

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-000715**Date Inspected:** 03-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe:**Fracture Critical****Index Lot #:****Witness Lot #:** B240-158-09**Bridge No:** 34-0006**Component:** Welder Qualification Test (sample ID T8-4G)**Welder:** Lv An**ID #:****Joint Description:** Single V groove with backing bar

N/A

WPS ID #:

WPS-B-P-2214-B-U2a-1

N/A

Base Metal: ASTM A709M Gr345

N/A

PQR ID #:

N/A

Thickness: 25mm

N/A

Process:

SMAW

N/A

Electrode Spec/Class: TL-508 / 4mm diameter

N/A

Positions:

over head (4G)

N/A

Backing Material: ASTM A709M Gr345

N/A

CWI:

ZPMC

N/A

Average Amps: 140~160

N/A

AWS Code:

D1.5 2002

N/A

Average Volts: 20~29

N/A

Applicable Sec:

5..21

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat: 120

N/A

Summary of Items Observed:

Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau witnessed welder qualification test for ZPMC welder Mr, Lv An. The qualification welding tests utilizing the Shielded Metal Arc Welding (SMAW) process was conducted by welders performed in the over head position (4G). The qualification welding process was monitored and recorded by ZPMC inspectors. Base on Caltrans witnessing, the qualification welding tests appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

WELDING WITNESS REPORT

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Summary of Conversations:

As notes within report above.

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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