

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-000331**Date Inspected:** 16-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** **Fracture Critical**
Mechanical Testing, describe: Macro-etching**Index Lot #:** B72-061-07**Witness Lot #:** B72-067-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Jin Rong**ID #:** N/A**Joint Description:** Fillet

N/A

WPS ID #: PWPS-B-T-2134

N/A

Base Metal: A709M Gr.50T2

N/A

PQR ID #: HP2007248-1

N/A

Thickness: 26 mm

N/A

Process: FCAW

N/A

Electrode Spec/Class: AWS 5.20/E71T-1

N/A

Positions: Overhead (4F)

N/A

Backing Material: N/A

N/A

CWI: Xiang Wen Hui/ Xu Bing

N/A

Average Amps:

N/A

AWS Code: AWS D1.5 (2002)

N/A

Average Volts:

N/A

Applicable Sec: AWS 5.13

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Bruce Berger observed the macro-etch test specimens of this procedure qualification test plate. These PQR samples did not appear to be in compliance with the code and specification. The samples were rejected by ZPMC Quality Control/Certified Welding Inspector Huang Wei for single pass fillet weld exceeding 8 millimeters in size.

Summary of Conversations:

There were no significant conversations held today.

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 Materials for your project.

WELDING WITNESS REPORT

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Inspected By:	Berger, Bruce	Quality Assurance Inspector
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Reviewed By:	McClary, David	QA Reviewer
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