

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-029846
Date Inspected: 12-Jul-2013

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

OSM Arrival Time: 730
OSM Departure Time: 1600
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:	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.

Welding QC Robert Zimny was present this day, inspecting completed welds of members. Inspector's reports have not been received from USA Hoist by end of day.

The fit-up/tacking was performed of 1/2" longitudinal stiffeners and of 3/8" radial gusset stiffeners for the Safety Mounting Plate per drawing 916250-11. The welding is in-progress and being performed by Manola Lunas #B utilizing Kobe Steel brand 'Familiarc' E71T-1 .045" diameter FCAW-G electrode 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 38CFH. The DC amperage measured 205A, and the DC voltage was measured at +26V. The welds performed of these completed members appear to meet the requirements of the contract documents.

Saw-cutting is in progress of material previously identified and issued an 'OK-to-Cut' by the prior QA inspector for items shown on Drawings# 916232-24, 916232-22, and Safety Mounting weldment with Buffer Strike Plate.

Of the above-mentioned cut members, the following items were fit-up and welded complete:

End Caps to PcMk# 7 of Drawing# 926232-10 (4 pieces),
End Caps to PcMk# 14 of Drawing# 916232-24 (2 pieces),
Through-Pipes to PcMk# 14 of Drawing# 916232-24 (2 pieces).

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The welding of these 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 mix of Argon@75%/CO2@25% with a flow rate of 36CFH. The DC amperage measured 230A and the DC voltage measured +27. These completed welds appear to meet the requirements of the contract documents.



Summary of Conversations:

This QAI inquired to Tim Moran as whether American Bridge/Fluor had received a directive as to how proceed with the Tower Elevator Tie-in Brackets. He expressed that he had not yet heard back from them on that regard.

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