

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-029736**Date Inspected:** 24-Jun-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:** 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	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at USA Hoist, Crest Hill, IL as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

Today at the USA Hoist fabrication shop, this QA randomly observed USA Hoist Quality Control (QC) Inspector Robert Zimny perform visual inspection on completely fillet welded front tie-in bracket. These brackets were previously welded per USA Hoist shop drawing #914204-14. During the QC inspection, MR. Robert Zimny was noted performing 100% visual inspection on the 1/4" fillet weld on all sides of the 13 1/4" long x 5 1/2" wide x 3/8" thick stiffener plate to the 14" long x 6" wide x 1/2" thick bent plate front tie-in bracket as well as measuring the required fillet size. The QC inspection was completed on 108 brackets out of 142 brackets required. After the inspection, QC has informed this QA that he found the brackets in conformance to the project requirements. According to Mr. Robert Zimny, he will continue to do the inspection on the rest of the brackets tomorrow. During the shift while QC was performing the inspection, this QA also performed random visual and size verification on the fillet weld of brackets mentioned above. The result of the QA verification was deemed in compliance to the project requirements.

At USA Hoist assembly shop, qualified welder Matt Wasiqi was observed continuing to perform fillet welding the tower tie-in brackets for the tower elevator per USA Hoist shop drawing #914204-17. The welder was noted using the gas shielded Flux Cored Arc Welding (FCAW-G) with 1.1mm E71T-1C Familiarc DW-50 wire electrode and implementing welding procedure specification FCAW 3210. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 38 CFH. During the shift, the working welding

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

parameters were measured 29 volts and 235 amperes which deemed in compliance to the project requirements. This QA randomly checked the workmanship and measured the required ¼” fillet on all sides of the stiffener which was found in compliance to the requirement.

Another USA Hoist qualified welder Andres Luna was observed continuing to perform fillet welding the same tower tie-in brackets for the tower elevator as mentioned above. The welder was noted using the same process and implementing the same welding procedure specification. The welder was noted using gas shielded FCAW-G with 1.1mm E71T-1C Familiarc DW-50 wire electrode implementing USA Hoist Welding Procedure Specification FCAW 3210. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 40 CFH. During the shift, the working welding parameters were measured 27 volts and 200 amperes which deemed in compliance to the project requirements. This QA randomly checked the workmanship and measured the required ¼” fillet on all sides of the stiffener which it was found in compliance to the requirement. With the two welders welding side by side on the tower tie-in brackets, approximately 90 pieces of this type of bracket were completed as of to date.



Summary of Conversations:

No significant conversation occurred today.

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: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer