

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-015498**Date Inspected:** 29-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2100**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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		Component:	Cable Band	

Summary of Items Observed:

The following report is based on METS observations at Goodwin International, Trentham, UK on this date:

The QA Inspector observed welding of Casting GG29443-2, Drawing Number 5540-B11-2-F. The welding was being performed by Mr. B. Kelsall. Mr. Kelsall was using WPS04-0120F4G Issue 6. The welding was being performed at 26.1 volts and 200 amps. The average heat input was .93 KJ, and the travel speed was 334 mm/minute. The filler metal was AWS 5.20 E71T-1M. The shielding gas was Argon, 20% CO₂, 2% O₂. These are within the allowable range of the WPS. Welding was being performed in the 1G position. A localized preheat was used and the welder verified the preheat with a 1770 C temperature indicating crayon.

The inspector was presented the shipper for Cable Band East Panel Point 72 (EPP-72) consisting of castings 5540-B4-1-M-8, GG29422-8, and 5540-B4-1-F-13, GG29423-13. This cable band is to be shipped to South Staffs for painting. A green tag was applied to the shipper. Caltrans Lot Number B243-182-10 was assigned for tracking purposes.

The inspector was presented the shipper for Cable Band West Panel Point 74 (WPP-74) consisting of castings 5540-B4-1-M-9, GG29422-9, and 5540-B4-1-F-9, GG29423-9. This cable band is to be shipped to South Staffs for painting. ABF-RFI-2167 is applicable to this cable band. A green tag with blue dot was applied to the shipper. Caltrans Lot Number B243-183-10 was assigned for tracking purposes.

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The inspector was presented the shipper for Cable Band East Panel Point 76 (EPP-76) consisting of castings 5540-B4-1-M-12, GG29422-12, and 5540-B4-1-F-14, GG29423-14. This cable band is to be shipped to South Staffs for painting. ABF-RFI-2168 is applicable to this cable band. A green tag with blue dot was applied to the shipper. Caltrans Lot Number B243-183-10 was assigned for tracking purposes.

The inspector was presented the shipper for Cable Band West Panel Point 94 (WPP-94) consisting of castings 5540-B3-1-M-17, GG29420-17, and 5540-B3-1-F-4, GG29421-4. This cable band is to be shipped to South Staffs for painting. A green tag was applied to the shipper. Caltrans Lot Number B243-182-10 was assigned for tracking purposes.

The QA Inspector reviewed welder performance qualifications for Welders Mr. B. Whitfield and Mr. B. Kelsell. The certifications are for the Flux Core Welding Process (FCAW). These welders qualified in the 3G position using an F6 welding wire and a shielding gas of argon, 20% CO₂ and 2% O₂.

SHOP REVIEW:

WPP-114, GG29436-5 and GG29437-6, a B9 Type 1 cable band was observed being machined at the Webster and Bennet machining center. The rough bore is being machined.

Casting GG29445-1, 5540-B13-2-F was observed at layout in preparation for machining.

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
Reviewed By:	Edmondson,Fred	QA Reviewer
