

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-000091**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 15-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 the following Procedure Qualification (PQR) tests:</p> <p>1G FCAW/SAW (TW-111 FCAW electrode with new SAW electrode) with ceramic backing on 60mm plate for HP-200712 - continued from previous day welding is approximately 75% complete</p> <p>2F FCAW multi-pass fillet weld test, HP-200713-1</p> <p>Caltrans Quality Assurance (QA) observed Moody International Inspection conduction welder qualification tests.</p> <p>Caltrans Quality Assurance (QA) observed machining of mechanical test samples for HP-200710 at Shan Xun Machine Shop.</p>
2	Key conversations	<p>Caltrans Quality Assurance Inspector (QA) spoke with ABF welding engineer Craig Knops regarding ZPMC continuing to weld HP-200712 despite the cracking that both QA and ABF representatives observed in the root pass of this PQR. Mr. Knops stated he was "sad" that ZPMC decided to continue welding, but that he could not direct ZPMC to stop. Mr. Knops stated that if cracking was observed in production that ZPMC would stop using this electrode.</p> <p>Caltrans Quality Assurance Inspector (QA) spoke with ABF welding engineer Craig Knops regarding the machining of PQR HP-200710. QA had observed that they appeared to be machining the plate as though it was performed to AWS D1.5, Figure 5.1 which includes All Weld Metal Tension (AWMT) and Charpy-V notch samples. The welding was actually performed to AWS D1.5, Figure 5.3 for weld soundness and does not require either the AWMT or Charpy samples. Mr. Knops spoke with ZPMC Testing Center Director Mr. Liu Liu about this and was informed that this was due to miscommunication with the Machine Shop, and that ZPMC did not intend to test either the AWMT or Charpy samples.</p>

