

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-008481**Date Inspected:** 01-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK**CWI Name:** None present**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:** Welder qualification**Summary of Items Observed:**

The following report is based on METS observations at Goodwin Steel Castings, Stoke-on-Trent, UK England.

The QA Inspector witnessed Terry Knall performing a Welder Performance Qualification in the 2G horizontal position using Welding Procedure Specification WPS04-0120F4C Issue 3. He was welding 15mm thick plate. Les Peake, QC Manager was supervising the qualification test. 3.2 mm E7018-1 electrode was used to make this open butt double bevel weld. The calibration sticker for the welding power supply indicates that it was last calibrated June 6, 2009. The weld was made at between 100 and 117 amps. This is within the WPS limits of 80-140 amps. The amperage was verified with Fluke 337 clamp meter serial number 98290166. The clamp meter was last calibrated April 8, 2009, recalibration is due April 8, 2010. The material certification records were not available for review. Mr. Les Peake has indicated that those records will be provided. Visual inspection of the completed weld was performed. The weld is acceptable to the visual inspection requirements of ASME Code QW-194.

Summary of Conversations:

Mr. Peake, QC Manager reports that an attempt will be made to radiograph the weld coupon with the linear accelerator, and if adequate sensitivity can not be obtained, the coupon will be sent out for radiography.

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.

WELDING INSPECTION REPORT

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