

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-000106**Date Inspected:** 17-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**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe:**Fracture Critical****Index Lot #:** B31-002-07**Witness Lot #:** B31-014-07**Bridge No:** 34-0006**Component:** N/A**Welder:** Li Zhen Ming**ID #:** N/A**Joint Description:** Non Standard (mod)**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:** 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:

On this date the Caltrans Quality Assurance (QA) representative Joe Lanz performed a review of radiographic film of a procedure qualification test plate ID HP2006128, Caltrans witness lot number B31-002-07 performed by Zhenhua Port Machinery Company (ZPMC). The test plate was radiographed by Jin Tong Jian Chen NDT Company LTD. of Shanghai China. The NDT Level II Inspector Mr. Haung Ming Hai performed the review of the radiographic film prior to submitting the NDT report and the radiographic film to the Quality Assurance Inspector for review. The film quality and weld quality were interpreted by Mr. Haung Ming Hai for compliance with AWS D1.5-2002 Section 6 Part B and Figure 6.1A and the results met the requirements of paragraph 6.26.2.

Mr. Haung Ming Hai found the radiographs to be acceptable and the QA inspector concurred with the interpretation. Caltrans lot number B31-014-07 was assigned for tracking purposes.

Summary of Conversations:

No relevant conversations.

Observed welding, testing or results:

WELDING WITNESS REPORT

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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
