

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017295**Date Inspected:** 01-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 815**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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 welding of Casting GG29426-4, Drawing Number 5540-B6-1-M. The welding was being performed by Mr. M. Edwards. Mr. Edwards was using WPS04-0120F4G Issue 6. The welding was being performed at 23 volts and 165 amps. The filler metal was AWS A5.1 E7018-1. 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 was at least 160 degrees C. with a temperature indicating crayon.

**SHOP REVIEW:**

The QA Inspector periodically observed the in process machining of an assembled B10 Type 1 cable band, castings GG29438-2, 5540-B10-1-M and GG29439-1, 5540-B10-1-F for West Panel Point 34. The interior bore was being machined to finished condition on the TSS-30 vertical mill. Goodwin International personnel performed the machining.

The QA representative periodically observed the casting GG29443-2, 5540-B11-2-F at machining center BTF-2. The setup of the casting in the fixture was observed, and the joint faces are being machined to final finish requirements by Goodwin International personnel.

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# WELDING INSPECTION REPORT

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The QA Inspector periodically observed the in process machining of an assembled B10 Type 2 cable band, castings GG29440-3, 5540-B10-2-M and GG29441-4, 5540-B10-2-F for West Panel Point 38. The interior bore was being rough machined on the Webster and Bennet vertical mill Goodwin International personnel performed the machining.



## 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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**Inspected By:** Riegler,Randy

Quality Assurance Inspector

**Reviewed By:** Edmondson,Fred

QA Reviewer

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