

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-000062**Date Inspected:** 06-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 **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe:**Fracture Critical****Index Lot #:** B60-012-06A**Witness Lot #:** B60-012-06**Bridge No:** 34-0006**Component:** Bid 52, 55 Tower and Girder**Welder:** Han Chang Hou**ID #:** n/a**Joint Description:** Fillet

N/A

WPS ID #: PWPS-B-T-2121

N/A

Base Metal: A709-50

N/A

PQR ID #: HP2006114

N/A

Thickness: 26

N/A

Process: SAW

N/A

Electrode Spec/Class: under review

N/A

Positions: 1F

N/A

Backing Material: A709-50

N/A

CWI: Hung Wei/Zhang Guanguan

N/A

Average Amps: 645

N/A

AWS Code: D1.5 '02

N/A

Average Volts: 32

N/A

Applicable Sec: 5.12.2

N/A

Travel Speed: 450

N/A

Heat Input: 2.75

N/A

Preheat: 20 C

N/A

Summary of Items Observed:

The Quality Assurance Inspector observed welding of the SAW 1F Plate. The electrode used was Atlantic CHW-S with CHF101 Flux. The documentation states the electrode is a F7A0-EH14 classification, but the electrode does not appear to be certified to ASTM A5.17.

The contractor performed the minimum size multi-pass fillet weld on one plate. The weld size appeared to be 12mm. The contractor attempted to perform the maximum size single pass fillet weld on the other side of the plate, however the weld size was smaller than desired and the contractor elected to attempt the fillet weld again on a separate plate. The completed weld still appears to be smaller than desired due to concavity of the weld.

Summary of Conversations:

See TL-6031 for conversations and 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

WELDING WITNESS REPORT

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Materials for your project.

Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer