

**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-015551**Date Inspected:** 24-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 735**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK**CWI Name:****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 International, Trentham, UK on this date:

The QA Inspector observed casting GG29442-2, 5540-B11-2-M being welded. The welder Mr. W. Whyte welding at 26.0 Volts and 200 Amps. The length of the weld was 70 mm and the time to complete the weld was 12 seconds.

This results in a heat input of 0.89 KJ which is within the allowable heat input of .6 to .95 KJ. The travel speed is 350 mm per minute which is within the allowable range on the WPS. The casting was preheated to greater than 160 degrees C. verified by a 177 temperature indicating crayon.

**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