

**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-000430**Date Inspected:** 03-Sep-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** **Fracture Critical**  
**Mechanical Testing, describe:** Macro Etching**Index Lot #:** B75-057-07**Witness Lot #:** B75-075-07**Bridge No:** 34-0006**Component:** Bid: 52**Welder:** Jiang Xiao 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 #:** HP2007257-1

N/A

**Thickness:** 90mm

N/A

**Process:** SMAW

N/A

**Electrode Spec/Class:** AWS A5.1

N/A

**Positions:** 1F

N/A

**Backing Material:** N/A

N/A

**CWI:** Huang Wei

N/A

**Average Amps:** 223 amps

N/A

**AWS Code:** D1.5-2002

N/A

**Average Volts:** 23.9 volts

N/A

**Applicable Sec:** 5.13

N/A

**Travel Speed:** 111.13 mm/min

N/A

**Heat Input:** 2.88 kj/in

N/A

**Preheat:** 190 degrees C

N/A

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Chuck Franco was present at the time requested to randomly observe macro etching being performed for a fillet weld soundness test for Procedure Qualification Record (PQR) HP2007257-1. There were 4 specimens each marked with the PQR Number and each separately marked with the letters A, B, C and D. Specimens A and C were rejected by ZPMC CWI Huang Wei for lack of fusion.

**Summary of Conversations:**

Mr. Wei informed the QA Inspector that a new fillet weld soundness test would be performed in a couple of days.

is in general conformance with the contract requirements.

**Observed welding, testing or results:**

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:** Franco,Charlie

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer