

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-000033**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 19-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>Reviewed RT film for the following PQRs:            1G Flux Core Arc Welding (FCAW), HP-2006107-8 - ZPMC rejected due to slag</p> <p>1G Submerged Arc Welding (SAW), HP-2006130 - needs to be RT tested again due to unacceptable film density</p> <p>Performed mechanical testing on 1G Gas Metal Arc Welding (GMAW) procedure test, HP-2006119-6 - tests appear to comply.</p> <p>Began welding of the 3G Submerged Arc Welding (SAW) procedure identified as HP-2006122 on 75mm thick HPS 485W material to AWS D1.5, Section 5.13 (Production Procedure). Welding will continue tomorrow.</p>
2	Key conversations	<p>ZPMC Testing Center Director Mr. Liu Liu stated they may want to perform another qualification on the 1G GMAW procedure to change the gas mixture in hope of reducing porosity and weld spatter.</p> <p>Mr. Liu Liu discussed with QA and ABF representative Craig Knops the HAZ Charpy-V notch requirement for the 485W material. He is aware that the 485W material requires HAZ Charpy testing, but has questions regarding the temperature and impact value requirements. They are currently performing testing with matching (90ksi) electrodes and under-matching (70ksi) electrodes, and would like further information regarding the requirements for each. QA stated he would contact the Engineer to determine these values.</p>
3	Quality Assurance Inspectors per shift	<p>1 AM            0 PM</p>

**Inspected By:** McClary, David

Quality Assurance Inspector

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# DAILY PROJECT JOURNAL

( Continued Page 2 of 2 )

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**Reviewed By:** Lowry,Patrick

QA Reviewer