

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-000612**Date Inspected:** 17-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1420**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: CVN retest**Index Lot #:****Witness Lot #:** B41-035-08**Bridge No:** 34-0006**Component:** PQR**Welder:****ID #:****Joint Description:**

N/A

WPS ID #:

N/A

Base Metal: HPS485WT

N/A

PQR ID #:

HP2008096-1

N/A

Thickness: 90mm

N/A

Process:

FCAW

N/A

Electrode Spec/Class: E71T-12JH4 -1.4mm

N/A

Positions:

3G

N/A

Backing Material:

N/A

CWI:

N/A

Average Amps:

N/A

AWS Code:

D1.5-2002

N/A

Average Volts:

N/A

Applicable Sec:

Section 5, figure 5.1

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

The Caltrans Quality Assurance Inspector (QA) was present as requested by the contractor to witness mechanical testing of PQR HP2008096-1 for a retest of Charpy's which fail on a previous test at the ZPMC metals laboratory located onsite.

The test appeared not to comply with the contract documents and a copy of the results were recorded and submitted to the QA.

Summary of Conversations:

The American Bridge/ Fluor (ABF) representative, Mr. Craig Knopps stated the PQR would be re-welded at a later 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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By:	Wright,Mark	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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