

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-006991**Date Inspected:** 27-May-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.

Observed repair welding of Casting B1-1-F G29417-3. The welding was being completed by Adrian Barnett. The welder qualification records for Mr. Barnett were reviewed and are in compliance with ASME Code Section IX and contract special provisions. Mr. Barnett was observed welding a temporary attachment to the casting in an area that will not be machined. A photograph is attached. This was reported to Les Peake, Quality Control Manager. The Amp Meter on the welding power supply was observed to be operating outside of the limits of the Welding Procedure Specification. The Amperage was verified with a Fluke Clamp Meter (serial number 98290166 cal due 4/8/10) and was noted to be 125 Amps which is within the parameters of the WPS for the 4mm electrode being used in making the SMAW weld. This was reported to the welding supervisor Mr. Terry Knall. The company providing calibration services has been contacted and is scheduled to recalibrate all of the welding power supplies this week.

Witnessed magnetic particle testing of Casting B2-1-F G29417-1. This testing follows excavation and surface dressing completed after the initial MT test was completed. The testing was being done in accordance with procedure MT06-09-02 Rev 4 by Hamish Milligan.

There is no radiography in progress on the cable band castings at this time. Operation of the linear accelerator remains impaired. It is limited in the exposure rate it can sustain, so the exposures are taking longer. The repair company is scheduled to come in on Friday to make repairs.

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Witnessed Tensile testing of the following:

Casting B14-CBT G29446-1

- Yield 415
- UTS 586
- Elongation 27%
- Reduction of area 48%

Casting B1-1F G29417-5

- Yield 409
- UTS 575
- Elongation 28%
- Reduction of area 57%

The results of the tensile testing are in compliance with contract special provisions and ASTM E148.

Item	Description	WBS	Dwg No.	Status
1	Temporary attachment			



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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