

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Vallejo, CA 94592-1133  
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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-000364**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**  
**Welding** **NDT****Welder Qualification**  
**Mechanical Testing, describe:** Fillet Weld Macro-Etches**Index Lot #:** B71-045-07a**Witness Lot #:** B60-040-07**Bridge No:** 34-0006**Component:** Bid 52**Welder:** Chen Ru yang**ID #:** N/A**Joint Description:** Figure 2.3 fillet welds

N/A

**WPS ID #:** PWPS-B-T-2134

N/A

**Base Metal:** A709-50-2

N/A

**PQR ID #:** HP2007248-2

N/A

**Thickness:** 25 mm

N/A

**Process:** FCAW-G

N/A

**Electrode Spec/Class:** AWS 5.20/E-71T-1

N/A

**Positions:** 4-F (single and multiple passes)

N/A

**Backing Material:** N/A

N/A

**CWI:** Lu Jian Ping

N/A

**Average Amps:**

N/A

**AWS Code:** AWS 1.5 2002

N/A

**Average Volts:**

N/A

**Applicable Sec:** AWS 5.10.3

N/A

**Travel Speed:**

N/A

**Heat Input:**

N/A

**Preheat:**

N/A

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) observed Macro-etch samples of the above fillet weld Weld Procedure Qualification test (PQR). QA measured the maximum size single-pass fillet weld qualified was 5.5mm and the minimum size multi-pass was 12mm.

**Summary of Conversations:**

No relevant conversations took place 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 Materials for your project.

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# WELDING WITNESS REPORT

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**Inspected By:**      McClary,David

Quality Assurance Inspector

**Reviewed By:**      Lowry,Patrick

QA Reviewer