

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 #: 69.15**SOURCE INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-000027**Date Inspected:** 09-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Quality Control Contact:** Lu Jian Hua**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:** NA**Bridge No:** 34-0006**Component:** NA**Bid Item:** 52, 55**Lot No:** NA**Summary of Items Observed:**

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

The Caltrans QA Inspector met Mr. John Kinsey and Mr. Jim Merrill in regards to radiographic film for welder qualification that was reviewed Friday, April 6, 2007. Mr. Kinsey requested that ZPMC QA Inspector, Mr. Lu Jian Hua to re-present the five radiographs 070403102, 070403058, 070403060, 0700403005 and 070403007 that were accepted by ZPMC and found unacceptable by Caltrans QA Inspector, as not being in compliance with AWS D1.5-2002 and Special Provisions requirements. Mr. Kinsey's review of the radiographs and remarks are as follows:

Radiograph #070403102

Lack of penetration, measuring 50mm in length. However, ZPMC radiograph reader sheet that was presented today, shows that this radiograph is now rejected by ZPMC. This was not the case when the film reader sheet was presented Friday, 4-6-2007.

Radiograph # 070403058

Weld reinforcement lines obscuring possible discontinuities in the weld and was accepted by ZPMC.

Radiograph # 070403060

Lack of fusion at the root, measuring 35 mm in length, weld reinforcement irregularities that obscure possible discontinuities in the weld and was accepted by ZPMC.

Radiograph # 070403005

Lack of fusion, measuring 20 mm in length was accepted by ZPMC.

Radiograph # 070403007

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Lack of penetration at the root, measuring 50 mm in length was accepted by ZPMC.

Mr. Kinsey and Mr. Merrill requested a meeting with American Bridge/Fluor (ABF) and ZPMC representatives in regards to the film review.

Those present for the meeting were Mr. Craig Knop and Mr. Dave Williams of ABF and ZPMC QA Inspector, Mr. Lu Jian Hua. Mr. Kinsey and Mr. Merrill informed ABF and ZPMC of the unacceptable welder qualification radiographs that were accepted by ZPMC. ABF and ZPMC reviewed the radiographs and agreed that they were not in compliance with Caltrans project documents. Mr. Merrill informed ABF, that it appears, ABF is not providing adequate quality control coverage and that AWS D1.5-2002, Section 5, paragraph 5.26.1.1 states; weld reinforcement shall be ground flush or finished with slight reinforcement so that there are no lines or surface irregularities that may obscure discontinuities in the radiograph. ABF and ZPMC agreed that they would initiate controls to correct future radiographic testing.

Summary of Conversations:

See Task Leader journal for this week.

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.

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