

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-000290**Date Inspected:** 30-Jun-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:**Fracture Critical****Index Lot #:** B72-054-07a**Witness Lot #:** B72-054-07**Bridge No:** 34-0006**Component:** Bid:52**Welder:** Jiang Xie Hu**ID #:** N/A**Joint Description:** B-U2-S

N/A

WPS ID #: PWPS-B-T-3221

N/A

Base Metal: HPS 485WT2/Z

N/A

PQR ID #: HP2007147-1

N/A

Thickness: 90 mm

N/A

Process: SAW

N/A

Electrode Spec/Class: AWS A5.23/ENi5

N/A

Positions: 1-G

N/A

Backing Material: A709M-HPS-485W

N/A

CWI: Huang Wei and Xu Bing

N/A

Average Amps: 600.7

N/A

AWS Code: D1.5 2002

N/A

Average Volts: 30.3

N/A

Applicable Sec: 5.13

N/A

Travel Speed: 447.2

N/A

Heat Input: 2.44 KJ/mm

N/A

Preheat: 188 Celcuis

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 2007147-1 using the submerged arc welding (SAW) electrode specification/classification A5.23/ENi5, diameter of electrode 4.8 mm in the 1-G position. The welding was performed per the AWS D1.5, Section 5.13 Production Procedure WPS. Total of passes/layers were 85 passes and 28 layers. 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 regarding the test 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

WELDING WITNESS REPORT

(Continued Page 2 of 2)

Materials for your project.

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