

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-012807**Date Inspected:** 22-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 745**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Goodwin Steel, UK**Location:** Trentham, 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 Caltrans METS QA Inspector Mr. Mike Brcic's observations at Goodwin International (GI), Trentham, UK on 22 March 2010.

SHOP REVIEW:

While this Caltrans QA Inspector was on site, GI, he had opportunity to review the progress of current castings located in the machine shop. The following castings and their current status, as they were observed this day by the Caltrans Inspector, is reflected here, see photos:

~ WPP70, GG29422-7 (B4-1-M cable band) is being scrutinized by QC inspector, Andy Cashmore, of Goodwin International, at the Marking out table per M3 step of the Manufacturing Inspection Test Plan (MITP 12-02-2009 issue 3).

~ EPP56, GG29426-2 and GG29427-7, B6 cable band, has been finished bore machined, and is being inverted 180°, at station known as TSS30, completing step K2 of the MITP. The cable band will then be moving to the NDT MPI tent for inspection per step M2 of MITP.

~ EPP12, GG29428-4 and GG29429-9, B7 cable band, has been finished rough bore machining, from opposite direction, fulfilling step I2 of the MITP at station known as the Webster Bennett vertical bore, the cable band is moving to the NDT MPI booth for rough bore inspection per step J2 of MITP.

~ GG29447-6, Strongback B14-CBB, located at station known as BTF2, is being final machined at joint face, which includes 55mm drilled holes as well as alignment keys, on surface known as area D of MITP.

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REPAIR WELDING

GG29421-2 (B3-1-F) Observed welder D.McDonagh, welder ID DM596, performing Gas Tungsten Arc Welding (GTAW) process using 2.4 mm diameter Filler material (.5% Mo), 3.2mm ceriated tungsten in a 2G position. Shielding gas in use was 99.9 % pure Argon, at a flow rate of 12 liters per minute. Parameters of WPS 271 Rev 1 (casting repair cycle is classified as a Minor), appeared to be followed; actual Amps during observation was 153, voltage 16.0. Temperature of casting was room temperature, 30°C (above 5°C minimum) interpass was below 235°C, confirmed with a temperature melting stick labeled 199°C. "Excavation" in work were identified as #4, per the Weld Excavation Map. Observed travel speed and Heat input was 130mm/min and 1.138kj/min respectively.

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



Summary of Conversations:

See above for conversations that this QA Inspector was a party to.

Comments

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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:	Edmondson,Fred	QA Reviewer
