

**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-012844**Date Inspected:** 24-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<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, Stoke-on-Trent on this date:

The QA Inspector observed weld repairs in progress on Casting GG29441-2. Drawing Number 5540-B10-2-F. Mr. A. Barnett, Welder Number 59 was observed welding excavation number 3 on revision 4 of the Weld Excavation Map. Mr. Barnett was using WPS04-0120F4B Issue 4 which was available at the work station. The casting was preheated to 160 degrees C, and verified with a temp stick. The amperage was observed to be 160 amps, the Voltage was observed to be 22 Volts. Four (4) mm E7018-1 was being used and the rod quiver in use was warm to the touch.

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

GG29445-1, Drawing 5540-B13-2-F; The Radiographic Technique report is complete, the package is complete  
GG29421-6, Drawing 5540-B3-1-F; the documentation package appears to be complete and acceptable  
GG29428-6, Drawing 5540-B7-1-M; the documentation package appears to be complete and acceptable  
GG29428-7, Drawing 5540-B7-1-M; the documentation package appears to be complete and acceptable  
GG29428-2, Drawing 5540-B7-1-M; the documentation package appears to be complete and acceptable  
GG29446-4, Drawing 5540-B14-CBT; the documentation package appears to be complete and acceptable  
GG29448-4, Drawing 5540-B15-1-M; the documentation package appears to be complete and acceptable  
GG29437-5, Drawing 5540-B9-1-F; the documentation package appears to be complete and acceptable  
GG29436-2, Drawing 5540-B9-1-M; the documentation package appears to be complete and acceptable

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# WELDING INSPECTION REPORT

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GG29439-2, Drawing 5540-B10-1-F; the documentation package appears to be complete and acceptable

The foundry operations are complete including Visual Inspection, Nondestructive Testing, Mechanical Testing, 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
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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