

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-000601**Date Inspected:** 28-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 0**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 12**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Dao, Shanghai

Quality Control Contact:	ABF Paint Supervisor William (B)	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: Surface Preparation and Coatings Application**Bridge No:** 34-0006**Component:** OBG 6BW, 6AW, 5BE, 1BW**Bid Item:** 79, 80, 81**Lot No:** B226**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) NACE III coating inspector, Mr. Donald Jordan arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China. The purpose of the coating inspections are to monitor the surface preparation and coating applications for the SAS Bay Bridge project. This QA NACE III coating inspector observed the following:

OBG 1BW

Caltrans QA Coatings Inspectors received a Notice of Inspection for to attend a joint inspection with ABF and ZPMC QC for visual inspection of the surface preparation to look for surface anomalies and weld defects on the floor area of OBG 1BW. ABF verbally requested that the Caltrans welding staff be notified to perform VT inspection after blast. Areas requiring grinding were identified and marked by QC and QA staff. Caltrans QA Weld Inspector's Larry Viars, Joe Alaniz and Umesh Utekar performed VT inspection to locate and mark any weld repairs required. The weld repair spots were identified by placing tape over the area so it can be located after primer application. After the inspection was complete, grinding was performed. Abrasive blasting of the area was performed again. Another surface preparation inspection will be performed after blasting is complete. Lots of weld spatter required grinding, edges and cut surfaces required grinding around floor beam connections. NO ZPMC or ABF steel inspectors were on site looking at the welds.

OBG 5BE

Caltrans QA Coatings Inspectors received a Notice of Inspection for to attend a joint inspection with ABF and ZPMC QC for abrasive blast surface preparation on the faying surfaces of box beam connections in OBG 5BE were inspected after abrasive blasting. 2 of the plates need weld repairs. It was suggested to ZPMC QC to have the plates welded prior to assembling these pieces. If they are not repaired prior to final blasting and primer

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application they will have to be pulled apart and welded then, causing unnecessary damage to the final primer coat.

OBG's 6BW, 6AW

Caltrans QA Coatings Inspectors received a Notice of Inspection for to attend a joint inspection with ABF and ZPMC QC for abrasive blast surface preparation on the faying surfaces for T beam connections in OBG's 6BW, 6AW PP 37 – 43 were abrasive blasted and primed.

Surface Preparation and Primer Application today were performed in the following manor:

The areas to be primed met the SSPC SP10 Contract requirements. Surface profile Testex Tape was used by ZPMC QC personnel to record the blast profile. The Testex tape was measured using a dial micrometer. The readings were within the contract requirements of 40 and 86 microns. Ambient conditions were within Contract required parameters. After acceptance of the surface preparation, Interzinc 22 primer was applied within the specified 8 hour window after the start of abrasive blasting. The coating was mixed under the supervision of Caltrans QA Coatings Inspector Jordan, International Paint's Onsite Technical Services Engineer Peng Zi Li and QC personnel representing ABF and ZPMC. Coating application methods were observed by QA to insure the primer was applied using the methods outlined in the Project Special Provisions.

Fabrication on assembled components of the OBG's are not complete. Coating damage requiring re-blast is expected.



Summary of Conversations:

There were no relevant conversations on this date.

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 (China) +8613472477571, who represents the Office of Structural Materials for your project.

Inspected By:	Jordan,Don	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
