

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-029427
Date Inspected: 22-Apr-2013

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

OSM Arrival Time: 700
OSM Departure Time: 1550
Location: 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 Elevator	

Summary of Items Observed:

Quality Assurance Inspector (QAI) James Kent Smith 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, identification letter "A", Jose Dominquez, Identification letter "C", and Manolo Luna, Identification letter "B":

Qualified Welders "A", "C", and "B" were observed during various intervals during the day welding the following components to the mast sections; using the approved drawing 914202-01-LH. Item #'s 6,7,8,9 and 10 are the components that make up the bolting tube connections of the mast sections. "A", "C", and "B" were all observed by this QAI to be using the Welding Procedure Specification (WPS) FCAW3210 with the 1.1mm E71T-1C Familiarc DW-50 wire electrode in the 2F position as weldment is being positioned for this position of welding as needed during final welding operations. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 38 CFH. The welding parameters were measured by this QAI using a Fluke clamp on meter, and were found to be 26 volts and 190 amperes which are in compliance with the WPS noted above. Following the completion of each weld(s) made by "A", "C" and "B", this QAI observed them to be checking the finished weld sizes using a weld file gage to ensure the 1/4" file weld size required by the approved drawings was being maintained. All completed welds were visually inspected by Robert Zimny, (QC) as observed by this QAI, with weld sizes being gauged at various locations along the weldments.

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The completed and accepted work observed at this location appeared to be in compliance with the contract specifications. Unless otherwise noted, work observed on this date appeared to generally comply with special provisions and applicable contract documents.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and USA Hoist Management and Quality Control personnel.

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:	Smith, James	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
