

**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-010124**Date Inspected:** 06-Nov-2009**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Goodwin Steel, UK**OSM Arrival Time:** 800**OSM Departure Time:** 1745**Location:** Stoke-on-Trent, UK

<b>CWI Name:</b>	None	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Cable Band	

**Summary of Items Observed:**

The following report is based on METS observations at Goodwin Steel Castings, Hanley, Stoke on Trent, UK on this date.

The QA inspector received a copy of the Goodwin Steel Castings "Weld Excavation Map" for casting GG31826-5, B14/SBT-5. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This second repair cycle is a minor repair and does not require post weld heat treatment. Caltrans Lot number B243-261-09 was assigned for tracking purposes.

The QA inspector received a copy of the Goodwin Steel Castings "Weld Excavation Map" for casting GG29446-5, B14/CBT-5. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This first repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot number B243-262-09 was assigned for tracking purposes.

The QA inspector received a copy of the Goodwin Steel Castings "Weld Excavation Map" for casting GG29440-1, B10/M-1. 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 B243-263-09 was assigned for tracking purposes. Post weld heat treatment and tensile testing for this casting was completed following the initial repair.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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The QA Inspector observed Casting GG29441-2 Drawing B10-2-F being welded by Adam Migas, Welder ID 80 to effect repair of the base metal. The welding power supply being used was Serial Number TA06056672. The amp and volt meters were last calibrated June 1, 2009 and are due for recalibration June 1, 2010. Mister Migas was observed using the Shielded Metal Arc Welding process. WPS 04-0120F4B was being used. He was using 3.2 mm E7018-1 electrode at 110 to 105 amps and 19 to 23 volts and was using temperature indicating crayons with temperatures of 170 degrees Celsius to verify minimum preheat and 399 degrees Celsius to verify maximum interpass temperature.

**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
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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