

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029895**Date Inspected:** 01-Aug-2013**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** USA Hoist Co.**OSM Arrival Time:** 700**OSM Departure Time:** 1530**Location:** Crest Hill, IL.**CWI Name:** Not 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:** SAS Tower Elevator**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI), Lonnie Whitehead, arrived at USA Hoist facility, as requested, to perform random observations of the welding of the SAS Tower elevator components and generally observe the quality control functions.

On this shift, QAI observed USA Hoist certified welder, Genaro Ulloa (D) performing fit-up and tack welding of sub-assembly components for the Safety Mounting Weldment with Buffer Plate. Mr. Ulloa was performing tack welds utilizing approved Welding Procedure Specification (WPS) #FCAW3210 with Kobe Steel Ltd. .045" (1.1mm) wire designated as AWS 5.20, E71T-1C/M-H8. Shielding gas in use is 75% Argon-25% CO2. The welding parameters were viewed at 26 Volts, 190 Amps and were verified to be within WPS tolerances.

Work observed on this day appear to generally comply with contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

Conversations only as pertaining to the work on this shift.

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 (909) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Whitehead,Lonnie	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer
