

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 #: 69.21**WELDING WITNESS REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000032**Date Inspected:** 09-Dec-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe:**Fracture Critical****Index Lot #:** B41-071-06a**Witness Lot #:** B41-072-06**Bridge No:** 34-0006**Component:** Bid 52, 55 Tower and Girder**Welder:** Zhang Xin Jian**ID #:** n/a**Joint Description:** B-U2a-GF

N/A

WPS ID #: PWPS-B-T-2231-FA

N/A

Base Metal: A709-50 F2

N/A

PQR ID #: HP2006107-3

N/A

Thickness: 26

N/A

Process: FCAW

N/A

Electrode Spec/Class: A5.20 / E71-T1

N/A

Positions: 1G

N/A

Backing Material: A709-50 T2

N/A

CWI: Huang Wei

N/A

Average Amps: 348

N/A

AWS Code: D1.5 '02

N/A

Average Volts: 34.6

N/A

Applicable Sec: 5.12.1

N/A

Travel Speed: 240.2mm/min

N/A

Heat Input: 3.02 KJ/mm

N/A

Preheat: 110 C

N/A

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector witnessed radiographic film for a Procedure Qualification (PQR) test plate using Flux Cored Arc Welding (FCAW), Hyundai Supercored 71H electrode, in the 1G (flat) position. The weld did not comply with the AWS D1.5, Section 6 requirements.

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.

WELDING WITNESS REPORT

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Inspected By:	Wright,Mark	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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