

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-015648**Date Inspected:** 06-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**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 GG29441-1, Drawing Number 5540-B10-2-F. The welding was being performed by Mr. M. Edwards. Mr. Edwards was using WPS04-0120F4G Issue 6. The welding was being performed at 27.0 volts and 190 amps. The heat input was 0.88 KJ, and the travel speed was 350 mm/min. These were being monitored. 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. Excavation Number 5, the through wall excavation was being welded. A backing bar was applied to the outside of the casting prior to commencement of welding.

Welding of cable band casting G29443-2, B11-2-F is complete

The QA inspector received a copy of the Goodwin Steel Castings "Weld Excavation Map" for casting GG29440-5, B10-1-M. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This initial repair cycle is a minor repair and does not require post weld heat treatment. Caltrans Lot Number B243-186-10 was assigned for tracking purposes.

SHOP REVIEW:

The following cable bands were observed at the layout table. They are being assembled to allow measurement of

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the length of the rope grooves:

~EPP_66 consisting of GG29425-2 and GG29424-5

~EPP-104 consisting of GG29416-1 and GG29417-8.

The QA Inspector traveled to BST accompanied by Mr. C. Ryder, QA Engineer where we met Mr. Seamus McShane, Technical Sales to observe commencement of the thread rectification process. The current plan is to machine the galvanized bolts on Monday through Thursday and have the bolts galvanized the next day.

Ungalvanized bolts will be machined on Fridays. The QA Inspector verified that the approved as noted drawings AS2852-A and AS2851-A were available and that the approved Manufacturing and Test Plan (MITP)(Revision D) was available. Machining of the cable band bolts began today.

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
