



Daily Diary Report by Bid Item

Contract No.: 04-0120F4

Diary #: 128 Const Calendar Day: 674 Date: 14-Jul-2011 Thursday

Inspector Name: Wright, Doug Title: Transportation Engineer

Inspection Type: Continuous

Shift Hours: 07:00 AM 06:30 PM Break: 00:30 Over Time: 03:00

Federal ID:

Location:

Reviewer: Soheilifard, Saman Approved Date: 23-Jul-11 Status: Approved

04-0120F4
 04-SF-80-13.2/13.9
 Self-Anchored
 Suspension Bridge

Weather

Temperature	7 AM	12 PM	4 PM
Precipitation			Condition

Working Day If no, explain:

Diary:

Dispute

Tower Activities

Electroslag welding (ESW):

The 15th ESW weld was done today. It was on the butt joint that connects shear plate cW to the South shaft. The following is a list of activities for this operation:

- 2 new barrels of weld wire were brought to the site and connected.
- At 09:15, the consumable guide was installed.
- From 09:15 until 11:30, the insulators, volt pick-ups, and cooling shoes were installed.
- From 11:30 until 12:00, QC & production went through their pre-weld checklists.
- At 13:16, the weld was started.
- It took about 2 minutes, 45 seconds for the weld parameters to stabilize.
- At 17:38, the weld was ended in the run-off tab.

On the 13th ESW weld (b1W-to-West shaft) that was welded last Saturday, a preliminary UT continued today. A portion was previously UT'd, and showed 1 rejectable indication neat the bottom where they experienced a power problem during welding. Today's UT showed 9 "recordable" indications, which are non-rejectable but with greater than 50mm in length. The code requires that these types of indications are suspected of being piping porosity, and be further evaluated with RT. However, this weld is a skewed T-joint, and the RT may not be very practical or show the entire weld. I emailed Mark Woods asking how should proceed on this issue.

9m external diaphragm welding:

- There was no welding today because the welders were pulled to work on OBG.

Tower head:

Today they continued working on the trial fit of the Tower head. Sanny Khaw was watching this operation, see his diary for a list of labor and additional details. The saddle cover plates, Tower head curved diaphragm, and the North chimney had previously been erected. Today they erected the East and West chimneys.

Prior to erecting the chimneys, some minor remedial work was done to avoid the conflicts that were encountered. The following work was done on the East, West, and South chimneys:

- On the C-D corner at the grillage top plate, the square edge of the corner was ground to make it a smooth curved corner. This should avoid the conflict with the interior C-D corner weld of the Tower head.
- At the bottom of the 'F' plate, near the D-F corner, the bottom 20mm was removed so as to not interfere with the 'F' splice plate weld reinforcement. The was done only in the area where the 'F' plate extended all

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the way to the bottom of the Tower head, which was a length of about 150mm. - See attached photo.
 - At the bottom of each longitudinal stiffener on the 'F' plate, a small snipe (12mm) was cut from the corner of the stiffener so as to not interfere with the 'F' splice plate weld reinforcement.

East chimney fit-up: Generally, this section fit fairly well. The C and D skins of the head were tightly aligned with the skins on the grillage. However, on the 'F' plate, there is a large gap between the 'F' plate and the 'F' splice plate that is welded to the grillage top plate. It appears that a 10mm thick shim will be needed. Also, a lot of the bolts on the 'F' plate do not align. This may be due to the stiffeners interfering with the clip angles welded to the grillage. Some of the clip angles will need to be removed.

West chimney fit-up: The fit-up on this section was not very good. The C skin is misaligned by about 6mm and the D skin is misaligned by about 4mm. It cannot be shifted because there is an interference between the Tower head stiffeners and the stiffener clip angles that are welded to the top of the grillage. The clip angles may need to be removed in order to shift this section into better position.

Fit-up will continue tomorrow with the South chimney.

04-0120F4 Bid Item: 053 T-L01-SPD.053 Tower Lift 01 Shear Plates and Diaphragms

AMERICAN BRIDGE/FLUOR, A JV

Labor

Trade	Class	Name	RT Hrs	OT Hrs	DT Hrs	Total	Remarks	Dispute
Contractor: AMERICAN BRIDGE/FLUOR, A JV								
Ironworker	APP	JEFFERY STONE	8.00	3.00	0.00	11.00		<input type="checkbox"/>
Ironworker	APP	Alex Blanco	8.00	3.00	0.00	11.00		<input type="checkbox"/>
Ironworker	APP	DEVAN MURPHY	8.00	3.00	0.00	11.00		<input type="checkbox"/>
Ironworker	APP	JEREMY DOLMAN	8.00	3.00	0.00	11.00		<input type="checkbox"/>
Ironworker	APP	JEFFERY SOUZA	8.00	3.00	0.00	11.00		<input type="checkbox"/>
Ironworker	FOR	RORY HOGAN	8.00	3.00	0.00	11.00		<input type="checkbox"/>
Ironworker	JNM	RICHARD GARCIA	8.00	3.00	0.00	11.00		<input type="checkbox"/>

Attachment



Trimming the area of the 'F' plate that conflicts with the 'F' splice plate weld reinforcement



The 15th ESW weld in progress