

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-015552**Date Inspected:** 01-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 845**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 welding of Casting GG29443-2, Drawing Number 5540-B11-2-F. The welding was being performed by Mr. M. Edwards. Mr. Edwards was using WPS04-0120F4G Issue 6. The welding was being performed at 25.5 volts and 200 amps. The average heat input was .84 KJ, and the travel speed was 360 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 QA inspector received and completed a review of the completed final document packages including the Certificate of Conformity for;

-East Panel Point 110 which is comprised of Castings GG29416-4, Drawing 5540-B1-1-M, and GG29417-1, Drawing 5540-B1-1-F. This package is complete and documents that this cable band is in compliance with project specifications. This cable band has not been received at Goodwin International from South Staffs.

-East Panel Point 70 which is comprised of Castings GG29422-10, Drawing 5540-B4-1-M, and GG29423-11, Drawing 5540-B4-1-F. This package is complete and documents that this cable band is in compliance with project specifications. This cable band has not been received at Goodwin International from South Staffs.

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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.

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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