

**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-008629**Date Inspected:** 12-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Goodwin Steel, UK**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. Radiography of B4-1-M GG29422-8 is complete and film is awaiting interpretation by Goodwin personnel.

Repair welding on casting B3-1-F GG29421-17 was observed. Mr. Kaminski was making the welds. He was using WPS04-0120F4B for the repair. The WPS was available to the welder in the welding booth. The welder was observed verifying the preheat and inter pass temperatures. The Temperature crayon that he was using was marked 399 degrees Celsius. The maximum inter pass temperature under this WPS is 425 degrees Celsius. The verification was performed following the first weld pass. The welder was using 4 mm electrode and running 109 to 124 amps which is within the WPS range of 100 180 amps. He was observed welding in the flat position.

Repair welding on casting B10-1-F GG29439-1 was observed. Mr. Gordon Douglas was making the welds. He was using WPS04-0120F4B for the repair. The WPS was available to the welder in the welding booth. The welder was observed verifying the preheat and interpass temperatures. The welder was using 5 mm electrode and running 221 to 235 amps which is within the WPS range of 140 240 amps. He was observed welding in the flat position.

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

GG29425-1, Drawing 5540-B5-1-F; this casting is awaiting dispatch to Goodwin International.

The foundry operations are complete including Visual Inspection, Nondestructive Testing, Mechanical Testing,

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and casting repair.

**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.

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<b>Inspected By:</b>	Riegler,Randy	Quality Assurance Inspector
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<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer
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