

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-024927**Date Inspected:** 27-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK

CWI Name:	N/A		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Cable Band**Summary of Items Observed:**

The following report is based on METS observations at Goodwin International, Trentham, UK on this date.

Upon arrival at Goodwin International, the QA Inspector met with Goodwin International personnel Mr. A. Bentley, QC Director and reviewed the status of all castings present at Goodwin International.

The cable band for Panel Point 54 East was observed. This cable band appears to be complete with the exception that finish grinding is not complete. The final dimensional inspection is not complete.

The cable band for Panel Point 48 East was observed at the TSS-30 vertical CNC Machining Center for finish machining of the bore.

The Cable Band for Panel Pint 24 East was observed in the welding bay. Casting GG29433-9 was observed being welded in conformance with Weld Excavation Map GG29433-9(R4). A fired burner was used to achieve the required preheat of 160 degrees to conform to WPS04-0120F4G Issue 6. The QA Inspector observed the welder Mr. M. Edwards verify the preheat with a temperature indicating crayon. The Crayon being used was 177 degrees C. The QA inspector did verify that the filler material was AWS A5.20 E71T-1M, and that the shielding gas was BOC Argon-shield Heavy. Welding of excavation number 20 was observed. Welding parameters observed were 26.9 volts, 183 amps, and travel speed was 350 mm per minute (24 seconds for 140 mm). These are within the limits of the WPS.

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The cable band casings for Panel Point 46 are being remade at Goodwin Steel Castings in Hanley, Stoke on Trent, UK.

The Cable Band for Panel Point 34 West was observed in the weld booth. Post Weld Heat Treatment was in progress on GG29439-1(R5) excavations 27, 28 and 29 at the suspender rope grooves.

The Cable Band for Panel Point 36 East was observed. The final dimensional report is complete. Mr. Bentley indicates that an RFI is to be submitted to address a wall thickness over 35 mm, for the width of the stanchion pad, and to address a wall thickness through the rope groove that exceeds the maximum tolerance.

The Cable Band for Panel Point 38 West was observed. It was reported that an RFI has been submitted to address the width of the stanchion pad.

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.

Inspected By:	Riegler,Randy	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
