

**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-015647**Date Inspected:** 05-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 reviewed the following final document packages including the certificates of conformance upon completion of manufacture prior to shipment to the site:

East Panel Point 106 (EPP-106). This is a B1 Type 4 cable band consisting of castings 5540-B1-4-M (9), and 5540-B1-4-F (7). The marking on the castings do not agree with the documentation package. The following are applicable to these castings: ABF-RFI-2046R0 for the female casting, and ABF-RFI -2129R0, ABF-RFI -2157R0, ABF-RFI-1725R0 and ABF-RFI-1724R0 for the male and female castings. A Blue tag identified with SMR Number S54-006-10 was attached to the certificate of conformance.

The QA Inspector received and completed review of the corrected documentation package for East Panel Point 84 (EPP-84). This is a B3 Type 1 cable band consisting of castings 5540-B3-1-M (14) and 5540-B3-1-F (13). The following are applicable to these castings: ABF-RFI-2157R0, ABF-RFI-1725R0 and ABF-RFI-1724R0 for the male and female castings. An orange tag was affixed to the Certificate of Conformance. CALTRANS Lot Number B243-185-10 was affixed for traceability.

The QA Inspector observed casting GG29441-1, 5540-B10-2-F staged in the weld booth for weld repair. Repair of this casting has not commenced at this time.

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# WELDING INSPECTION REPORT

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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 26.6 volts and 200 amps. The average heat input was and the travel speed were being monitored. The filler metal was AWS 5.20 E71T-1M. The shielding gas was Argon, 20% CO<sub>2</sub>, 2% O<sub>2</sub>. 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.

## 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.

WPP28, GG29436-7 and GG29437-5, a B9 Type 1 cable band was observed being machined at the TSS-30 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.

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**Inspected By:** Riegler,Randy Quality Assurance Inspector

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**Reviewed By:** Edmondson,Fred QA Reviewer

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