

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-000190**Date Inspected:** 26-Apr-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:**Index Lot #:** B71-021-07a**Witness Lot #:** B71-021-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhang Xing Jin, Jiang Xiao Hu**ID #:** N/A**Joint Description:** B-U2-S**WPS ID #:** PWPS-B-T-2221-FA-2 **N/A****Base Metal:** A709-Gr 50-2/Z25**PQR ID #:** HP200787 **N/A****Thickness:** 26 mm**Process:** SAW **N/A****Electrode Spec/Class:** AWS 5.17**Positions:** 1-G **N/A****Backing Material:** A709-Gr 50F-2**CWI:** Liu Liu and Huang Wei **N/A****Average Amps:** 746.7**AWS Code:** AWS D1.5 (2002) **N/A****Average Volts:** 36.8**Applicable Sec:** AWS 5.12 Max Heat Input **N/A****Travel Speed:** 568.5 mm/min**Heat Input:** 3.0 KJ/mm **N/A****Preheat:** 100-230 celsius**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 200787 using the submerged arc welding (SAW) electrode specification/classification A5.17/F7A4 EH14, diameter of electrode 4.8 mm in the 1-G position total of 27 passes. The welding was performed per the AWS D1.5, Section 5.12 Maximum heat input. The welding on the 600 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 Materials for your project.

WELDING WITNESS REPORT

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