

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-007111**Date Inspected:** 08-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**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:

The following report is based on METS observations at Goodwin Foundry, Stoke on Trent, England.

Repair

QA inspector witnessed repair welding of castings B1/M-8, GG29416-8 and B1/M-7, GG29416-7 as submitted in ABF-SUB-000366 Rev. 32. The welder was observed welding in the flat position utilizing approved welding procedure WPS04-0120F4B. Parameters were observed to be within the limits of the WPS.

QA inspector witnessed buildup welding of casting B8/M-1, GG29426-1 as submitted in ABF-SUB-000366 Rev. 31. The welder was observed welding in the flat position utilizing approved welding procedure WPS04-0120F4B. Parameters were observed to be within the limits of the WPS.

QA inspector witnessed the jacking to required dimensions of GG29447-1, B14CBB to correct distortion. The corners of the casting were spread to the required dimension and strong-backs were welded in place to maintain the dimension during stress relief. See attached digital image.

Release

The QA inspector received and completed a review of the document packages including the Certificate of Conformity for:

GG29417-8, Drawing 5540-B1-1-F; this casting is awaiting dispatch to Goodwin International.

The foundry operations are complete including Visual Inspection, Nondestructive Testing, Mechanical Testing, and casting repair.

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GG29433-1, Drawing 5540-B8-1-F; this casting is awaiting dispatch to Goodwin International. The foundry operations are not complete. Radiographic testing of locations A, 4-5 and C, 4-5 have not been completed at this time.

Radiography

The QA inspector witnessed radiography performed by Goodwin Steel Castings. Mr. Scott Bennett performed radiography on casting GG29439-1, B10/F-1. The casting was radiographed using a single wall exposure. The radiographs were performed using a 3.2mm effective focal spot size, 8MEV linear accelerator. The source to film distance was maintained at 2,500mm. Number 40 to 80 hole type and Set 1C wire type image quality indicators were placed source side on each different thickness radiographed. AGFA type D4 and D7 film of various sizes were used for single and composite views to cover the range of thicknesses. Radiography of this casting was completed on this date.

Summary of Conversations:

During this visit, METS met with Mr. Jason Cross, Quality Assurance Manager. Mr. Cross reported that Goodwin Steel had been in discussions with an South Staffs about the possible issue with the required coating dry film thickness required. Mr. Cross was referred to CCO 37 for information on changes to the coating requirement.

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:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
