

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017021**Date Inspected:** 20-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1815**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 met with Goodwin International personnel Mr. Chris Ryder. The QA inspector reviewed copies of the completed documentation for the Cable Band assemblies being shipped to site listed below. The documents contained the following. Material test reports, nondestructive test reports, dimension verification reports and Certificate of compliance from Goodwin Steel. The material appeared to be in conformance with contract documents with the following exceptions noted below.

a) The QA Inspector reviewed the documentation package for East Panel Point 50. This package includes castings: GG29428-6, 5540-B7-1-M and GG29429-4, 5540-B7-1-F. This is the final review prior to dispatch to the job site. The following are applicable to these castings: ABF-RFI-1725R0, ABF-RFI-1724R0 and ABF-RFI-2157R0 for the male and female castings. An orange tag with Caltrans Lot number B243-225-10 was affixed to the certificate of conformance for tracking purposes.

b) The QA Inspector reviewed the documentation package for East Panel Point 10. This is a B7 Type 1 cable band consisting of castings GG29428-9, B7-1-M (9), GG29429-5, B7-1-F (5). This review was completed prior to shipment of the castings to site. The following are applicable to these castings: ABF-RFI-1724R0, ABF-RFI-1725R0, and ABF-RFI-2157R0. for the male and female castings. An orange tag with Caltrans Lot number B243-225-10 was affixed to the certificate of conformance for tracking purposes.

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c) The QA Inspector reviewed the documentation package for East Panel Point 64. This is a B5 Type 1 cable band consisting of castings GG29424-2, B5-1-M (2), GG29425-5, B5-1-F (5). This review was completed prior to shipment of the castings to site. The following are applicable to these castings: ABF-RFI-1724R0, ABF-RFI-1725R0, and ABF-RFI-2157R0. for the male and female castings. An orange tag with Caltrans Lot number B243-225-10 was affixed to the certificate of conformance for tracking purposes.

The QA Inspector observed Mr. Paul Hollies, QC Inspector measuring the length of the suspender rope grooves on the Cable Bands for Panel Point 24 west bound, and Panel Point 30 West bound. The length of the groove at 180 degrees for Panel Point 24 west bound is 1517 for the top groove and 1526 for the bottom groove. The QC Inspector observed that there is mismatch of up to 6 mm at the ends of the rope grooves on Panel Point 30 West bound, and he identified the casting for additional fettling prior to measuring the length of the suspender rope grooves. Measurement of the length of the suspender rope grooves is being completed due to thickness at the rope groove exceeding that allowed.

The QA Inspector observed Mr. A. Cashmore, QC Inspector laying out the area on Casting GG29432-2, 5540-B8-1-M (2) to be welded.

The QA Inspector observed welding of Casting GG29427-6, Drawing Number 5540-B6-1-F. The welding was being performed by Mr. Dan McDonagh. Mr. McDonagh was using WPS 271 Revision 1. The welding was being performed at 27 volts and 180 amps. The heat input was and the travel speed were being monitored. The filler metal was AWS A5.28 ER70S-A1. The shielding gas was Argon with a flow rate of 12 L/min These are within the allowable range of the WPS. Welding was being performed in the 1G position.

SHOP REVIEW:

The QA Inspector periodically observed the in process machining of an assembled B10 Type 2 cable band, castings GG29440-1, 5540-B10-2-M and GG29441-3, 5540-B10-2-F for West Panel Point 36. The interior bore and end face was being machined on vertical mill TSS-30 to final finish requirements. Goodwin International personnel performed the machining.

The QA representative observed the in process machining of casting GG29435-2, 5540-B8-2-F at horizontal mill BTF-2. The spot faces are being machined at step 14 of the route card to final finish requirements. Goodwin International personnel performed the machining.

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Summary of Conversations:

The QA Inspector had a conversation with Mr. C. Ryder, QA Engineer concerning the shipment of cable bands scheduled for 21 September, 2010. Mr. Ryder indicates that the container for shipping the finished cable bands will be arriving at 1330 for load out.

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
