

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-000165**Date Inspected:** 22-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** CWI - Huang Wei**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:** N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Mecha**Bid Item:** 52**Lot No:** B97-001-07**Summary of Items Observed:**

On this date the Caltrans Quality Assurance (QA) representative, John P. Tracy, performed a witness of PQR mechanical testing samples. Following is a list of test plates and the details of the review.

Upon arrival, Kevin Dye, Danny McDonald and David La Rue of ABF were present and in the company of CWI-Huang Wei of ZPMC.

Test Plate ID HP2007259, Caltrans witness lot number B97-001-07. The PQR welding was witnessed by Caltrans Inspector, Rosco Dixon, lot # B59-149-07. Two reduced section tensile specimens, one round, all-weld metal tension specimen, a set of five CVN impact samples, already placed within a -29.5 degrees centigrade bath upon arrival, were presented along with three macro etch samples. Two of the three macro etched samples had noted indications of entrapped slag at the fusion boundary between the base metal and the backing bar. AWS D1.5-2002, paragraph 5.19.6 refers to Section 6.26.1 which states "Thorough fusion shall exist between adjacent layers of weld material and between weld metal and base metal". Radiographic examinations, previously conducted, were acceptable per ZPMC. It was determined, by Huang Wei of ZPMC, that the two samples be rejected and that two new macro etch samples be cut, prepped and etched. Further results are pending as of this date.

The remaining samples had their individual examinations performed and they appeared to conform to the criteria set forth in contractual documents in regards to tensile, impact and bending properties, however at no time during the witness process were the samples identified as Compressional, SPCM or Fracture Critical.

Summary of Conversations:

At the completion of the mechanical testing the CWI / QC Inspector, Huang Wei, of ZPMC reported that macro etch samples were rejectable and that the remaining mechanical testing was found to be acceptable in accordance with the criteria set forth within the contractual documents.

SOURCE INSPECTION REPORT

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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:	Tracy,John	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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