

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-000103**Date Inspected:** 11-Jan-2007**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 #:** B31-002-07**Witness Lot #:** N/A**Bridge No:** 34-0006**Component:** N/A**Welder:** Li Zhen Ming**ID #:** N/A**Joint Description:** Non Standard**WPS ID #:** PWPS-B-T-3231-1 N/A**Base Metal:** ASTM A709 Gr 345**PQR ID #:** HP2006128 N/A**Thickness:** 75mm**Process:** FCAW-G N/A**Electrode Spec/Class:** A5.20/E71T1-1**Positions:** 1G N/A**Backing Material:** ASTM A709 Gr 345**CWI:** Huang Wei, Lu Tien Hua, Hu Gang N/A**Average Amps:** 333.7**AWS Code:** D1.5-2002 N/A**Average Volts:** 33.3**Applicable Sec:** 5.12 N/A**Travel Speed:** 275.1mm/min**Heat Input:** 2.43Kj/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 5.12 requirements. The QA inspector noted that the test was started on 01-08-2007 with the QC inspector Huang Wei, continued on 01-11-2007 with the QC inspector Lu Tien Hua and completed on 01-11-2007 with the QC inspector. The welding appeared to comply with the contract documents. Caltrans lot number B31-002-07 was assigned for tracking purposes.

Summary of Conversations:

At the completion of the welding the QC inspector Hu Gang reported that the test plate was found to be visually 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

WELDING WITNESS REPORT

(Continued Page 2 of 2)

Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
----------------------	----------	-----------------------------

Reviewed By:	Wright,Mark	QA Reviewer
---------------------	-------------	-------------