

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000156**Date Inspected:** 23-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:** reduced section tension, all weld metal tension, side bend, charpy (CVN) and macro specimens.**Index Lot #:** B49-014-07**Witness Lot #:** B49-016-07**Bridge No:** 34-0006**Component:** Bid: 52, 55 Tower & Girder**Welder:** Zhang Xing Jin**ID #:** NA**Joint Description:** B-U2-S**N/A** **WPS ID #:** PWPS-B-T-2221-F-4 **N/A****Base Metal:** A709-50F-2**N/A** **PQR ID #:** HP200746-3 **N/A****Thickness:** 26mm**N/A** **Process:** SAW **N/A****Electrode Spec/Class:** A5.23/ENi5**N/A** **Positions:** 1G **N/A****Backing Material:** A709-50F-2**N/A** **CWI:** Huang Wei **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 by ZPMC Quality Assurance Manager, Mr. Lui Lui to witness the mechanical testing for procedure qualification (PQR) testing of HP200746-3. The PQR test plate was welded in the 1G position using the submerged arc welding (SAW) process, 4.8mm diameter electrode, specification AWS A5.23 and classification ENi5 and flux identified as MIL800-HPNi. The mechanical testing was performed in accordance with AWS D1.5 section 5.13, figure 5.1 requirements. The weld test specimens appeared to comply with the contract documents.

Summary of Conversations:

At 1100 hours. ZPMC Quality Assurance Manager, Mr. Lui Lui met with Caltrans QA and stated that ZPMC would be performing mechanical for PQR HP200746-3 at 1300 hours. At 1300 hours Caltrans was present to witness the mechanical testing.

WELDING WITNESS REPORT

(Continued Page 2 of 2)

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
---------------------	----------------	-------------