

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-009443**Date Inspected:** 16-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 810**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 on this date.

The QA inspector witnessed Adrian Barnett welding Casting GG29441-2 B10-2-F. He was observed welding in the flat position performing a weld metal buildup. He was using welding power supply serial number 7410045568. The weld was being made using 150-163 amps with 4 mm E7018-1 SMAW electrode.

The QA inspector reviewed the shipping document for, and observed castings GG29424-2 5540-B5-1-M, GG29421-18, 10, and 9 5540-B3-1-F, and GG29420-4 5540-B3-1-M loaded on the truck for transfer to Goodwin International.

QA inspector received a copy of the Goodwin Steel Castings "Weld Excavation Map" for casting GG29425-6, B5-1-F. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-147-09 was assigned for tracking purposes.

QA inspector received a copy of the Goodwin Steel Castings "Weld Excavation Map" for casting GG29446-4, B14-CBT. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-148-09 was assigned for tracking purposes.

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QA inspector received a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29424-6, B5-1-M. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-149-09 was assigned for tracking purposes.

QA inspector received a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29417-1, B1-1-F. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This third repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-150-09 was assigned for tracking purposes.

QA inspector received a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29422-8, B4-1-M. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-151-09 was assigned for tracking purposes.

QA inspector received a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29425-4, B5-1-F. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-152-09 was assigned for tracking purposes.

QA inspector received a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29423-10, B4-1-F. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-153-09 was assigned for tracking purposes.

QA inspector received a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29418-5, B2-1-M. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a minor repair and does not require post weld heat treatment. Caltrans Lot Number B243-154-09 was assigned for tracking purposes.

QA inspector received a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29424-5, B5-1-M. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-155-09 was assigned for tracking purposes.

QA inspector received a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29445-1, B13-1-F. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a major repair and requires post weld heat treatment. This document was returned for correction. Excavation number 38 is listed as 215 mm from datum B (end of the casting furthest from the identification), and it is actually located 215 mm from datum A (end of the casting closest to the identification). In addition, the locations excavated to remove discontinuities that were identified by radiography have not been identified as such on the weld excavation map.

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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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