

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-008147**Date Inspected:** 27-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1200**Contractor:** Goodwin Steel, UK**Location:** Trentham, 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 B14-CBT G29446-1. This weld repair was completed on the finished machined casting. The welding was being completed by Witold Kaminski at Goodwin International. The welder qualification records for Mr. Kaminski were reviewed and are in compliance with ASME Code Section IX and contract special provisions. Mr. Kaminski was observed welding excavation number 1 on revision 4 of the weld map and WPS04-0120F4A. A 3.2 mm E7018-1 electrode was used. The amperage for this weld was 90 amps which is within the limits of 80-140 amps in the WPS. The weld was made in the vertical position. A photograph of the finished weld is attached. The calibration record for the welding power supply was reviewed. The serial number for the power supply is LB039682. It was last calibrated September 26, 2008 and is on a one year calibration interval. This weld repair was completed in accordance with the Welding Procedure Specification and appears to conform to project specifications.

Item	Description	WBS	Dwg No.	Status
1	Cable Band Casting B14-CBT Completed weld repair of final machined casting.			

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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
Reviewed By:	Lanz,Joe	QA Reviewer
