

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-000157**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**
Mechanical Testing, describe: fillet weld macro specimens.**Index Lot #:** B71-016-07a**Witness Lot #:** B49-017-07**Bridge No:** 34-0006**Component:** Bid 52**Welder:** Zhan Xing Jin**ID #:** N/A**Joint Description:** Figure 2.3 fillet welds

N/A

WPS ID #: PWPS-B-T-2121-4

N/A

Base Metal: 709-50F-2

N/A

PQR ID #: HP200747

N/A

Thickness: 26 mm

N/A

Process: SAW

N/A

Electrode Spec/Class: AWS A5.23/F9A4-ENi5

N/A

Positions: 1-F (single pass)

N/A

Backing Material: N/A

N/A

CWI: Liu Liu

N/A

Average Amps:

N/A

AWS Code: AWS D1.5 2002

N/A

Average Volts:

N/A

Applicable Sec: AWS 5.10.3

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 HP200747. The PQR test plate was welded in the 1F position, maximum single pass fillet weld 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 test was performed in accordance with AWS D1.5 section 5.10.3, figure 5.8 requirements. The fillet weld size for the maximum single pass weld measured approximately 8.5mm. 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 HP200747 at 1300 hours. At 1300 hours Caltrans was present to witness the mechanical testing.

Observed welding, testing or results:

WELDING WITNESS REPORT

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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
