

**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-020845**Date Inspected:** 01-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**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>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<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 that Goodwin International personnel perform finish grinding of a B5 Type 1 cable band for west panel point 68 (WPP-68) consisting of castings 5540-B8-1-M-3, and 5540-B8-1-F-2, and an assembled B9 Type 1 cable band for west panel point 28 (WPP-28) consisting of castings 5540-B9-1-M-7, and 5540-B9-1-F-5. All sharp edges from the machining operations and suspender groove transitions are being ground to required finish by Goodwin International personnel.

QA Inspector observed welding of Casting GG29426-1, Drawing Number 5540-B6-1-M. The welding was being performed by Mr. Dan McDonagh. Mr. McDonagh was using WPS04-102F4B Issue 5. The welding was being performed at 230 amps. The filler metal was 5mm AWS A5.1 E 7018-1. Welding was being performed in the 1G position.

The QA Inspector observed measurement of the length of the suspender rope grooves on the cable band for East Panel Point 38, a B10 type 2 cable band. The locations at 180 degrees were marked out and the length was remeasured at 180 degrees. The results are:

Location	measurement at 180 degrees	calculated length at 200 degrees
Top:	2058 mm	2287 mm
Bottom:	2050 mm	2278 mm

Note that measurement labeled top is actually the groove that is closest to the center column when installed.

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# WELDING INSPECTION REPORT

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**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.

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

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