

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-019843**Date Inspected:** 19-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**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 GG29429-1, Drawing Number 5540-B7-1-F. The welding was being performed by Mr. B Kelsall. Mr. Kelsall was using WPS04-0120F4 Issue 5. The welding was being performed at 190 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. Mr. Kelsall was using a Tempilstik to verify the preheat at greater than 160 degrees.

An attempt was made to complete post weld heat treatment of Casting GG29441-2, Drawing Number 5540-B10-2-F. This casting failed to reach the required temperature of 630 degrees +/-20 degrees. Controller B2624 was being used. The thermocouple wire used was Type K .711 mm Batch No. T1US29014.

The QA Inspector did periodically observe the in process machining of an assembled B8 Type 1 cable band, castings GG29432-8, 5540-B8-1-M and GG29433-1, 5540-B8-1-F for West Panel Point 22. The rope grooves are being machined to restore alignment following welding. Goodwin International personnel were performing the machining.

The QA Inspector did periodically observe the in process machining of an assembled B8 Type 1 cable band, castings GG29432-4, 5540-B8-1-M and GG29433-9, 5540-B8-1-F for East Panel Point 24. The end is being machined to achieve equal lengths of the castings. Goodwin International personnel were performing the machining.

---

---

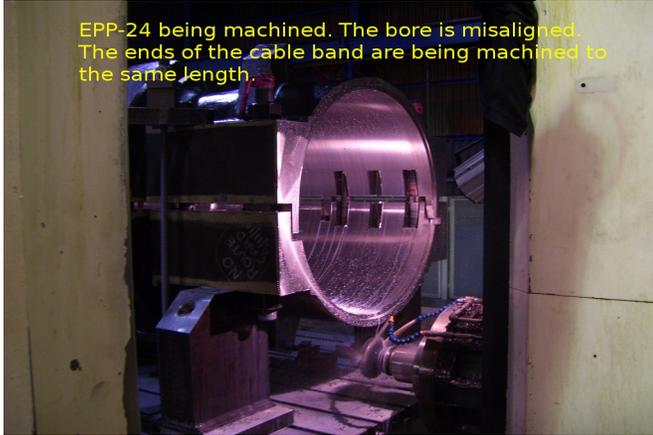
# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

There are currently ten cable bands that have been sent to South Staffs for coating, that have not been released following coating. These will be reviewed for release upon receipt of the results of test of the Noxyde Plus Paint subjected to sub freezing temperatures. One (The cable band for East bound panel point 100) that had been released to South Staffs for coating has been recalled to Goodwin International for rework prior to re-coating.



## 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

---