

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-029243**Date Inspected:** 11-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL

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|------------------------------------|--------------|----|-----|
| 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:**

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 finishing welding the Door Mesh Assembly Tapped Spacers (Part number 914912-05) to the Mesh Assembly 1" x 1" x 16 Gauge U-Band Frame at various locations where the Door Frame Assembly bolt holes and Door Mesh Assembly welded M8 x 22MM LGHEX nuts do not align properly on door mesh 1 thru 6. Welder Luna was observed utilizing Welding Procedure Specification (WPS) FCAW3210 with the 1.1mm E71T-1C Familiarc DW-50 wire electrode in the 2G or Horizontal 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.

WELDING INSPECTION REPORT

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Manolo Luna (B):
Welder Luna positioning the Door Mesh Assembly for welding as per ABF-RFI-003214R00.



Manolo Luna (B):
Welder Luna was observed welding the Door Mesh Assembly Tapped Spacers (Part number 914912-05) to the Mesh Assembly 1" x 1" x 16 Gauge U-Band Frame as per ABF-RFI-003214R00.

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.

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