

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 #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006136**Date Inspected:** 02-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK**CWI Name:** Fredrick M. Hawksworth**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:** Cable band**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Randall Riegler was present during the times noted above for observations relative to the work being performed.

Witnessed weld repair in progress on casting B3-1-M(1). The welder T. Knall No. 261 was observed making the weld. WPS04-0120F4B was used for this weld and the welder has a copy. The weld was being made in the flat position. Preheat was applied and verified by the welder with a 170 degree C temperature measuring crayon. Maximum interpass temperature was also verified and monitored with a 399 degree C temperature measuring crayon. The weld rod used is E7018 4mm batch no. 2071023F. The material test records for the welding rod were verified for conformance with the WPS and are acceptable. The welding rod is stored in cabinet no. 2 at 150 degrees C. The allowable range for amperage from the WPS is 100 to 180 A. The amperage observed was generally 150. The welding power supply used was serial number TA06056672. The ammeter was calibrated 11-6-08 and is on an annual calibration schedule. The calibration records were reviewed and are current. The welder performance qualification records were reviewed. The welder is qualified to make this weld and the continuity records are current.

Reviewed the film and technique for 5540-B14-SBT (1). The technique does not assure 100% coverage at Band A 6-7, and 7-8, and Band B 6-7, and 7-8. In addition location A10-11 and B1-2 do not meet density requirements and will be reshot.

Reshots on B6-1-M(1), and B6-1-F(1) were completed. Radiography of these castings is complete.

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The tensile testing machine was repaired. The problem was a broken wire in the cable to the extensometer.

Summary of Conversations:

No relevant conversations.

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 Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riegler,Randy	Quality Assurance Inspector
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Reviewed By:	Lanz,Joe	QA Reviewer
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