

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-029343**Date Inspected:** 19-Mar-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:**

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:

Matt Wasigi (A):

The welder was observed assembling and Tack welding the Top Panel Side Cab Frame Weldment as per drawing 91600 Section B-B. Welder was observed measuring the distances and clearances between Part numbers 916015, 916016, 916017 & 916018 ensuring proper fit between members before tack welding. Welder Wasigi was observed utilizing Welding Procedure Specification (WPS) FCAW3129 with the 1.1mm E71T-1C Familiar DW-50 wire electrode in the 1G and 2G positions. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 38 CFH. The welding parameters measured were 26 volts and 190 amperes are compliance with the WPS noted above.

TL-6034: (Lot# B359-005-13)

This QAI verified received materials from Alro Steel Corporation as per CEM-3101. See report form TL-6034 for details.

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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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
