

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 #: 69.15**SOURCE INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-000024**Date Inspected:** 29-Mar-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**Quality Control Contact:** Lui Lui**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:** NA**Bid Item:****Lot No:** B49-019-07 & B49-020-07**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans QA inspector was present as requested by ZPMC to witness the mechanical testing for PQR HP200712 and HP200748 as follows:

HP200712- Test plate consisted of 60mm test plate with a complete joint penetration groove weld, performed in the 1G position with ceramic backing. The test plate was welded out with a combination welding process of flux core arc welding (FCAW) for the root pass and three filler pass welds, plus welding the remainder of the groove with the submerged arc welding (SAW) process per AWS D1.5, Section 5.13.

All Weld Metal Tension Test

Reduced Section Tension Test

Side Bend Test

Groove Weld Macro Test

Testing performed to AWS D1.5, Section 5.16, Figure 5.3 and Table 5.5 requirements.

Caltrans assigned lot number B49-019-07.

HP200748- Test plate consisted of 26mm test plate with a complete joint penetration groove weld, performed in the 1G position with steel backing. Submerged Arc Welding (SAW) Complete Joint Penetration Groove Weld, 1G position with Steel Backing. AWS D1.5, Section 5.13.

All Weld Metal Tension Test

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Reduced Section Tension Test

Side Bend Test

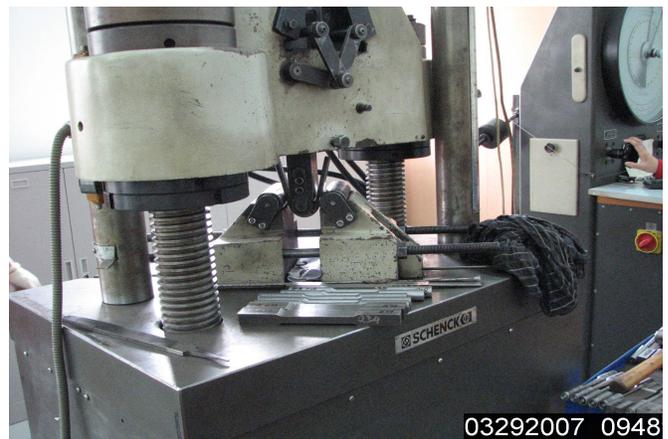
Charpy-V Notch (CVN) Test

Groove Weld Macro Test

Testing performed to AWS D1.5, Section 5.16, Figure 5.1 and Table 5.5 requirements.

Caltrans assigned lot number B49-020-07.

ZPMC Quality Assurance Manager, Mr. Liu Liu submitted supporting testing documentation for review and records. The recorded test information appeared to be complete, accurate and complying with contract documents. The testing records are on file at Caltrans field office for future reference. See Caltrans Welding Witness Report (TL-6032), dated March 29, 2007 for additional information.



Summary of Conversations:

As identified within the contents of this report.

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:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	McClary, David	QA Reviewer
