

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-000147**Date Inspected:** 19-Mar-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: reduced section tension, side bend and macro etch specimens.**Index Lot #:** B49-006-07**Witness Lot #:** B49-011-07**Bridge No:** 34-0006**Component:** Bid: 52, 55 Tower & Girder**Welder:** Zhang Xing Jin**ID #:** NA**Joint Description:** B-L2a-S**N/A** **WPS ID #:** PWPS-B-T-223(2)1T **N/A****Base Metal:** A709-50F-2**N/A** **PQR ID #:** HP200711 **N/A****Thickness:** 60mm**N/A** **Process:** FCAW/SAW **N/A****Electrode Spec/Class:** A5.20, E71T1-1/A5.17, EH14**N/A** **Positions:** 1G **N/A****Backing Material:** ceramic**N/A** **CWI:** Bing Xu **N/A****Average Amps:****N/A** **AWS Code:** D1.5 **N/A****Average Volts:****N/A** **Applicable Sec:** 5.13 **N/A****Travel Speed:****N/A** **Heat Input:** **N/A****Preheat:****N/A****Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector was present as requested to witness the mechanical testing for procedure qualification (PQR) HP200711 using flux core arc welding (FCAW) and submerged arc welding (SAW). The welding consumable for the FCAW welding process is identified as 1.4mm diameter electrode, specification AWS A5.20 and classification E71T1-1 and the SAW welding process as 4.8mm diameter electrode, specifications AWS A5.17, classification EH14 and flux designated as S-777MXH(F7A(P)2 requirements. The mechanical testing was performed in accordance with AWS D1.5 section 5.13, figure 5.3. The weld test specimens appeared to comply with the contract documents.

WELDING WITNESS REPORT

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Summary of Conversations:

At 1000 hours. ZPMC Quality Assurance Manager, Lui Lui met with Caltrans QA and stated that ZPMC would be performing mechanical for PQR HP200711 at 1300 hours. At 1300 hours Caltrans witnessed the mechanical testing.

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: Hasler, Mike

Quality Assurance Inspector

Reviewed By: McClary, David

QA Reviewer
