

**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 #: 69.22P.A**WELDING WITNESS REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000297**Date Inspected:** 11-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), Jiangyin**Location:** Shanghai, China**Witness:** **Procedure Qualification Record**  
**Welding** **NDT****Welder Qualification**  
**Mechanical Testing, describe:****Fracture Critical****Index Lot #:** B72-037-07**Witness Lot #:** B26-012-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhu Hai Ping**ID #:** N/A**Joint Description:** B-U2a

N/A

**WPS ID #:** PWPS-B-T-3214

N/A

**Base Metal:** A709M-HPS-485W

N/A

**PQR ID #:** HP200778-1

N/A

**Thickness:** 25 millimeters

N/A

**Process:** SMAW

N/A

**Electrode Spec/Class:** AWS A5.5/ E9018M MR

N/A

**Positions:** Overhead 4G

N/A

**Backing Material:** A709M-HPS-485W

N/A

**CWI:** Wei Huang

N/A

**Average Amps:**

N/A

**AWS Code:** AWS D1.5 2002

N/A

**Average Volts:**

N/A

**Applicable Sec:** Paragraph 5.13

N/A

**Travel Speed:**

N/A

**Heat Input:**

N/A

**Preheat:**

N/A

**Summary of Items Observed:**

1) PQR Test Plate HP200778-1- The Caltrans QA Inspector performed the review of retested radiographs that were subsequently taken after the PQR weld cap was ground. Initial review on June 7th, 2007 of the preliminary radiographs revealed linear indications that were not in compliance with AWS D1.5 (2002) requirements. These retest radiographs appear to be in compliance with the requirements of AWS D1.5 (2002). These radiographs have been previously reviewed by ZPMC and ABF representative Mr. Nate Lindell. This 6032 is supported

**Summary of Conversations:**

The Caltrans QA Inspector informed ZPMC CWI, Mr. Lu Jian Hua, that the retested PQR test plate radiographs appear to be in compliance with the requirements of AWS D1.5 (2002).

**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

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# WELDING WITNESS REPORT

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Materials for your project.

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**Inspected By:** Cuellar,Robert

Quality Assurance Inspector

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**Reviewed By:** McClary,David

QA Reviewer