

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029844**Date Inspected:** 10-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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.

No CWI/Welding QC was present this day.

Welding continued of Left-Handed Bearing & Roller Mounting Plates of Drawing# 914232, with both of these assemblies being completed this day. Pre-weld fit-ups of the Right-Handed assemblies was completed this day. 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 38CFH. The welds performed of these completed members appear to meet the requirements of the contract documents.

Welding also was in-progress of Tower Mast Poles of Segments #14, 15, 16, 17. The welding was performed by Andres Luna, #1233, utilizing Kobe Steel 'Familiarc' E71T-1 .045" diameter FCAW-G wire as per AWS A5.20 and the approved WPS# FCAW3210. The shielding gas used was a mix of Argon@75%/CO2@25% with a flow rate of 36CFH. No

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Summary of Conversations:

Tim Moran had mentioned that re-galvanized sample Elevator Landing angle had already been performed by MW Galvanizing and that it would shipped back to USA Hoist the following day for viewing and inspection.



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