

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-000143**Date Inspected:** 17-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 #: B71-014-014a		Witness Lot #: B71-014-007	
Bridge No: 34-0006		Component: Bid: 52,55 Tower & Girder	
Welder: Zhang Xin Jin/SAW; Jiang Xiao Hu/FCAW		ID #: N/A	
Joint Description: B-U2a-GF		N/A	WPS ID #: PWPS-B-T-223(2)1T-1 N/A
Base Metal: A709-Gr 50-2/Z25		N/A	PQR ID #: HP200706 and HP200708 N/A
Thickness: 60 mm		N/A	Process: FCAW + SAW N/A
Electrode Spec/Class: AWS A5.20 + A 5.17		N/A	Positions: 1-G N/A
Backing Material: Ceramic JN 401		N/A	CWI: Liu Liu and Huang Wei N/A
Average Amps: 280/ FCAW; 650/SAW		N/A	AWS Code: AWS D1.5 2002 N/A
Average Volts: 28.3/FCAW; 33.7/SAW		N/A	Applicable Sec: AWS 5.13 N/A
Travel Speed: 211.5/FCAW; 572/SAW		N/A	Heat Input: 2.19/SAW & 2.35/FCAW N/A
Preheat: 100 Min; 230 Max.		N/A	

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector was present as requested to witness the welding of the Procedure Qualification Record (PQR) test plate HP 200712-3 using flux cored arc welding (FCAW), TWE-711 in the 1-G (flat) position (diameter of the electrode 1.4 mm) for the root pass and additional 3 passes following the supported PQR HP200706 and the submerged arc welding (SAW) EH14 diameter of electrode 4.8 mm in the 1-G position total of 52 passes following the supporting PQR HP 200708. The welding was performed per the AWS D1.5, Section 5.13. The welding on the 400 mm test coupon appeared to be in compliance with the contract documents.

Summary of Conversations:

The QA inspector did not have any significant conversations on this date.

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:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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