

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-000247**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 29-Aug-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** /**HSR's:** /**NCR's:** /

Item	Title	Detail
1	Other important observations	<p>At approximately 9:00 am today, I went on a shop floor walkthrough with Mazen Wahbeh and Keith Devonport. We were accompanied by ABF's Peter Ferguson. We conducted walkthroughs of the fabrication bays containing ZPMC's internal weld trials and the Tower mock-ups. We later conducted a walkthrough of the new Tower fabrication facility which is currently under construction.</p> <p>ZPMC Internal Closed Rib Weld Trials</p> <p>ZPMC has started to install a new gantry welding machine in the fabrication bay. Construction of the new machine appeared to be at about 40% completion. We did not witness any in-progress welding. ZPMC was performing grinding in between performing the root pass welds and fill pass welds. The root pass in the panel that we looked at had inconsistent profile. Peter explained that the root pass profile was thicker at the locations of the tack welds, and that was why ZPMC was grinding the tacks before performing the fill pass. I did not see any method of controlling the depth grinding in order to ensure a consistent profile of the root pass. We also saw some of the macroetches that have been taken from the practice welds. We notice some undercut and melt-through, but there did not seem to be any issues with achieving the necessary penetration.</p> <p>We also saw some panels on which ZPMC has performed practice welds on T-stiffeners for the bottom and side plates, and we saw a practice weld of a longitudinal splice of two deck panels.</p> <p>Tower Mock-up Fabrication</p> <p>We saw some in-progress fabrication of the 77-m mock-up. ZPMC was conducting fit-up of stiffeners to Skin Plates A and D. We saw what</p>

DAILY PROJECT JOURNAL

(*Continued Page 2 of 2*)

appeared to be a jig or fixture that could be used for assembly welding of the tower shafts.

New Tower Fabrication Facility

Construction progress of the new facility is estimated to be 100% for structural, 70% for electrical, 90% for the overhead cranes and 10% for machinery and equipment. Peter stated that the new offices located next to the new facility would be ready for occupation in one month.

Inspected By: Velasco, Abifhiram

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer
