

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-000149**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** **Fracture Critical**
Mechanical Testing, describe: macro etch specimens.**Index Lot #:** B49-008-07**Witness Lot #:** B49-013-07**Bridge No:** 34-0006**Component:** Bid: 52, 55 Tower & Girder**Welder:** Zhang Xing Jin**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:****AWS Code:** AWS D1.5 **N/A****Average Volts:****Applicable Sec:** 5.10 **N/A****Travel Speed:****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) HP200716, submerged arc welding (SAW) minimum single pass weld, using 4.8mm diameter electrode, specification AWS A5.17, classification EH14 and flux S-777MXH F7A(P)2 requirements. The mechanical testing was performed in accordance with AWS D1.5 section 5.10.3, figure 5.8 requirements. 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, Mr. Lui Lui met with Caltrans QA and stated that ZPMC would be performing mechanical for PQR HP200716 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
