

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-000230**Date Inspected:** 29-May-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe: AWMT, Reduce Section
Tensile, Macro-etch, Side
Bend and Charpy-V Notch
(+HAZ)**Index Lot #:** B49-024-07**Witness Lot #:** B60-028-07**Bridge No:** 34-0006**Component:****Welder:** Zhu Hai Ping**ID #:****Joint Description:** B-U2a

N/A

WPS ID #: PWPS-B-T-3112

N/A

Base Metal: A709 Grade 485 (HPS 70)

N/A

PQR ID #: HP200777

N/A

Thickness: 75mm

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS A5.5/9018M-H4R

N/A

Positions: 3G

N/A

Backing Material: A709 Grade 485 (HPS 70)

N/A

CWI: Song Wei Min

N/A

Average Amps:

N/A

AWS Code: D1.5 2002

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:

The Caltrans Quality Assurance (QA) Inspector observed Mechanical Testing for the above Weld Procedure Qualification Test (PQR). The All Weld Metal Tension sample failed to meet the Special Provision requirements for Ultimate Tensile Strength.

Summary of Conversations:

ZPMC did not have enough material left from the PQR to perform retest samples of the AWMT test at two additional locations. Therefore, ZPMC will weld another test plate.

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

WELDING WITNESS REPORT

(Continued Page 2 of 2)

Materials for your project.

Inspected By: McClary, David

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer