

**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.yy**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000085**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 10-Mar-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** 0 / 0**HSR's:** 0 / 0**NCR's:** 0 / 1

Item	Title	Detail
1	Major component movement	<p>Caltrans Quality Assurance (QA) witnessed mechanical testing of the following Procedure Qualification (PQR) test plates:</p> <p>2F FCAW Fillet Weld Macro Etch Tests, HP-200713, qualified 7.1mm maximum size single pass, minimum size multi-pass failed for lack of penetration at the root</p> <p>3F FCAW Fillet Weld Macro Etch Tests, HP-200715, qualified 8.2mm maximum size single pass and 12.2mm minimum size multi-pass</p> <p>Caltrans Quality Assurance (QA) witnessed the continuation of welding of the Procedure Qualification (PQR) test plate for 1G FCAW/SAW (Supercored 71H FCAW electrode with new SAW electrode) with ceramic backing on 60mm plate for HP-200711 - welding is still in process, approximately 80% complete.</p>
2	Key conversations	<p>Caltrans Quality Assurance (QA) spoke with ABF Representative Jeff Evans regarding discrepancies observed by QA on the Preliminary Welding Procedures (PWPS) being given to Caltrans prior to performing the Procedure Qualification Tests (PQR). QA requested that ABF give QA the procedures prior to the day of actual welding to allow time to review the PWPS and have ABF and ZPMC the opportunity to correct any discrepancies prior to welding. QA also informed Mr. Evans that QA has observed the CWI Inspectors from ZPMC signing the "Reviewed by" section of mechanical testing without reviewing either the paperwork or the test samples. QA stressed that the CWI plays an important roll in reviewing and approving the testing.</p> <p>ZPMC Quality Control Hu Gang informed QA that PQR HP-2006107-10 had been incorrectly submitted in their Welding Quality Control Plan (WQCP) as being qualified to the Production Procedure (AWS D1.5, Section 5.13) when it was qualified under the Maximum Heat Input (AWS D1.5, Section 5.12.1) criteria. This is necessary in order to qualify the parameters used during the fillet weld qualification and the non-standard</p>

