

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-000274**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 11-Sep-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** /**HSR's:** /**NCR's:** /

Item	Title	Detail
1	Meetings attended	At 9:00 am, we conducted the weekly ZPMC conference call between Team China and Pier 7. We discussed tower mock-up construction, material check sampling and fine grain size verification, closed rib UT procedure and weld trials, and OBG bottom and side plate fabrication. Also discussed was ABF/ZPMC's request to be allowed to bend the flange plates for tower diaphragms on Changxing Island instead of at Wuxi Boiler. ABF/ZPMC have not yet shown that they have the capability to perform this at the Changxing Island facility, and they must do so before the State will consider this option. Jim Merrill raised the issue of performing RT on heavy plates (thicker than 45 mm) on Changxing Island. Currently ZPMC has no means of doing this. METS has encouraged ABF/ZPMC to research this issue before it becomes a critical item, but ABF/ZPMC has not yet done this.
2	Other important observations	<p>I conducted a walkthrough of the OBG deck and bottom plate fabrication bays at approximately 10:30 am. I observed ZPMC performing welds using the Gantry on an already welded closed rib panel. They appeared to be practicing the GMAW process while running all 6 heads (3 ribs) at the same time. They seemed to be having troubles keeping the welding heads continuously synchronized. For example, all welding heads did not begin welding at the same time, and some heads did not maintain a welding arc while the others continued welding along the length of the rib. No ABF personnel were present when I arrived. I also observed what appeared to be a recently welded closed rib panel that had poor weld profile due to under fill.</p> <p>I later walked through the OBG bottom and side plate shop floor. The bay is currently not ready for fabrication for this project. The welding Gantry is not completely assembled, and there is equipment and material from other jobs still in the bay. I estimate at least 2 weeks before this bay can be ready for OBG fabrication.</p>

DAILY PROJECT JOURNAL

(*Continued Page 2 of 2*)

- 3 Meetings attended
- At 1:30 pm, we had the daily technical issues meeting with ABF and ZPMC. We discussed and resolved the heat straightening tolerances issue. We discussed the issue of bending the tower diaphragm flange plates at Changxing Island. ABF stated that they would work with ZPMC on their proposal to do this and present it to the State at a later time. We also discussed the NDT requirements for finished welds that are later torch cut during fabrication.

Inspected By: Velasco, Abifhram

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer
