the tack welded hinges and transferred them to the door frame. Welder Manolo Luna tack welded the other pairs of the hinge to the door frame. After the completion of the tack welding on the three pairs of hinges to the door enclosure and door frame, Mr. Genaro Ulloa started to put the assembly together and adjusted the position of the door frame/enclosure where required until they were satisfied with the clearances on all sides of the door.

After the completion of the trial fit up of the first elevator door assembly mentioned above, Mr. Genaro Ulloa called Mr. Bob Overbeek and showed him the position or condition of the trial fit. Mr. Overbeek was noted using an 18" long Starrett Precision Machinist level to check the alignment of the door assembly. USA Hoist personnel made some more small adjustment here and there until Mr. Overbeek was satisfied that the trial fit assembly deemed acceptable.

The trial fit of the first elevator door assembly was completed and looked good. Mr. Genaro Ulloa informed this

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QA that they will leave the tack weld on the three pairs of weld-on hinge as it is for now. USA Hoist will weld them fully after the completion of trial fit on all six (6) door assemblies.



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
