

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-006410**Date Inspected:** 28-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK**CWI Name:** n/a**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.

There was a power outage from about 0730 to about 1030 with no work being performed.

Observed Adam Migas welding temporary attachments to casting B14-CBB. The attachments are in area that would not normally be machined. These attachments are not described in the approved repair plan. This was discussed with Jason Cross, Quality Assurance Manager for action.

Completed final review of the document package for Casting B6-1-M (1) G29426 prior to being shipped to Goodwin International for final machining. Goodwin reviewed the tensile test results using ASTM E29 rounding as allowed by ASTM E148. The original test was failed due to a low ultimate tensile strength on 26 January, 2009. The actual test result was 547.9 MPa. After rounding in accordance with ASTM E29, the result is 550 MPa which meets the requirement of ASTM E148 Grade 550-345. Review of the document package is complete and it is acceptable.

Witnessed tensile testing of Casting B1-1-M(1) G29416. This tensile test was completed following re-heat treatment using water quench. Results comply with project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Jason Cross QAM reported that Casting B1-1-F(2) G29417 has been welded in areas not addressed in the weld repair plan. These areas had been identified as being machined out at final machining. The casting was being repaired using WPS04-0120F4B, that is used for major repairs. This casing will be post weld heat treated. An internal Goodwin NCR GSC 00056 was generated to address this.

Item	Description	WBS	Dwg No.	Status
1	temporary attachments			



Summary of Conversations:

See above for 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 , who represents the Office of Structural Materials for your project.

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