

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-000231**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 #:** B71-022-007a**Witness Lot #:** B60-027-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhuhai Ping**ID #:** N/A**Joint Description:** B-U2a**WPS ID #:** PWPS-B-T-3211 **N/A****Base Metal:** A709 Gr. HPS485W**PQR ID #:** HP200776 **N/A****Thickness:** 75 mm**Process:** SMAW **N/A****Electrode Spec/Class:** AWS 5.5/E9018M-H4R**Positions:** 1-G **N/A****Backing Material:** A709 Gr. HPS485W**CWI:** Liu Liu and Huang Wei **N/A****Average Amps:****AWS Code:** AWS D1.5 (2002) **N/A****Average Volts:****Applicable Sec:** AWS 5.13 **N/A****Travel Speed:****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 wait for the results of HP200776-1, which was welded at a higher heat input.

is in general conformance with the contract requirements.

Observed welding, testing or results:

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.

Inspected By:	McClary, David	Quality Assurance Inspector
Reviewed By:	Lowry, Patrick	QA Reviewer
