

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-029867**Date Inspected:** 30-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist, Crest Hill, IL.**Location:** USA Hoist, 1000 Sak Drive

CWI Name:	None present		
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:** Tower Elevator guide masts & tie-in attachments**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) travelled this day to USA Hoist, 1000 Sak Drive, Crest Hill, IL. for the purpose of performing in-process inspections of Tower Elevator related fabricated members to the requirements of the contract documents.

Upon arrival to USA Hoist, this QAI proceeded to fabrication area of their facility to observe the operations to be performed that day.

This QAI observed the continuation of the welding being performed per USA Hoist Engineer, Robert Overbeek, directive to increase the weld sizes of the Tower Elevator guide masts. These weld areas are those of joints of members #1 and #10 where their curved sections form a flare-bevel groove type intersection with their adjacent members. This QAI had previously reported that the welds were undersized with regard to the weld symbols as provided on the drawings, which are not approved as of this date. Mr. Overbeek and Tim Moran were also previously informed by this QAI of the discrepancy at the time of it's discovery, so it could be addressed towards a resolution.

The welder performing the rework repair welding was Matt Wasiqi, ID# "A", utilizing .045" diameter FCAW-G wire as per AWS D1.1 and the Welding Procedure Specification (WPS) identified as FCAW3139. There was no Quality Control (QC) Inspector present on this date. This QAI performed monitoring of in-process welding, verifying adherence to the WPS parameters. This work is in progress so far, with no members being fully completed this day. This QAI performed an orientation turn over to QAI Fritz Belford to provide QA coverage of the project after his departure this day.

WELDING INSPECTION REPORT

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USA Hoist Engineer Mr. Robert Overbeek this day had relayed that the condition of the Tower Elevator Cab as received back from AZZ Galvanizing was unacceptable to him. Specifically, he did not approve of the appearance of the exterior sheet steel sides of the cab. The sheet steel was visibly bowed/arc'd between the areas where design tack welds attach them to the Cab frame due to the heat introduced by the galvanizing process. Photos were taken by QAI Fritz Belford and attached to his report.

Summary of Conversations:

Please refer to 'Items Observed' section above for conversation this day.

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:	Morris, Monty	Quality Assurance Inspector
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Reviewed By:	Foerder, Mike	QA Reviewer
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