

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-000048**Date Inspected:** 16-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	Welder Qualification	Fracture Critical
	Welding	Mechanical Testing, describe:	
	NDT		
Index Lot #: B41-073-06A		Witness Lot #: B60-030-06	
Bridge No: 34-0006		Component: N/A	
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 #: HP2006107-7 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: A709-50 T2		N/A	CWI: Huang Wei N/A
Average Amps: 340.1		N/A	AWS Code: AWS D1.5 (2002) N/A
Average Volts: 34.1		N/A	Applicable Sec: 5.12.1 N/A
Travel Speed: 365.6mm/min		N/A	Heat Input: 1.90 KJ/mm N/A
Preheat: 70 C		N/A	

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector witnessed mechanical testing of Procedure Qualification (PQR) test plate using Flux Cored Arc Welding (FCAW), Hyundai Supercored 71H electrode, in the 1G (flat) position. The testing appeared to comply with the contract 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: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer