

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 #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000309**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 21-Sep-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** 1 / 4**HSR's:** 0 / 2**NCR's:** 0 / 4

Item	Title	Detail
1	Major component movement	<p>QA observed welding on the 77m Tower Mock-up: Continue repairs of Skin Plates A and E.</p> <p>QA observed welding on the 114m Tower Mock-up: Continue welding of Skin Plate Stiffeners.</p>
2	Meetings attended	<p>QA met with ABF and ZPMC at 1400 to discuss the schedule for the next two days:</p> <p>77m Tower Mock-up: Finish repair of Skin A and E Stiffeners, Diaphragms are waiting for flanges.</p> <p>89m Tower Mock-up: Send Diaphragms SA13 and P126 to machining.</p> <p>114m Tower Mock-up: Continue machining, fitting and welding of Skin Plate butt stiffeners, UT scheduled for Upper and Lower Skin Plate A and E Stiffeners,</p>
3	Key conversations	<p>Caltrans met with ABF and ZPMC at 1330 to discuss issues related to fabrication:</p> <p>ZPMC asked about results of check samples. QA informed ZPMC that this was delayed due to the typhoon and would forward the results as soon as they are received.</p> <p>ZPMC asked about an RFI submitted for FCAW welding of HPS material. The RFI has not been received by Caltrans yet.</p> <p>ZPMC asked about an overhead tack welding procedure. ABF is still reviewing the submittal.</p> <p>ABF and ZPMC asked about the variation in number of passes for non-standard joints related to AWS D1.5 table 5.3. QA responded the number of passes can be reduced proportionally to the area of the joint for thinner plate (non-standard joints are qualified on maximum thickness).</p> <p>QA spoke with ABF QCM Steve Lawton about the latest check sample list.</p>

DAILY PROJECT JOURNAL

(Continued Page 2 of 2)

The list has several heat numbers listed incorrectly and would result in both redundant and additional check samples being take. Mr. Lawton stated he would look into the matter and get back with QA.

4 Other important observations

QA Jim Cochran traveled to Wuxi Boiler to observe bending of the flange plates for the Tower Mock-up Diaphragms.

QA Dixon observed the completion of the first check sample tests at Shanghai Institute of Iron and Steel Technology. The samples appeared to comply with the applicable ASTM standards. QA will check results against the submitted MTRs on Monday.

At 1430 ABF brought QA a set of closed-rib PJP UT calibration blocks, but would not comment as to whether the notches in the blocks were accurate.

5 Quality Assurance Inspectors per shift

3 Day Shift (Brannon, Viars on Island, Dixon at testing Lab.)
1 Swing Shift (Franco)
1 Graveyard Shift (Hasler)

Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer
