

**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-001494**Date Inspected:** 13-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Dao, Shanghai**Quality Control Contact:** William (Bill) Oak**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:** Coatings Inspection**Bridge No:** 34-0006**Component:** OBG 3AE**Bid Item:** 77, 78, 79**Lot No:** B265**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) NACE III coating inspector, Mr. James Lumley 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 3AE**

Performed joint three party inspection with ZPMC, ABF and Caltrans QA representatives. VT inspection of base metal and welded area was performed concurrent with abrasive blast inspection. ABF QA Don Walton and Dave Duon and Caltrans QA Larry Viars and Caltrans QA Lumley assisted in the inspection process and marked areas of base metal fabrication defects for repairs and amendment. Typical repairs consisted of arc strikes, burrs, weld slag and dross deposits as well as areas not in conformance with SSPC SP-10 requirements. ZPMC performed grinding operations on repairable areas, other areas which required amendment consisted of weld porosity and incomplete welds. Which were mapped and covered with duct tape.

Caltrans QA Larry Viars observed and ensured ZPMC performed requirements stated in ZPMC WQCP relative to performance of MT of areas which exhibited visible arc strikes. ZPMC performed grinding operations to other areas as stated previously then also performed additional re-abrasive blasting operations to base metal surfaces to re-establish profiles as well as correct areas which were not in conformance with SSPC SP-10 requirements. Areas of inspection were primarily the floor "T" stiffeners and internal bottoms of skin as well as surfaces approximately 2' up on vertical areas above the "T" stiffeners and the floor. ZPMC QC representative Dong Yaofei obtained profiles and monitored ambient conditions within the blast shop. Profiles obtained ranged between 68-82um which is within the range specified by the contract documents and the coating manufacturers recommendations. Interzinc 22 was applied to the aforementioned areas utilizing air-spray methods and supplemented with roller application as

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well on the hard to reach areas primarily the underside of the top flanges of the “T” stiffeners.

Note: No International Protective Coatings technical service representative present nor available during the course of this inspection process.

**Summary of Conversations:**

ZPMC requested inspection of surfaces a second time verbally after initial inspection was performed Caltrans QA Lumley requested additional Notice of Inspection for this.

**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 Eric Tsang. (858) 699-9549, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lumley,James	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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