

**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-029150**Date Inspected:** 19-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

<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.

At USA Hoist fabrication shop, welding foreman Genaro Ulloa together with another welder Matt Wasaqi were noted continuing trial fitting the first door assembly for elevator door stops 2, 3 and 6. Prior to the trial fit assembly, welder Matt Wasaqi was noted tack welding the three 120mm long mild steel weld-on hinge. The welder was noted using the gas shielded Flux Cored Arc Welding (FCAW-G) with 1.1mm diameter E71T-1C Familiarc DW-50 wire electrode. After bolting the enclosure frame to the temporary beam and 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. USA Hoist personnel were noted tack welding the three (3) 120mm long mild steel weld-on hinge per shop drawing number 914933. The first door assembly was completed and Mr. Genaro Ulloa started installing the Norton Parallel Rigid Arm Door Closer.

With the template they made when they installed the first door closer on door stops 1, 4 and 5, Mr. Genaro Ulloa and Matt Wasaqi used the same template and installed the first door closer on elevator door stops 2, 3 and 6. The door closer on these first elevator door stops 2, 3 and 6 was completed but there was one issue that followed and that the door closer does not close all the way. According to Mr. Genaro Ulloa, the tension of the door closer has already adjusted to maximum but still the door does not close all the way. The three (3) doors for the elevator door stops 2, 3 and 6 are heavier than the elevator door 1, 4 and 5 due to their longer lengths. Due to this issue, Mr.

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## WELDING INSPECTION REPORT

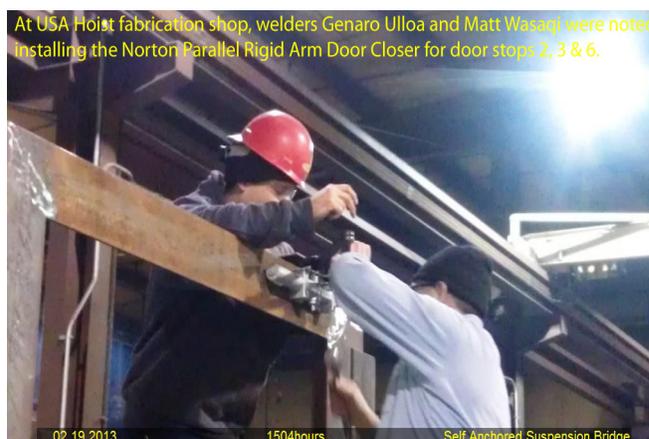
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Genaro Ulloa called USA Hoist Engineer Bob Overbeek to look the issue at hand. After looking at the door closer, Mr. Overbeek informed this QA that he will study the door closer issue and then come up with possible solution.

Still at USA Hoist fabrication shop, another welder Manolo Luna was noted assembling the top platform for the elevator cab. The welder was noted putting together various formed and standard channels that were previously cut to size and notched according to the shop drawing. Although the top platform was noted assembled, there was no welding performed due to welding shop drawing was not yet released to the floor.



### 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.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

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**Reviewed By:** Foerder, Mike

QA Reviewer