

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.15**SOURCE INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-000020**Date Inspected:** 21-Feb-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Quality Control Contact:** Fu Yu Hong**Quality Control Present:** Yes No**Material transfer:** Yes No N/A**Sampled Items:** Yes No N/A**Stock Transfer:** Yes No N/A**OK to Cut:** Yes No N/A**Rebar Test Witness:** Yes No N/A**Delayed/Cancelled:** Yes No N/A**Other:****Bridge No:** 34-0006**Component:** Mock-up**Bid Item:** 52**Lot No:** B60-008-07**Summary of Items Observed:**

Caltrans Quality Assurance (QA) verified the mill markings of 23 plates (20-A709 grade 50-T2 and 3-A709 HPS 485W), total weight 335,176 kg, for the Caltrans Mock-ups. Below is a listing of plates verified:

A709 grade 50 T-2 Material

30mm thickness: 1 plate - Heat number 6205682N

60mm thickness: 3 plates - Heat numbers 6103068N, 6102938N and 6204841N

70mm thickness: 12 plates - Heat numbers 06206321N (5 plates), 06103701N (2 plates), 06103775N (1 plate), 06103775N (3 plates), and 6102938N (1 plate)

75mm thickness: 2 plates - Heat numbers 06205705N and 06102665N

90mm thickness: 2 plates - Heat numbers 06104356N and 06103195N

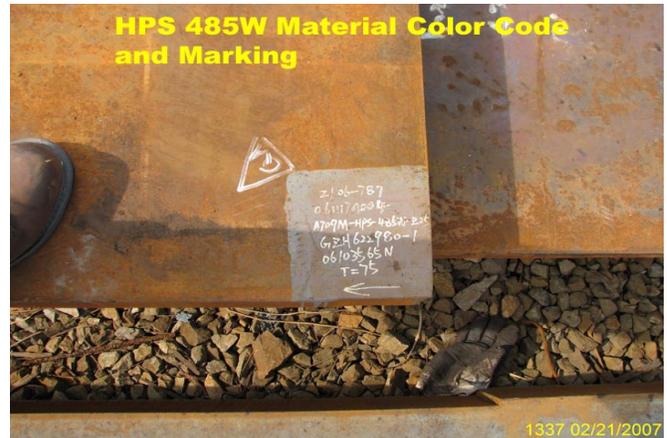
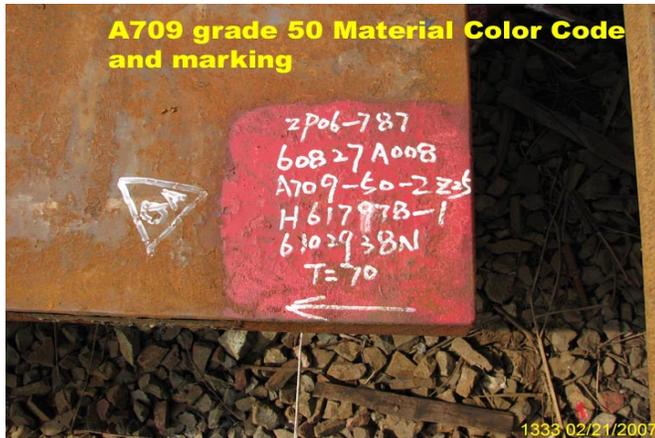
A709 HPS 485W Material

75mm thickness: 3 plates - Heat numbers 06103430N (1 plate) and 06103565N (2 plates)

All of the plates were marked by the mill with the size, grade and batch number in paint and the heat numbers in die stamp form. ZPMC color coded each plate by material grade (red for A709 grade 50 and grey for A709 HPS 485W). See Photos below:

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Summary of Conversations:

Caltrans Quality Assurance (QA) met with ABF representative Jeff Evans and ZPMC Quality Control Fu Yu Hong about ZPMC's method of Material tracking. ZPCM's system is broken into 4 phases: Receiving, Blast and Paint, Identification, and Cutting.

Receiving - each plate is assigned a number consisting of the year, month, day, "A" and number (i.e. 60807A135 : 2006, August, 7th plate 135) a list is made identifying the plate number with the associated MTR, Heat and Batch number.

Blast and Paint - The plates are blasted and painted to prevent corrosion during fabrication. The plate number is used to track the plate through the blasting and painting process. For larger thickness's, the plate may be cut prior to blasting and painting. In this case, each piece is die-stamped with the plate number prior to cutting.

Identification - each plate is color coded by material grade and the following information is written on the plate with paint marker: Job number (ZP06-787), Plate Number, Batch Number, Heat Number, Material Grade, Thickness and direction of roll.

Cutting - each plate is given a "cut sheet" detailing the piece numbers (consisting of a drawing number - piece number) to be given each piece, and assigned cut sheet number. This number corresponds to the CAD, CAM program for the burn table. A separate list is generated detailing the cut sheet number and the plate being cut, including grade, size, plate number, heat, batch and weight. A separate list is generated detail the piece name, piece number, grade, size and weight, but does not appear to list any cut sheet number or heat number.

ZPMC Project Manager Wu Yun informed QA that he received the e-mail with the list of Visa letters. Mr. Wu stated that he would draft the letters and see if he could get them signed by Mr. Guan today.

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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Inspected By:	McClary,David	Quality Assurance Inspector
Reviewed By:	Lowry,Patrick	QA Reviewer
