

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-015706**Date Inspected:** 14-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2030**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 Mr. M. Edwards, and Mr. R. Biealwa performing welder qualification tests. Mr. C. Ellis, Welding Engineer, Goodwin International was representing the manufacturer in performance of this qualification. The welders were using WPS04-0120F4G. The qualification was performed in the 2G position. These welders were previously qualified in the flat (1G) and vertical (3G) positions. The plate being used is 1/2" EN10025-2:2004 S355J2-N. It is identified with heat number 89076. The heat number was observed to have been stamped into the qualification coupons. This material appears to meet the mechanical and chemical requirements of ASTM A572. ASTM A 572 is an S1 material in accordance with QW-422. QW-420.2 indicates that qualification with an S-number material qualifies on the corresponding P-Number materials. The interpass temperature was verified with a 400 degree Centigrade temp stick.

The inspector was presented the shipper for the Cable Band for West Panel Point 66 (WPP-66) consisting of castings 5540-B5-1-M-6, GG29424-6, and 5540-B5-1-F-4, GG29425-4. This cable band is to be shipped to South Staffs for painting. ABF-RFI-2141 is applicable to this cable band. The dimensional reports have been revised, however the dimensional report for 5540-B5-1-M-6, GG29424-6 requires additional revision. The referenced drawing revision number requires correction. A tolerance is entered in error for dimension 37. This is a minimum dimension and a tolerance of ± 0.5 is shown.

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The QA Inspector performed a review of Certificate of Conformity SSPC 9296/10 from South Staffs documenting that the coatings on the following castings conforms to project specifications:

- ~East Panel Point 72 (EPP-72) Male Casting: GG29422-8, Female Casting: GG29423-13
- ~West Panel Point 74 (WPP-74) Male Casting: GG29422-9, Female Casting: GG29423-9
- ~East Panel Point 76 (EPP-76) Male Casting: GG29422-12, Female Casting: GG29423-14
- ~West Panel Point 94 (WPP-94) Male Casting: GG29420-17, Female Casting: GG29421-4
- ~West Panel Point 72 (WPP72) Male Casting: GG29422-11, Female Casting: GG29423-12

Cable bands EPP-72, WPP-72 and WPP-94 were assigned a green tag with Caltrans lot number B243-197-10 for tracking purposes.

Cable bands WPP-74, and EPP-76 were assigned a green tag with blue dot with Caltrans lot number B243-198-10 for tracking purposes.

These cable bands were received at Goodwin International this date. A visual verification of the castings was completed. One area with damage to the paint was noted. This damage appears to be due to handling. Mr. C, Ryder, QA Engineer, Goodwin International indicates that the paint will be repaired on site prior to wrapping for shipment.

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.

~EPP-26, GG29436-3 and GG29437-4, B8 type 1 cable band was observed at the TSS-30 machining. Casting GG29436-1, 5540-B9-1-M was observed at the layout table.



Summary of Conversations:

Relevant conversations are documented above

Comments

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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
