

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-000092**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 19-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>QA witnessed welding of the following PQR test plate: 1G SAW (Lincoln LA85+MIL800-HPNi (F9A4-ENi5-G-H2)) on 26mm A709 grade 345 plate for HP-200746 - Welding is complete.</p> <p>QA witnessed mechanical testing for the PQR test plates: 1G FCAW Non-standard Joint using Ceramic Backing on 60mm plate, HP-200710 1G FCAW/SAW (TW-111 FCAW S-777MXH+H14 SAW) with ceramic backing on 60mm plate, HP-200712 2F FCAW multi-pass fillet weld test, HP-200713-1 1F SAW (S-777MXH+H14) fillet weld, HP-200716</p> <p>QA performed random observations of bend tests on Welder Qualification Tests performed by Mood International Inspection. ZPMC rejected 1 of the 11 Welder Qualifications.</p>
2	Key conversations	Caltrans Quality Assurance (QA) spoke with ABF representative Peter Ferguson regarding the U-rib welding gantry. Mr. Ferguson informed QA that ZPMC is currently re-assembling the welding heads on the gantry. Mr. Ferguson stated ZPMC would probably begin conducting internal rib trials during this week.
3	Quality Assurance Inspectors per shift	3 AM 0 PM
4	Logistics	ZPMC gave Caltrans Quality Assurance another PQR schedule which added two Production Procedure (Section 5.13) Submerged Arc Welding (SAW) test plates. One utilizes the JW-B+JW3 (F7A2-EM12K) and the other utilizes S-777MXH+H14 (F7A(P)2-EH14). Both are being performed because ZPMC wanted to qualify a lower Heat Input than was previously qualified by the Maximum Heat Input test plates. Note: the original two SAW PQR's had been performed and Maximum-Minimum Heat Input tests, but both electrodes' Minimum Heat Input test plates failed Charpy-V Notch

DAILY PROJECT JOURNAL

(Continued Page 2 of 2)

Impact testing.

Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer
