

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-000401**Date Inspected:** 25-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 #:** B75-056-07**Witness Lot #:** B75-056-07**Bridge No:** 34-0006**Component:** Bid: 52**Welder:** Jing Rong**ID #:** N/A**Joint Description:** "T" FILLET

N/A

WPS ID #: PWPS-B-T-2132

N/A

Base Metal: ASTM A709 50T-2

N/A

PQR ID #: HP2007226-1

N/A

Thickness: 26 mm

N/A

Process: FCAW

N/A

Electrode Spec/Class: AWS A5.20

N/A

Positions: 2F

N/A

Backing Material: N/A

N/A

CWI: Huang Wei

N/A

Average Amps: 263 amps

N/A

AWS Code: D1.5-2002

N/A

Average Volts: 29.6 volts

N/A

Applicable Sec: 5.13

N/A

Travel Speed: 500.13 mm/min

N/A

Heat Input: 0.93 kj/in

N/A

Preheat: 35 degrees C

N/A

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Chuck Franco was present at the time requested to randomly observe welding being performed on a Procedure Qualification Record (PQR). The welding was performed with the flux cored arc welding (FCAW) process in the 2F or horizontal "T" fillet position. The QA Inspector observed ZPMC CWI Huang Wei monitoring welding amperage and welding voltage. Mr. Wei was being assisted by Meng Chun Xia of the ZPMC Technological Department, who was monitoring preheat, travel speed and recording all weld parameters. The QA Inspector also performed random verification of the above weld parameters and documented same.

Summary of Conversations:

There were no relevant conversations.

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

WELDING WITNESS REPORT

(Continued Page 2 of 2)

Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer