

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-002708**Date Inspected:** 01-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Quality Control Contact:** Mr. Don Walton**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:** Coating Inspection**Bridge No:** 34-0006**Component:** See Below**Bid Item:** 77, 78, 79**Lot No:** B# 204**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) NACE II coating inspector, Mr. Baskar Govindarajan 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 II coating inspector observed the following:

An inspection was requested on the OBG Segment, 11 CE, External surfaces for adhesion test at Paint shop 1, vide inspection request no. 4466. This QA inspector observed, ABF inspector Mr. Helen, Mr. Stone and Mr. Turtle inspecting the adhesion test carried out by ZPMC QC Personnel. The result of adhesion test carried out at 6 places found to be in the range of 2.98 Mpa to 10.03 Mpa. This QA Inspector observed at two places the results found to be less than the requirement of Contract specifications which is 4 Mpa. This 2 surfaces found rejected by ABF Inspectors and additional Dollies found glued with primer surfaces adjacent to the Failure areas. High DFT observed in adjacent areas. International protective coatings technical service representative Mr. Li Peng was found present during the course of this inspection process. (Photo of Adhesion test where the failure happened is attached)

An inspection was requested on the OBG Internal entire ceiling, 11 CE, for DFT Check before transportation after Interzinc 22 application, vide inspection request no. 4467 at Paint shop 1. This QA inspector observed, ABF inspector Mr. Helen and Mr. Stone inspecting all the surfaces. The DFT measured by ABF Inspectors found to be in the Range of 96 to 140 which is acceptable as per contract documents. This was found accepted by ABF Inspectors after minor touch ups. International protective coatings technical service representative Mr. Li Peng was found present during the course of this inspection process.

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An inspection was requested on the OBG segment 11DW, External surface except Top Deck for Surface preparation inspection, vide request no. 4469 at Blast shop 1. This QA inspector observed, ABF inspector Mr. Stone, Mr. Wei, Mr. Turtle and Mr. Sun performing the profile inspection. This Caltrans inspector observed, Mr. Vibin (B 294), Mr. Tim McClendon (B 290), Mr. Larry Viars (B 252) and Mr. Art Peterson (B 273) from CT were present during the inspection for Pre blast visual inspection and found they marked all the Grinding points, Grinding +MT and weld repair points. This QA inspector observed, ABF inspectors rejected all internal surfaces for Overblast, Grinding and further weld repairs. This was again offered for inspection vide notification no. 4473. Salt test have been performed by ZPMC QC inspectors in 2 places and the result found to be 27.8 & 44.4 US/CM which is acceptable as per contract documents. Surface profile have been found measured by ZPMC QC Inspectors at 6 places and the result found to be in the range of 75 to 84 microns which is acceptable as per contract documents. This QA inspector found these surfaces offered for inspection again, vide inspection request no. 4474. This QA inspector found ABF inspector Mr. Stone inspecting marked surfaces and accepted for Interzinc 22 application. International protective coatings technical service representative Mr. Li Peng. was found present during the course of this inspection process.

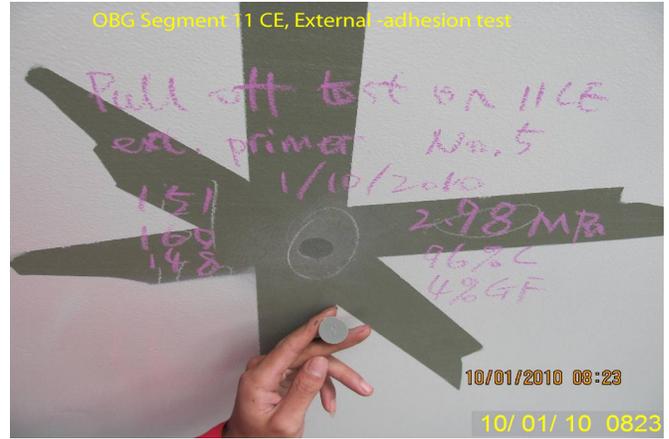
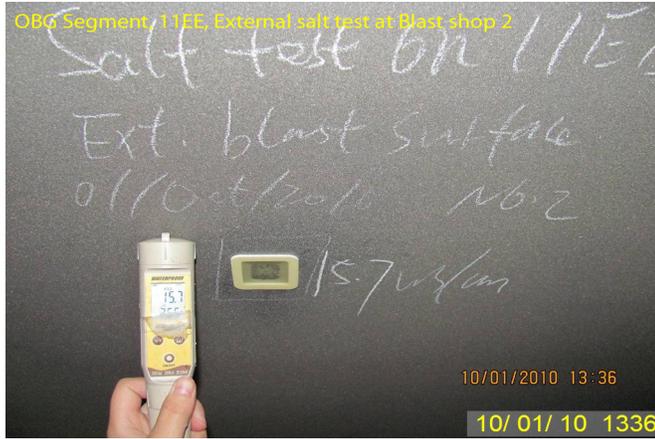
An inspection was requested on the OBG segment 11EE, External surface for Surface preparation inspection, vide request no. 4468 at Blast shop 2. This QA inspector observed, ABF inspector Mr. Stone, Mr. Wei, Mr. Turtle and Mr. Sun performing the profile inspection. This Caltrans inspector observed, Mr. Vibin (B 294), Mr. Tim McClendon (B 290), Mr. Larry Viars (B 252) and Mr. Art Peterson (B 273) from CT were present during the inspection for Pre blast visual inspection and found they marked all the Grinding points, Grinding +MT and weld repair points. This QA inspector observed, ABF inspectors rejected all internal surfaces for Overblast, Grinding and further weld repairs. This was again offered for inspection vide notification no. 4471. Salt test have been performed by ZPMC QC inspectors in 2 places and the result found to be 15.7 and 19 US/CM which is acceptable as per contract documents. Surface profile have been found measured by ZPMC QC Inspectors at 6 places and the result found to be in the range of 74 to 85 microns which is acceptable as per contract documents. This QA inspector found these surfaces accepted by ABF Inspectors for Interzinc 22 application. International protective coatings technical service representative Mr. Li Peng. was found present during the course of this inspection process. (Photo of Salt test conducted in External surfaces is attached)

An inspection was requested on the OBG Shim plates -X 83- 12 pieces, L splices, X 36E -3 pieces and X 36F -2 pieces for Surface preparation inspection, vide request no. 4470 at Blast shop 1. This QA inspector observed, ABF inspectors Mr. Sun, and Mr. Stone performing the said inspection. These plates found accepted by ABF Inspectors after minor touch ups in edges which was not blasted as per the requirement of SSPC SP 10. The surface profile measured by ZPMC QC Inspectors found to be in the range of 66 to 79 microns which is acceptable as per contract documents. International protective coatings technical service representative Mr. Li Peng. was found present during the course of this inspection process.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations

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 Michek Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer