

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-016523**Date Inspected:** 23-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Goodwin Steel, UK**Location:** Stoke on Trent, UK

CWI Name:	N/A	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. Adrian Barnett perform welding of excavations number 33 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 2G (horizontal) 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 2205, voltage of 24.2 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 image below.

WELDING INSPECTION REPORT

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Summary of Conversations:

Mr. Scott Bennett, who performed radiography on cable band casting GG29441-1, B10-2-F repairs as detailed in ABF – SUB – 366R135 reported that this casting had been transported to Applied Inspection for radiography of thin sections.

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
