

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028727**Date Inspected:** 09-Nov-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 530**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Goodwin Steel, UK**Location:** Stoke-On-Trent, UK**CWI Name:****CWI Present:**

Yes No

Inspected CWI report: Yes No N/A**Rod Oven in Use:**

Yes No N/A

Electrode to specification: Yes No N/A**Weld Procedures Followed:**

Yes No N/A

Qualified Welders: Yes No N/A**Verified Joint Fit-up:**

Yes No N/A

Approved Drawings: Yes No N/A**Approved WPS:**

Yes No N/A

Delayed / Cancelled:

Yes No N/A

Bridge No: 34-0006**Component:** Type B16 Supplemental Cable Bands after pro**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Shailesh Wadkar, arrived at Goodwin Steel Castings to observe the surface Non Destructive Testing (NDT), defect excavation & repair of Type B16 Supplemental Cable Bands after proof machining. The manufacturing of the additional Type B16 Supplemental Cable Bands at the foundry is as part of a risk management strategy to address the concern with certain cable band gaps closing up as the work is progressing on-site during the main cable load transfer to the orthotropic box girders. The following items observed on this date were:

Repair welding is in progress for Clamp ID No: GG37015-6. Welder was identified as Mr. Witold Kaminski and the welding process was identified as Shielded Metal Arc Welding (SMAW). Welding was observed to be done in 1G position. Welding was done as per welding procedure specification (WPS): WPS04-0120F4A Issue-5.

This QA Inspector observed that the pre-heating and interpass temperature was maintained as per WPS requirement; while the welding was in progress. Also proper interpass cleaning followed by interpass visual inspection was done before depositing the following run. See attached photo for details.

This QA Inspector performed random visual inspection of the completed welds and were observed free from any surface discontinuities.

This QA Inspector also observed that the post weld heat treatment (PWHT) is in progress for the below mentioned clamps:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

- 1) Male clamps: GG37014-5, 6, 8 & 9.
- 2) Female clamps: GG37015-7, 8 & 9.

PWHT was done at 630°C for 3 hrs followed by cooling in still air. Furnace 'A' was used for performing this PWHT. Weld dress up and visual inspection after completion of repair welding was done by the Certified Welding Inspector (CWI) before performing this PWHT.

Clamp ID Nos: GG37014-7 and GG37015-5 are ready for Green tagging.



Summary of Conversations:

Except as noted above, only general conversations between this QA Inspector and Goodwin International personnel relevant to the welding, NDT & PWHT of the Type B16 cable bands on this date.

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 Gary Thomas, 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Shailesh	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer
