

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-009884**Date Inspected:** 13-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 750**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1735**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, 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 Castings	

Summary of Items Observed:

The following report is based on METS Caltrans QA Inspector Mike Brcic's observations at Goodwin Steel Castings, Stoke-on-Trent, England, UK.

REPAIR WELDING-

GG29444-1 (B13-M) ~ Observed welder W.Kaminski, weld ID 629, performing SMAW process, 4mm, E7018-1 electrode, in a 1G position. Parameters of WPS 04-0120F4B issue 4, were verified and followed, Amp average during observation was 180, voltage was 24. Temperatures of casting exceeded 170° Celsius (preheat) and was below 425° Celsius for an interpass temperature. Excavation in work was identified as #42, "Major", on the Weld Excavation Map.

FINAL DOCUMENT PACKAGE REVIEW

This QA inspector received and completed a review of the final document packages including the Certificate of Conformity for casting GG29447-6, Drawing 5540-B14-CBB; package was returned for administrative correction, QA personnel corrected immediately and casting is now awaiting dispatch to Goodwin International of Trentham, UK.

The foundry operations are complete including Visual Inspection, Nondestructive Testing, Mechanical Testing, and casting repairs as of date of review.

WELDING INSPECTION REPORT

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Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations took place this day that this inspector was a party to.

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, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
