

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029843**Date Inspected:** 09-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** USA Hoist**Location:** Crest Hill, IL.**CWI Name:** None present**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:** Tower Elevator items**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) arrived at the USA Hoist production facility for the purpose of performing inspections of Tower Elevator items to the requirements CC0-085, Standard Specification and Special Provisions. The turnover report to this QAI from previous QAI Joselito Lizardo was reviewed to determine the status of items currently on-hand and in-progress.

Welding is in-progress, but not completed, of Right-Hand and Left-Hand Bearing & Roller Mounting assemblies shown on Drawings #914233-20 and 914232-20, respectively. The welding was performed by Manola Lunas #B utilizing E71T-1 .045" diameter FCAW-G electrode as per AWS A5.20 and the approved WPS# FCAW3210. The shielding gas used was mix of Argon@75%/CO2@25% with a flow rate of 37CFH. No QC was present this day. The welds that have been so far performed of these members exhibit a very good appearance.

This QAI left USA at 1300 to travel to Shopwerks Abrasive Blasting & Coatings to inspect painting of the Elevator Cab frame.

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Summary of Conversations:

This QAI spoke with Project Manager Tim Moran regarding the corner indications of 1R bends of Tower Elevator Tie-In Brackets. Mr Moran mentioned that SMR Tim Truong had suggested the possibility that further inspection by Magnetic Particle Testing may be indicated.

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: Morris, Monty

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer