

**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-024065**Date Inspected:** 06-May-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 Trentham UK on this date:

The QA Inspector met with Goodwin International personnel Mr. Chris Ryder. The QA inspector received the dispatch notice for the cable band assemblies listed below shipping to South Staffs, Tipton, West Midlands, UK for further processing. The Documentation packages for the cable bands for Panel Point 8 West, Panel Point 8 East, and West Panel Point 44 were reviewed. The Partial Documentation Packages contained the following: Material test reports, nondestructive testing reports, and Certificates of Compliance and Dimensional Inspection Reports from Goodwin Steel Castings and from Goodwin International. The material appeared to be in conformance with the contract documents with the following exceptions noted below:

## a. West Panel Point 8:

~RFI-2381 is not addressed in the documentation.

~Weld map GG29449-4(R3): completion of the weld repair has not been accepted by the CWI.

~Weld map GG29448-1(R2): completion of the weld repair has not been accepted by the CWI.

~RFI-2311 applies to this cable band.

## b. East Panel Point 8:

~Weld map GG29448-2(R3): completion of the weld repair has not been accepted by the CWI.

~RFI-2311 applies to this cable band.

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# WELDING INSPECTION REPORT

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c. West Panel Point 44:

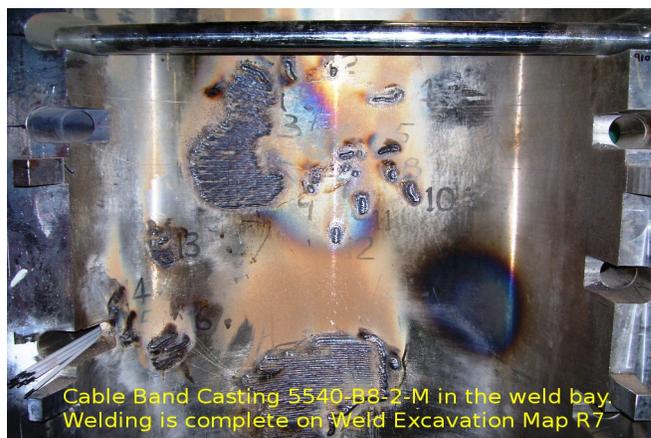
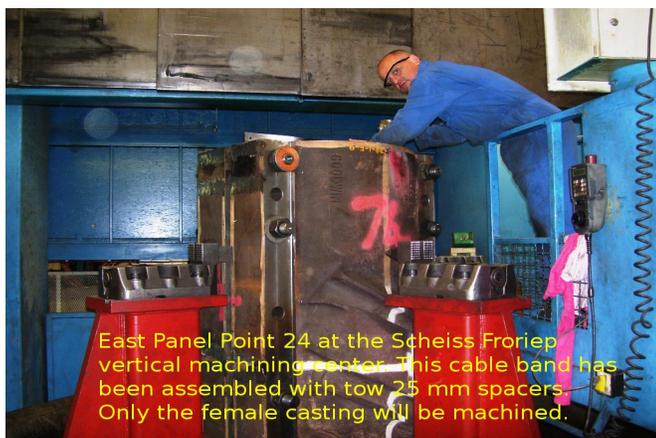
~Weld Map GG29442-2(R2): completion of the weld repair has not been accepted by the CWI.

~RFI-2374, and RFI-2371 apply to this cable band.

A green tag with blue dot was applied to the shipper for the cable bands for Panel Point 6 (four cable bands), and for Panel Point 44 West for shipment to South Staffs.

The QA Inspector observed welding of Casting GG29434-2, Drawing Number 5540-B8-2-M. The welding was being performed by Mr. M. Edwards. Mr. Edwards was using WPS 04-0120F4B Issue 5. The welding was being performed at 112 amps. The filler metal was 4mm Babcock A2 E7018-1. The preheat was monitored with Tempil sticks. The QA Inspector observed Mr. Edwards verify that the preheat was in excess of 160 degrees. These are within the allowable range of the WPS.

The assembled cable band for East Panel Point 24 was observed at the Scheiss Froriep vertical machining center for machining of the bore on the female casting. This cable band was assembled with two spacers (50 mm in total) to allow machining of the female half while not affecting the male half.



## Summary of Conversations:

The QA Inspector had a conversation with Mr. A. Bentley, QC Director who indicates that his best estimate is that the cable bands will be complete within three weeks.

## 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

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**Reviewed By:** Edmondson,Fred

QA Reviewer