

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-029852
Date Inspected: 18-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:	None present this day	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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No	N/A
		Component:	Tower Elevator Components		

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.

This QAI observed the welding of the Bottom Outer Safety Mounting frame utilizing as a reference Drawing# 916240-03. The welding was performed by Manola Lunas #B utilizing Kobe Steel brand 'Familiarc' E71T-1M .045" diameter FCAW-G electrode as per the Welding Procedure Specification (WPS) FCAW3210. The shielding gas used was a mix of 75% Argon and 25% CO2 with a flow rate of 38CFH. The welding was completed during this shift and appeared to meet the requirements of the contract documents.

This QAI also observed the welding of the Top Drive Outer Support Tubes (Left and Right Handed). The welding of the support tubes was performed by the welder, Andres Luna #1233, utilizing Kobe Steel 'Familiarc' E71T-1 .045" diameter FCAW-G wire as per the WPS identified as FCAW3210. The shielding gas used was mix of 75% Argon and 25% CO2 with a flow rate of 36CFH. The DC amperage measured 230 amps and the DC voltage measured 27 volts. The welding was completed during this shift and appeared to meet the requirements of the contract documents. The work was performed on this date as referenced on drawing 916232-10.

Other work that this QAI observed today was: 1) Fit and bonding of rubber seal/cushions to Elevator Cab frame between it's surface and the window frame inserts. 2) Press-fitting of alignment bushings into counterbored ends Tower Elevator Masts continued.

WELDING INSPECTION REPORT

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Summary of Conversations:

This QAI was introduced by USA Hoist Project Manager Tim Moran to his high-strength bolting representative from supplier 'Fastenal' and discussed upcoming sampling of same.

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