

**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-018166**Date Inspected:** 09-Nov-2010**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Goodwin Steel, UK**OSM Arrival Time:** 815**OSM Departure Time:** 1700**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 periodically observed the excavation of magnetic particle testing indications on casting 5540-B13-2-M. The excavation was completed by Goodwin personnel and removal of the discontinuities was verified by liquid penetrant testing (visible solvent removable technique) and then by magnetic particle testing (AC Yoke, contrast color visible) by Mr. C. Fallows, NDT level II. The discontinuities have been removed to an acceptable size and the casting is awaiting weld mapping.

The QA Inspector observed cable band for east panel point 32 at fettling. The QA Inspector was observed Mr. A. Cashmore, QC Inspector inspecting the alignment of the suspender rope grooves. He identified this area for repair.

The QA Inspector observed welding of Casting GG29425-2, Drawing Number 5540-B5-1-F. The welding was being performed by Mr. Dan McDonagh. Mr. McDonagh was using WPS 271 Revision 1. The welding was being performed at 17.5 volts and 160 amps. The heat input and the travel speed were being monitored. The filler metal was AWS A5.28 ER70S-A1 batch 14585. The shielding gas was Argon with a flow rate of 13 L/min. These are within the allowable range of the WPS. Welding was being performed in the 1G position.

# WELDING INSPECTION REPORT

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Item	Description	WBS	Dwg No.	Status
1	East Panel Point 66 5540-B5-1-F(2) Weld repair of the suspender rope groove			



**Summary of Conversations:**

Relevant conversations are documented above.

**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.

<b>Inspected By:</b>	Riegler,Randy	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer