

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-008625**Date Inspected:** 08-Aug-2009**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Goodwin Steel, UK**OSM Arrival Time:** 900**OSM Departure Time:** 1400**Location:** Stoke-on-Trent, UK**CWI Name:****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 Steel Castings, Stoke-on-Trent, UK England.

On this date, the QA inspector observed Goodwin Steel Castings (GSC) welding personnel perform weld build up of the flanges adjacent to the grooves on Cable Band Casting B8/F. The GSC welding personnel Mr. W. Kaminski was making the weld repair using Shielded Metal Arc Welding (SMAW) process per the welding procedure specification WPS04-012F4B Issue 4 in the 1G (flat) position. The filler metal utilized was identified as 3.2 mm diameter E-7018-1. The minimum preheat temperature of 160 degrees Celsius and maximum interpass temperature of 425 degrees Celsius was verified to meet the WPS requirements by the QA inspector utilizing Tempilstik temperature indicators. The SMAW welding amperage of 105 to 118 was observed to be within the welding procedure specification parameter range of 80 amps to 140 amps. The work was completed on this date and appears to meet the minimum requirements of the welding procedure specification.

The QA inspector reviewed radiographic film of casting GG29444-1, B13-2-M with Goodwin Steel Castings NDT Level III technician Mr. Les Peake. The film quality and casting quality were reviewed for compliance with Goodwin Steel Castings Radiographic Inspection Procedure RT06-09-020 revision 2. The radiographs exhibited several areas of non-compliance with Contract special provisions section 10-1.60. Several of these areas had been previously identified by the radiographer Mr. Ian Pointon prior to this review. Locations B5-6, G0-1, J0-1, L0-1, and L2-3 were reviewed with Mr. Les Peake, and Mr. Peake agrees that these do not meet film quality requirements, and will be re-radiographed. Radiograph G1-2 is missing. See RADIOGRAPHIC FILM REVIEW SUMMARY-CASTINGS (TL-6030) for details.

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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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