

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-015176**Date Inspected:** 27-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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	

Summary of Items Observed:

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

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

GG29418-1, Drawing 5540-B2-1-M; this package has been revised to include additional weld repairs, NDT, PWHT and Mechanical tests. It was returned for correction The welder performance qualification record for Shielded Metal Arc Welding for Dan McDonagh is not included in this documentation package.

GG29438-2, Drawing 5540-B10-1-M; this package documents that this casting is in compliance with project specifications.

GG29433-6, Drawing 5540-B8-1-F; this package documents that this casting is in compliance with project specifications.

GG29427-1, Drawing 5540-B6-1-F; This package has been revised to include additional weld repairs, NDT, PWHT and Mechanical tests. This package documents that this casting is in compliance with project specifications.

GG29421-11, Drawing 5540-B3-1-F; This package has been revised to include additional weld repairs and NDT. The weld repair on weld excavation map R3, excavation 15 requires post weld heat treatment. There is documentation that the weld repair has been completed, however, there is no record of post weld heat treatment. In

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addition, There is no record of certification for Mr. C. Fallows as a Level II in Magnetic Particle Testing. There is however a record of training for Mr. Fallows. This package was returned for correction.

GG29416-1, Drawing 5540-B-1-M; This package has been revised to include weld repairs on weld excavation map R2. This package documents that this casting is in compliance with project specifications.

On 12 April, 2010, the QA Inspector reported that final documentation package for casting B8-2-F(2) had been presented for review. Radiography of this casting remains incomplete, however, it was reported that radiography of this casting resumed the evening of 26 May, 2010.

The QA Inspector observed the CWI Fred Hawksworth monitoring welding of casting GG29431-2. Mr. T. Knall was observed performing welding of excavation 30 using the flux core arc welding (FCAW) method. Mr. Hawksworth was monitoring heat input and travel speed.

Summary of Conversations:

The QA Inspector had a conversation with Sarah Cross this date concerning Casting GG29421-11, Drawing 5540-B3-1-F. It was stated the the weld on weld map R3 had not been made. Ms. Cross indicated that an email had been sent to ABF documenting this however that no response had been received. The QA Inspector suggested that the document package be revised to reflect that that weld had not been made.

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
Reviewed By:	Edmondson,Fred	QA Reviewer
