

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-000139**Date Inspected:** 17-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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 #:** B49-009-07**Witness Lot #:****Bridge No:** 34-0006**Component:** Bid: 52, 55 Tower & Girder**Welder:** Zhang Xing Wei**ID #:** NA**Joint Description:** T-Joint**WPS ID #:** PWPS-B-T-2122-3 **N/A****Base Metal:** A709-50F-2**PQR ID #:** HP200716 **N/A****Thickness:** 26mm**Process:** SAW **N/A****Electrode Spec/Class:** A5.17/F7A(P)2-EH14**Positions:** 1F **N/A****Backing Material:** NA**CWI:** Huang Wei **N/A****Average Amps:** 650**AWS Code:** AWS D1.5-2002 **N/A****Average Volts:** 32.2**Applicable Sec:** 5.10 **N/A****Travel Speed:** 563.1**Heat Input:** 2.2 kJ/mm **N/A****Preheat:** 97.5**N/A****Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector was present as requested to witness the welding of a minimum size multi pass fillet weld, procedure qualification (PQR) HP200716 test plate using submerged arc welding (SAW), electrode specification A5.17, classification F7A(P)2-EH14 and diameter 4.8mm. The welding was performed in accordance with AWS D1.5 2002, Section 5.10.3 fillet weld soundness requirements. The testing was performed in a closed shop with wind condition less than 10km/hr. The welding appeared to comply with the contract documents. The completed weld test was visually inspected by ZPMC Quality Assurance Inspector, Mr. Huang Wei and accepted for conformance with contract documents.

Summary of Conversations:

As identified within the contents of this report.

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:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	McClary, David	QA Reviewer
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