

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-000360**Date Inspected:** 27-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	Welder Qualification	Fracture Critical
	Welding	Mechanical Testing, describe:	
	NDT		
Index Lot #: B71-048-07a		Witness Lot #: B71-048-07	
Bridge No: 34-0006		Component: Bid: 52,55 Tower & Girder	
Welder: Chen Ru Yang		ID #: N/A	
Joint Description: B-U2a		N/A	WPS ID #: PWPS-B-T-3214 Rev. 2 N/A
Base Metal: A709M HPS 485 W		N/A	PQR ID #: HP2007249-2 N/A
Thickness: 25 mm		N/A	Process: SMAW N/A
Electrode Spec/Class: AWS-A5.1/E-7018-1		N/A	Positions: 4-G N/A
Backing Material: A709 HPS 485 W		N/A	CWI: Ye Yong Jun and Huang Wei N/A
Average Amps: 169.9		N/A	AWS Code: AWS D1.5 (2002) N/A
Average Volts: 23		N/A	Applicable Sec: AWS 5.13 N/A
Travel Speed: 100.5 mm/min		N/A	Heat Input: 2.34 KJ/mm N/A
Preheat: 144 Celsius		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 2007249-1 using the shielded metal arc welding (SMAW) electrode specification/classification A5.1/E7018-1, diameter of electrode 4.0 mm in the 4-G position. The welding was performed per the AWS D1.5, Section 5.13 Production Procedure WPS. Total of passes/layers were 14 passes and 8 layers. The welding of test coupon appeared to be in compliance with the contract documents.

The QA inspector did not observe any significant air movement by the testing area.

169.9 23.0 100.5 2.34 144

Summary of Conversations:

