

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029149**Date Inspected:** 15-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
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	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.

At USA Hoist fabrication shop, welding foreman Genaro Ulloa together with another welder Matt Wasaqi were noted trial fitting the Norton Parallel Rigid Arm Door Closer door assembly for elevator door stops 1, 4 and 5. Since the second door assembly for door stops 1, 4 & 5 was completed, USA Hoist personnel did not disassemble the door assembly but instead worked on the same assembly and located the appropriate location for the door closer. The personnel were noted trial fitting the door closer on many locations before they finally found one. According to Mr. Genaro Ulloa, he will show this tentative location of the door closer to Mr. Bob Overbeek and then if he is satisfied he will take the measurements and make a template for all six (6) elevator door closer. Mr. Bob Overbeek was not able to check the trial fit up of the door closer today.

While waiting for Mr. Bob Overbeek, USA Hoist welder Matt Wasaqi performed tack welding of the three (3) 120mm long mild steel weld-on hinge on the third door assembly for elevator door stops 1, 4 & 5. 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. The shift was completed after transferring the hinge measurements.

WELDING INSPECTION REPORT

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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