

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-000505**Date Inspected:** 31-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**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 #:** B72-054-07a**Witness Lot #:** B72-073-07**Bridge No:** 34-0006**Component:** Bid:52**Welder:** Jiang Xie Hu**ID #:** N/A**Joint Description:** B-U2-S

N/A

WPS ID #: PWPS-B-T-3221

N/A

Base Metal: HPS 485WT2/Z

N/A

PQR ID #: HP2007147-1

N/A

Thickness: 90 mm

N/A

Process: SAW

N/A

Electrode Spec/Class: AWS A5.23/ENi5

N/A

Positions: 1-G

N/A

Backing Material: A709M-HPS-485W

N/A

CWI: Huang Wei and Xu Bing

N/A

Average Amps:

N/A

AWS Code: D1.5 2002

N/A

Average Volts:

N/A

Applicable Sec: 5.13

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

This Quality Assurance (QA) Inspector, Bruce J. Berger reviewed the radiographic film for this procedure qualification test. The weld and film appears to be in compliance with the code and specification.

Summary of Conversations:

This QA Inspector Bruce J. Berger and Mr. John Kinsey of Caltrans had a conversation with Mr. Steve Lawton and Kevin Carpenter of American Bridge/Fluor (ABF). The conversation was concerned with the dark marks on the film in the area of interest caused by film mishandling. Mr. Lawton stated that he would discuss with ZPMC and their radiographic lab about the timing of the mishandling and the resolution of the problem. Mr. Lawton stated that he would contact Caltrans when he discovered the problem.

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.

WELDING WITNESS REPORT

(Continued Page 2 of 2)

Inspected By:	Berger, Bruce	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Cochran, Jim	QA Reviewer
---------------------	--------------	-------------
