

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-000312**Date Inspected:** 12-Jul-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 #:** B71-042-07a**Witness Lot #:** B71-042-07**Bridge No:** 34-0006**Component:** Bid 52**Welder:** Zhang Xing Jin**ID #:** N/A**Joint Description:** Figure 2.3 fillet welds

N/A

WPS ID #: PWPS-B-T-3121

N/A

Base Metal: A709-HPS 485W T2/Z

N/A

PQR ID #: HP2007152

N/A

Thickness: 90 mm

N/A

Process: SAW

N/A

Electrode Spec/Class: AWS 5.23/ENi5-F9A4

N/A

Positions: 1-F (single and multiple passes)

N/A

Backing Material: N/A

N/A

CWI: Ju Lian Ping

N/A

Average Amps: 600

N/A

AWS Code: AWS D1.5 2002

N/A

Average Volts: 30

N/A

Applicable Sec: AWS 5.10.3

N/A

Travel Speed: 450 mm/min

N/A

Heat Input: 2.4 KJ/mm

N/A

Preheat: 119 Celsius

N/A

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector witnessed welding of the Procedure Qualification (PQR) test plate using single and multiple passes (2) with submerged arc welding (SAW), LA-85, 4.8 mm diameter electrode in the 1F (flat) position. The welding was performed per the AWS D1.5-02, Fillet Weld WPS Qualification Section 5.10 requirements. The welding appeared to comply with contract documents.

Summary of Conversations:

The QA inspector did not have any significant conversations on this date

is in general conformance with the contract requirements.

Observed welding, testing or results:

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.

WELDING WITNESS REPORT

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