

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-029563**Date Inspected:** 03-May-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:** See below**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:** Elevator Cab frame assembly**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the Fabricator's shop and observed the work and the inspection performed by USA Hoist personnel. The inspection was performed on the Elevator Cab frame assembly and on the Elevator Tower Poles. The welding was performed utilizing Flux-Cored Arc Welding with shielding gas process (FCAW-G) as per the approved Welding Procedure Specifications (WPS's).

At the start of the shift this QAI observed the following:

No Quality Control (QC) inspector was present this day.

This QAI witnessed the welding of the Elevator Cab frame assembly at the areas found deficient or lacking of welds as per the TL-6031 Daily Welding report dated 5-2-2013. The welding was performed by Manolo Luna #B as per the prequalified WPS FCAW-3210 and WPS FCAW-3139 using the gas-shielded Flux Cored Arc Welding (FCAW-G) process. The electrode utilized was E71T-1 Kobe Familiarc .045 diameter flux-cored wire as per AWS A5.20 and allowed per the AWS D1.1 Structural Welding Code. The shielding gas utilized was a 75% Argon/25% CO2 mix and was delivered at a flow rate of 35 Cubic Feet per Hour (CFH) as per both WPS FCAW-3210 and WPS FCAW-3139.

This QAI observed the fit-up/tacking and welding in-progress of the sheetmetal skin strips (2 total) item #3 to outer-face side of the composite boxed-shape member formed from bent-plate channel members #27 and #58 assembled in a toe-to-toe configuration. These areas of welding were not completed this day, with approximately 75% having been performed. The WPS FCAW-3139 was utilized for this welding.

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This QAI observed the welding performed and completed of the top of plates #13 (2 total) to C4x5.4 channels #25, #51, and #2 (2 total). This QAI also witnessed the welding performed and completed of the bottom side of plates #13 (2 total) to C4x5.4 channels #2 (2 total). This QAI monitored the parameters of the welding performed, verifying adherence to the approved WPS. The welding was observed and verified by this QAI and appeared to be in compliance with the contract documents.



Summary of Conversations:

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.

Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer