

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-016251**Date Inspected:** 16-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Goodwin Steel, UK**Location:** Stoke on Trent, 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 Foundry in Stoke on Trent, England.

On this date, the QA inspector periodically observed Goodwin Steel Castings (GSC) welding personnel Mr. William Yates perform welding of excavations numbers 33 and 34 on Cable Band Casting GG29434-2, B8-2-M per Submittal 366R147. The in process repair welding of the excavation utilized the gas shielded flux cored arc welding (FCAW-G) process per the welding procedure specification WPS04-012F4G Issue 6 in the 1G (flat) position. The filler metal utilized was identified as 1.2 mm diameter E71T-1M. The minimum preheat temperature of 160 degrees Celsius and maximum interpass temperature of 425 degrees Celsius was verified to meet the WPS requirements by the QA inspector utilizing Tempilstik temperature indicators. The FCAW-G welding amperage of 170, voltage of 22.3 by clamp type meter and travel speed of 380mm/min was verified to be within the welding procedure specification parameter ranges by the QA inspector. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification. See digital images below.

On this date, the QA inspector observed that weld repairs have been completed on excavations numbers 1 through 37 on Cable Band Casting GG29441-1, B10-2-F per Submittal 366R135. This casting is waiting for radiographic testing.

WELDING INSPECTION REPORT

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Summary of Conversations:

During this visit, METS met with Mr. Jason Cross of Goodwin Steel Castings. Mr. Cross reported that he had just submitted a revised repair plan for Cable Band Casting GG29434-2, B8-2-M originally approved in Submittal 366R147. The repair plan was revised to include the welding procedure specification WPS04-012F4G Issue 6. This repair is already in progress using this procedure. See body of report.

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:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
