

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-000101
Date Inspected: 23-Jan-2007

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

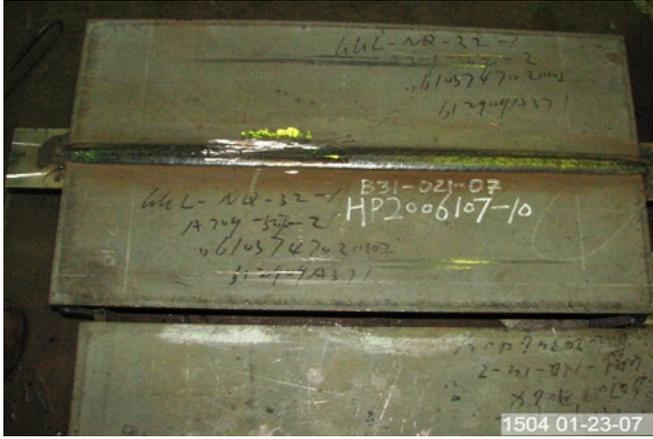
Witness:	Procedure Qualification Record	Welder Qualification	Fracture Critical
	Welding	Mechanical Testing, describe:	
	NDT		
Index Lot #: B31-021-07		Witness Lot #: N/A	
Bridge No: 34-0006		Component: N/A	
Welder: Jiang Xiao Hu		ID #: N/A	
Joint Description: Non Standard		N/A	WPS ID #: PWPS-B-T-3231-F(5) N/A
Base Metal: ASTM A709 Gr HPS485W		N/A	PQR ID #: HP2006107-10 N/A
Thickness: 75mm		N/A	Process: FCAW-G N/A
Electrode Spec/Class: A5.20/E71T1-1		N/A	Positions: 1G N/A
Backing Material: ASTM A709 Gr HPS485W		N/A	CWI: Huang Wei N/A
Average Amps: 343.8		N/A	AWS Code: D1.5-2002 N/A
Average Volts: 32.5		N/A	Applicable Sec: 5.13 N/A
Travel Speed: 260.2mm/min		N/A	Heat Input: 2.58Kj/mm N/A
Preheat: 160 C		N/A	

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector witnessed welding of a Procedure Qualification (PQR) test plate using gas shielded flux cored arc welding (FCAW-G) using Supercored 71H electrode, in the 1G (horizontal) position. The welding was performed per the AWS D1.5, 2002 Section 5.13 requirements. The ZPMC QC inspector Mr. Huang Wei recorded the preheat and interpass temperatures, the average amperage and voltage and the travel speed for all weld passes. The QA inspector noted that the welding appeared to comply with the contract documents. Caltrans lot number B31-021-07 was assigned for tracking purposes. Pictures are on file.

WELDING WITNESS REPORT

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Summary of Conversations:

At the completion of the welding the ZPMC QC inspector Mr. Huang Wei reported that the test plate was found to be acceptable in accordance with the contract documents.

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.

Inspected By:	Lanz, Joe	Quality Assurance Inspector
Reviewed By:	Wright, Mark	QA Reviewer
