DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029152
Date Inspected: 21-Feb-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: USA Hoist

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:

Quality Assurance Inspector (QAI) Fritz Belford was at the USA Hoist shop in Crest Hill, Illinois between the times noted above in order to monitor Quality Control functions and the in process work being performed by USA Hoist personnel. The following items were observed:

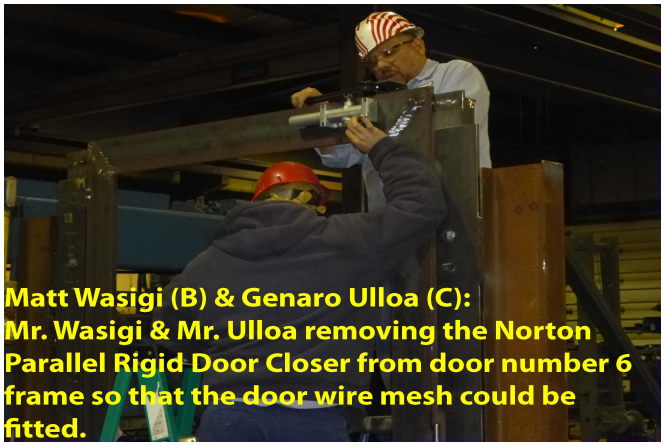
Manolo Luna (B):
Welder Luna was observed continuing with the machine cutting of 6” x 6”x .375” tubular steel (Heat#0168580) for the elevator tower. At the end of the shift approximately 24 tubes had been cut to length using the Marvel band saw. Cutting will continue on the following shift.

Matt Wasigi (A):
Matt Wasigi (A):
Welder Wasigi was observed trial fitting the steel wire mesh (.75” x .75” x .135” Wire with Plain Steel C-Channel Frames: 1” Wide x 16 Ga. with 5/16” – 18 Hex Nuts welded to inside of frame) manufactured by Flynn & Enslow Inc. for door number 2, 5 & 6 by drilling holes for the M8 x 25MM LG, FHCS bolts at locations corresponding to the M8 HEX nuts welded to the door wire mesh frame assembly. Currently Mr. Wasigi is only fitting the wire mesh to the doors using temporary bolts, installation of the wire mesh will be performed after the corrections of bolts & nuts misalignment as noted on a few of the bolt holes. (Ref. Dwg. 914912 & 914926)
Welder Wasigi was also observed performing FCAW-G on doors number 1, 4 & 5 welding the hinges to the door frames utilizing Welding Procedure Specification (WPS) FCAW3210. The welder was noted using 1.1mm E71T-1C Familiarc DW-50 wire electrode in the 1G or flat position. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 35 CFH. The welding parameters measured were 26

volts and 196 amperes are compliance with the WPS noted above.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents



Matt Wasigi (B) & Genaro Ulloa (C):
Mr. Wasigi & Mr. Ulloa removing the Norton Parallel Rigid Door Closer from door number 6 frame so that the door wire mesh could be fitted.

Matt Wasigi (B):
Mr. Wasigi drilling bolts holes for the M8 x 25MM LG, FHCS bolts matching locations of the M8 HEX nuts welded to the door wire mesh frame assembly.

Summary of Conversations:
Conversations this day as required for scope of work.

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 Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer