

**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-000006**Date Inspected:** 11-Nov-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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 #:** B60-010-06A**Witness Lot #:** B60-014-06**Bridge No:** 34-0006L/R**Component:** Bid 52, 55 Tower and Girder**Welder:** Han Chang Hou**ID #:** n/a**Joint Description:** B-U2-S**N/A WPS ID #:** PWPS-B-T-221-FA N/A**Base Metal:** A709-50**N/A PQR ID #:** HP2006101 N/A**Thickness:** 26**N/A Process:** SAW N/A**Electrode Spec/Class:** under review**N/A Positions:** 1G N/A**Backing Material:** A709-50**N/A CWI:** Hung Wei N/A**Average Amps:** 747.9**N/A AWS Code:** D1.5 '02 N/A**Average Volts:** 36.5**N/A Applicable Sec:** 5.12.2 N/A**Travel Speed:** 572.7 mm/min**N/A Heat Input:** 2.86 KJ/mm N/A**Preheat:** 100 C**N/A****Summary of Items Observed:**

The Quality Assurance Inspector observed mechanical testing of the 1G SAW Maximum Heat Input PQR. The mechanical properties appear to comply with the contract documents. The electrode used for welding the PQR does not appear to comply with the contract documents. No certification of the electrode to ASTM A5.17 has been provided and ZPMC has not submitted an RFI as of this date.

**Summary of Conversations:**

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.

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# WELDING WITNESS REPORT

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<b>Inspected By:</b>	McClary, David	Quality Assurance Inspector
<b>Reviewed By:</b>	Lowry, Patrick	QA Reviewer

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