

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-000346**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 11-Oct-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** 6 / 21**HSR's:** 3 / 6**NCR's:** 0 / 10

Item	Title	Detail
1	Critical Weld Repairs (CWRs)	<p>CWR-013 114m Skin Plate D Stiffener MA110-6 (1st time repair 15% length)</p> <p>CWR-014 114m Skin Plate D Stiffener MA110-9 (1st time repair 100% length)</p> <p>CWR-015 114m Skin Plate D Stiffener MA110-12 (1st time repair 12% length)</p> <p>CWR-016 114m Skin Plate C Stiffener MA112-13 (3rd time repair – initial UT and repair documentation missing)</p> <p>CWR-017 114m Skin Plate A Stiffener MA107-3 (3rd time repair >10% – initial UT and repair documentation missing)</p> <p>CWR-018 114m Skin Plate C Stiffener MA112-10 (1st time repair 100% length)</p>
2	Heat Straightening Requests (HSRs)	<p>HSR-004 114m Skin Plate C MA111 Stiffener Plates Weld Joint 5, 6, 7, 8, 9 and 10</p> <p>HSR-005 77m Skin Plate E MA1 Stiffener Plate Weld Joint 3</p> <p>HSR-006 114m Internal Splice Plate MUC-A119 Weld Joints 1 and 2</p>
3	Major component movement	<p>77m Tower Mock-up: No welding observed.</p> <p>89m Tower Mock-up: Welding Skin Plate butt joints.</p> <p>114m Tower Mock-up: Bending diaphragm flange plates.</p>
4	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: Skin A awaiting CWR for 3rd time repair, MT Connection Plates on Skin Plate D, Heat Straighten Skin Plate E,</p>

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Begin Welding Diaphragm flange plate butt joints pending 2 additional flange plate from Wuxi Boiler.

89m Tower Mock-up:

Weld Skin Plate Butt Joints,

Beveling Skin Plates.

114m Tower Mock-up:

Work pending resolution of stiffener to skin plate repair rate.

5 Key conversations

Caltrans met with ABF and ZPMC at 1300 to discuss issues related to fabrication:

Bent Diaphragm Flange Plates from Wuxi undergoing verification of bends and templates.

Material issues were identified by ABF on Batch 20 related to the supplemental grain size. ABF added that there should have been 74 pages of supplemental grain size in the revised RFI and another 8 pages have also been added. ZPMC is still trying to determine how many more heats have been ordered that will require the supplemental grain size from the mill.

Caltrans to discuss internally to determine if RFI is needed.

ZPMC asked ABF about the status of the 1st batch of rolled shapes for submittal to Caltrans. ABF responded that this was rejected by ABF and returned to ZPMC for correction.

ABF brought up an issue with the MTR's for the rolled shapes (channel and angle) being substituted on the Tower Mock-up in accordance with RFI 556R0. ABF informed Caltrans that the material does not meet the mechanical requirements of standard Q235 as listed in the RFI. Caltrans will discuss internally to determine if this material can be accepted for purpose.

Caltrans inquired about the status of the UT calibration block for the Closed-rib UT. ABF informed us that they currently have 4 samples at approximately 90, 80, 70 and 60% penetration that they are currently using for procedure development. Additional blocks are being prepared for Caltrans. All of the calibration blocks are being manufactured using a wire type band saw rather than Electrical Discharge Machining (EDM). ABF stated that ZPMC has decided not to use EDM at this time.

ZPMC presented a preliminary Closed-rib Weld Trial Schedule as follows:

Verify Closed-rib joint geometry tomorrow,

Tack Weld Closed-ribs to deck section on Monday,

Weld Closed-ribs PJP to deck section on Tuesday.

ABF informed Caltrans that they would like to schedule a meeting to discuss the beginning of fabrication on the OBG Bottom and Side Panels tomorrow (ABF later stated they would like this meeting on Monday, October 15, 2007).

6 Quality Assurance Inspectors per shift 3 Day Shift (Acuna, Brannon, Viars)
3 Swing Shift (Berger, Dixon, Smith)
2 Graveyard Shift (Hasler, Hernandez)

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Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer