

**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.yy**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000028**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 13-Dec-2006**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** 0 / 0**HSR's:** 0 / 0**NCR's:** 0 / 0

Item	Title	Detail
1	Major component movement	<p>Conducted welding of the following PQR test plates:</p> <p>1G Flux Core Arc Welding (FCAW) procedure identified as HP-2006107-7 using Hyundai Supercored 71H electrode to AWS D1.5, Section 5.12.1 (Maximum Heat Input), note ZPMC has lowered the Amperage and Voltage from those conducted on the previous 4 test which failed RT for lack of fusion.</p> <p>1G Submerged Arc Welding (SAW) procedure identified as HP-2006130 on 75mm thick HPS 485W material to AWS D1.5, Section 5.13 (Production Procedure). Welding was not completed by the end of the shift and will continue tomorrow.</p>
2	Key conversations	<p>The Caltrans Quality Assurance (QA) Inspector observed improper recycling of flux, which could cause contamination of the weld metal on the HPS 485W Test plate. The QA Inspector spoke with ZPMC Quality Control Managers Lu Jian Hua and Hu Gang and showed them the flux handling requirements in AWS D1.5, sections 4.8.3 and 4, and 12.6. ZPMC elected to continue welding using their current flux handling practices.</p> <p>ZPMC Quality Control Manager Lu Jian Hua informed the Caltrans Quality Assurance (QA) Inspector that they would maintain a ceramic heater on the HPS 485W test plate to prevent cracking overnight due to cooling.</p>
3	Logistics	ZPMC has begun installing piling for the overhead crane at the new facility.
4	Quality Assurance Inspectors per shift	2 AM 0 PM

**Inspected By:** McClary, David

Quality Assurance Inspector

**Reviewed By:** Lowry, Patrick

QA Reviewer