

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 #: 69.21**WELDING WITNESS REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000005**Date Inspected:** 11-Nov-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island, Shanghai, China**Witness:** Procedure Qualification Record
Welding NDT**Welder Qualification**
Mechanical Testing, describe: AWMT, Tensile, Side Bend,
Macro and Charpy-V**Index Lot #:** B72-047-06A**Witness Lot #:** B60-013-06**Bridge No:** 34-0006**Component:** N/A**Welder:** 34-0006**ID #:** 053619**Joint Description:** Single V/w Backing

N/A

WPS ID #: PWPS B.T.2231FA

N/A

Base Metal: A709M 345

N/A

PQR ID #: HP-2006103 (Max)

N/A

Thickness: 26mm

N/A

Process: FCAW

N/A

Electrode Spec/Class: A5.20/E71T-1

N/A

Positions: 1G

N/A

Backing Material: A709M

N/A

CWI: Liu Liu

N/A

Average Amps: 354.6

N/A

AWS Code: AWS D1.5 (2002)

N/A

Average Volts: 35.7

N/A

Applicable Sec: 5.12 Max & 12

N/A

Travel Speed: 276.1mm/min

N/A

Heat Input: 2.75kilojoules/mm

N/A

Preheat: 122.9C

N/A

Summary of Items Observed:

The Quality Assurance Inspector observed mechanical testing of the 1G FCAW Maximum Heat Input PQR. The Charpy-V Notch tests do not appear to comply with the contract documents. The impact values for the five (5) specimen were: 27, 42, 71, 24 and 32 Joules at -30 degrees celsius. All other mechanical tests appear to comply with the contract documents.

Summary of Conversations:

ZPMC intends to perform re-tests of the Charpy-V Notch samples on Monday, November 13, 2006. See TL-6031 for additional details.

Observed welding, testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By:	McClary, David	Quality Assurance Inspector
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Reviewed By:	Lowry, Patrick	QA Reviewer
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