

**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-000192**Date Inspected:** 04-May-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 Bends, Macro's, Charpy's  
and All-Weld-Metal.**Index Lot #:** B71-021-07a**Witness Lot #:** B49-023-07**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**N/A** **WPS ID #:** PWPS-B-T-2221-FA-2 **N/A****Base Metal:** A709-Gr 50-2/Z25**N/A** **PQR ID #:** HP200787 **N/A****Thickness:** 26 mm**N/A** **Process:** SAW **N/A****Electrode Spec/Class:** AWS 5.17**N/A** **Positions:** 1-G **N/A****Backing Material:** A709-Gr 50F-2**N/A** **CWI:** Liu Liu and Huang Wei **N/A****Average Amps:****N/A** **AWS Code:** AWS D1.5 (2002) **N/A****Average Volts:****N/A** **Applicable Sec:** AWS 5.12 Max Heat Input **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. Liu Liu to witness the mechanical testing for procedure qualification record (PQR) testing of HP200787. The mechanical testing was performed in accordance with AWS D1.5 section 5.12, figure 5.1 requirements. The mechanical testing and weld test specimens appeared to comply with the contract documents.

**Summary of Conversations:**

At 0900 hours. ZPMC Quality Control Inspector, Mr. Liu Liu met with Caltrans QA and stated that ZPMC would be performing mechanical for PQR HP200787 at 0930 hours. At 0930 hours Caltrans was present to witness the mechanical testing.

is in general conformance with the contract requirements.

**Observed welding, testing or results:**

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# WELDING WITNESS REPORT

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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.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary, David	QA Reviewer

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