

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005166**Date Inspected:** 16-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Steel Lay Down Yard**CWI Name:** Jeff Evans**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** A709SL-Gr345 Steel Plate**Summary of Items Observed:**

On this date Caltrans Quality Assurance (QA) Inspector, Albert Carreon, was present during the times noted above for observations relative to the work being performed.

ABF Jeff Evans, Caltrans Engineer Kit Guest, ZPMC steel representative and QA Inspector met and went to the Caltrans Steel Lay Down Yard to red tag thirteen (13) A709SL-Gr345 steel plates.

On 01-14-08 Caltrans QA Inspector reviewed thirteen (13) Check Test Sample reports for Shear Link A709SL-Gr345. These mechanical tests were performed at SRIM lab and the results recorded verified that the Upper Yield Strength:MPa exceeded the maximum allowable limit of 450MPa per the Special Provisions.

An Incident Report was written and issued by the direction of Mr. Kit Guest on 01-14-09.

For further information about the failed Check Sample test results, please review the Upper Yield Strength:MPa in the chart below.

List of Material for Caltrans Check Test Samples that exceeded the allowable Upper Yield Strength

Report Date Test Report # Received Type/Grade Thickness Sample QA Lot # Test Type Upper YS MPa

12/25/2008	2008-S-170	11/30/08	A709SL-Gr345	40mm	ACC.152	B75-55-08	G	444MPa - 469MPa
12/25/2008	2008-S-178	11/30/08	A709SL-Gr345	50mm	ACC.138	B75-63-08	G	466MPa - 469MPa
12/25/2008	2008-S-179	11/30/08	A709SL-Gr345	50mm	ACC.138	B75-64-08	G	455MPa - 490MPa

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

12/25/2008	2008-S-183	11/30/08	A709SL-Gr345	50mm	ACC.138 B75-70-08	G	454MPa - 468MPa
12/25/2008	2008-S-184	11/30/08	A709SL-Gr345	60mm	ACC.138 B75-76-08	G	437MPa - 455MPa
12/25/2008	2008-S-188	11/30/08	A709SL-Gr345	60mm	ACC.138 B75-80-08	G	462MPa - 448MPa
12/25/2008	2008-S-192	11/30/08	A709SL-Gr345	40mm	ACC.152 B75-84-08	G	487MPa - 474MPa
12/25/2008	2008-S-193	11/30/08	A709SL-Gr345	40mm	ACC.152 B75-85-08	G	484MPa - 486MPa
12/25/2008	2008-S-197	11/30/08	A709SL-Gr345	60mm	ACC.138 B75-89-08	G	462MPa - 455MPa
12/25/2008	2008-S-198	11/30/08	A709SL-Gr345	50mm	ACC.138 B75-90-08	G	474MPa - 462MPa
12/25/2008	2008-S-202	11/30/08	A709SL-Gr345	40mm	ACC.152 B75-72-08	G	489MPa - 474MPa
12/25/2008	2008-S-203	11/30/08	A709SL-Gr345	60mm	ACC.138 B75-73-08	G	458MPa - 441MPa
12/25/2008	2008-S-204	11/30/08	A709SL-Gr345	60mm	ACC.138 B75-74-08	G	467MPa - 436MPa

Summary of Conversations:

Mr. Evans informed Caltrans METS that he was attaching Red Tags to all 13 A709SL-Gr345 steel plates in question. He explained that the type of Red Tags used were Outstanding Repair Red Tags. He was directed by ABF not place rejected Red Tags on these 13 steel plates until this issue is further researched.

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 Serge Sinevod (Chinese cell # 13482570045), who represents the Office of Structural Materials for your project.

Inspected By:	Carreon,Albert	Quality Assurance Inspector
Reviewed By:	Lindenmuth,Mahlon	QA Reviewer
