

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-013483**Date Inspected:** 06-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK

CWI Name:	N/A		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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 on this date:

The QA Inspector observed Mr. Dan McDonagh welding Casting GG29421-7, Drawing Number 5540-B3-1-F excavation 16R. Mr. McDonagh was using procedure WPS271 Revision 1. He was observed welding at 17 volts and 169 amps. His travel speed was 190 mm/min. Heat input was .90 Kjoules. The filler material being used is CMW 1940 batch number 14585.

SHOP REVIEW:

The QA Inspector reviewed the status of machining operations at Goodwin International. The following was noted:

WPP-114, GG29447-5 and GG29446-4, a B14 cable band was observed being machined at the Webster and Bennet machining center. The bore is being rough machined.

GG29422-12, Drawing number 5540-B4-1-M is in machining center BTD-3 at step 3 of the route card for machining of the joint faces.

GG29436-5, Drawing number 5540-B9-1-M is in machining center BTD-3 at step 2 of the route card for machining of the end faces.

GG29432-5, Drawing number 5540-B8-1-M is in horizontal boring machine BTF-3 at step 3 of the route card for

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machining of the joint faces.

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:	Edmondson,Fred	QA Reviewer
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