

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-000403**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	Welder Qualification	Fracture Critical
	Welding	Mechanical Testing, describe:	
	NDT		
Index Lot #: B75-055-07		Witness Lot #: B75-055-07	
Bridge No: 34-0006		Component: Bid: 52	
Welder: Jiang Xian Hu		ID #: N/A	
Joint Description: "T" FILLET		N/A	WPS ID #: PWPS-B-T-3111 N/A
Base Metal: ASTM A709M-HPS-485T2/Z		N/A	PQR ID #: HP2007251 N/A
Thickness: 90mm		N/A	Process: SMAW N/A
Electrode Spec/Class: AWS A5.5		N/A	Positions: 1F N/A
Backing Material: N/A		N/A	CWI: Huang Wei N/A
Average Amps: 258 amps		N/A	AWS Code: D1.5-2002 N/A
Average Volts: 23.2 volts		N/A	Applicable Sec: 5.13 N/A
Travel Speed: 138.13 mm/min		N/A	Heat Input: 2.60 kj/in N/A
Preheat: 193 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 shielded metal arc welding (SMAW) process in the 1F or flat "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

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Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer