

**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-015682**Date Inspected:** 09-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 715**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 cable band West Panel Point 92 which is comprised of Castings GG29420-5, Drawing 5540-B3-1-M, and GG29421-7, Drawing 5540-B3-1-F has been received from South Staffs and was sighted by this inspector. The documentation package was reviewed. It is complete and documents that this cable band is in compliance with project specifications. 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 with Lot Number B243-187-10 was attached to the certificate of conformance.

The cable band West Panel Point 86 which is comprised of Castings GG29420-11, Drawing 5540-B3-1-M, and GG29421-11, Drawing 5540-B3-1-F has been received from South Staffs and was sighted by this inspector. The documentation package was reviewed. It is complete and documents that this cable band is in compliance with project specifications. 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 with Lot Number B243-187-10 was attached to the certificate of conformance.

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# WELDING INSPECTION REPORT

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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 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 177 degree Centigrade temperature indicating crayon.

## SHOP REVIEW:

EPP-28, GG29436-8 and GG29437-8, 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.

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<b>Inspected By:</b>	Riegler,Randy	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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