

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-000090**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 14-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) started witnessing submerged arc welding (SAW) of the Procedure Qualification (PQR) test plates for 1G FCAW/SAW (TW-111 FCAW electrode with new SAW electrode) with ceramic backing on 60mm plate for HP-200712 - ABF representative Craig Knops recommended that welding be suspended until ZPMC has determined the cause of cracking in the root pass.</p> <p>Caltrans Quality Assurance (QA) observed radiographic testing and review the film at Jin Tong Jian Chen RT company in Shanghai on Procedure Qualification (PQR) test plate, HP-200711 (1G FCAW/SAW with Hyundai Supercored 71H electrode and new SAW electrode).</p>
2	Key conversations	<p>Caltrans Quality Assurance Inspector (QA) spoke with ABF welding engineer Craig Knops regarding the cracking observed in the root pass of the current ceramic backing PQR. Mr. Knops went to the PQR welding area and observed the cracks in the first test plate. Mr. Knops spoke with ZPMC Testing Center Director Mr. Liu Liu and recommended that ZPMC suspend welding until the cause of cracking was determined.</p> <p>ZPMC Quality Control Mr. Hu Gang gave QA a new PQR schedule which listed a 75mm plate thickness for testing the 1G, 3G and 4G SMAW procedures on A709 HPS 485W plate, and also added two additional PQR's using Lincoln LA85 (F9A4-ENi5-G-H2) on A709 grade 345 material.</p>
3	Quality Assurance Inspectors per shift	3 AM (2 on Changxing Island, 1 in Shanghai at Jin Tong Jian Chen RT) 0 PM
4	Logistics	Welding on HP-200712 and subsequent conversations between ABF and ZPMC regarding the root cracking were suspended due to weather issues (fog and heavy seas) requiring Caltrans and ABF to take a 1400 ferry back to Shanghai. (later ferries were being cancelled)

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QA Reviewer